



Gas Tungsten Arc Welding (Steel and Stainless Steel-Vertical)

Project 6 – Specification and Print

Weld Type	Fillet
Welding Process	GTAW
Position	Vertical
Material	1/8" Stainless Steel
Joint Type	Tee
Backing Option	
Backing Material	

Polarity	DC+
Electrode	308
Transfer Mode	
Tungsten Electrode	2% Ceriated
Shielding Gas	100% Argon
Flow Rate	25 cfh
Cup Size	

Welding Procedure									
Weld Layers	Pass No.	Process	Filler Metal Classification	Filler Metal Diameter in (mm)	Current Amps	Current Type and Polarity	Wire Feed Speed	Volts	Remarks
Stringer	Tee	GTAW	308	1/16"	75a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: Butt Joint single pass weld in vertical up

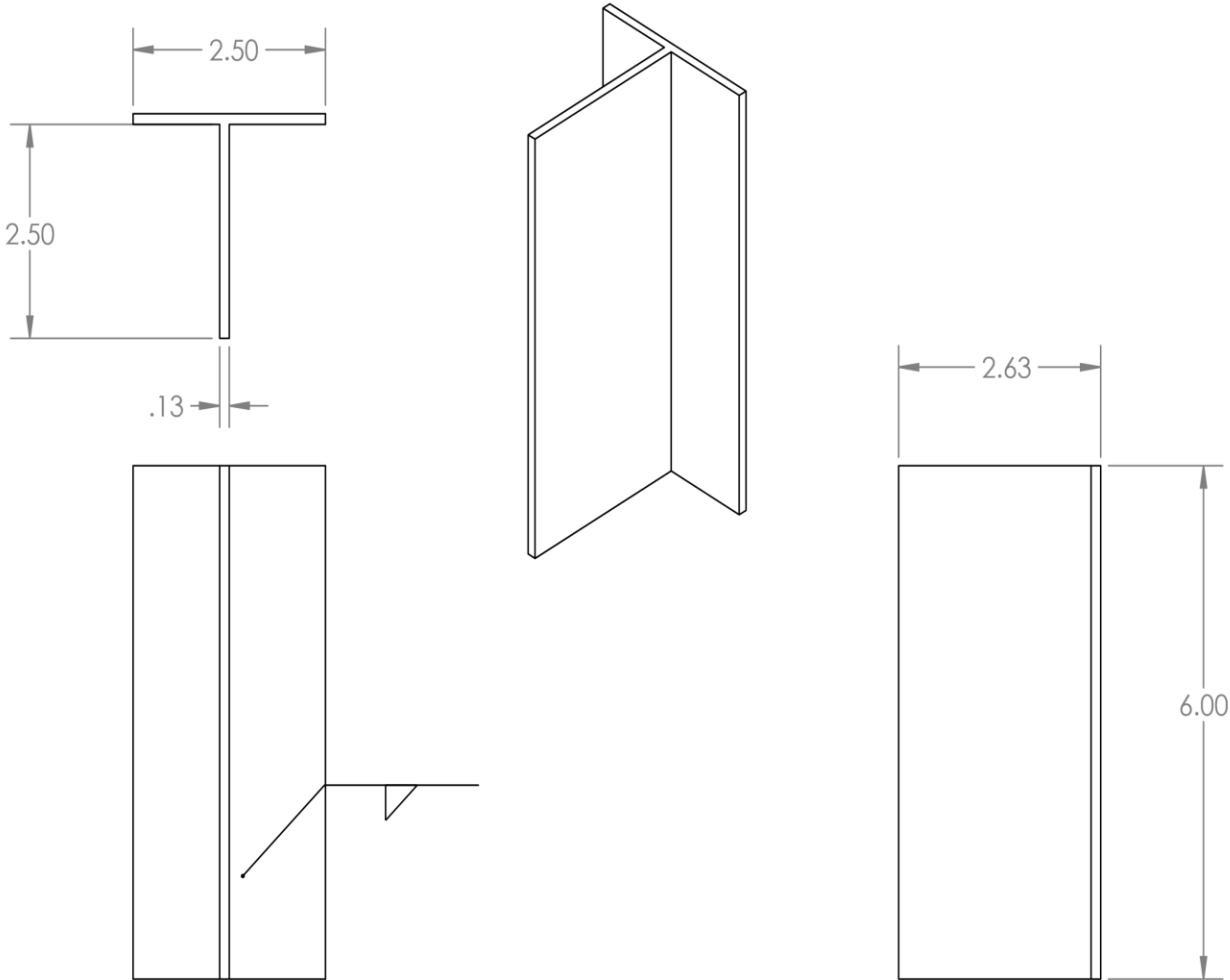
Additional Notes: Show instructor progress every 30 minutes, minimum.





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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	TITLE: CIMWD-122 Project 6
		DIMENSIONS ARE IN INCHES	DRAWN		
		TOLERANCES:	CHECKED		
		FRACTIONAL ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±	Q.A.		SIZE DWG. NO. REV
		THREE PLACE DECIMAL ±	COMMENTS:		Part 8 1 8TH vert
		INTERPRET GEOMETRIC TOLERANCING PER:			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		MATERIAL			
		FINISH			
PROPRIETARY AND CONFIDENTIAL	USED ON	DO NOT SCALE DRAWING			
APPLICATION					

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