



Gas Metal Arc Welding (Flat and Horizontal)

Project 2 – Specification and Print

Weld Type	2 Fillet and 1 PJP Groove
Welding Process	GMAW
Position	Horizontal
Material	1/16" Steel
Joint Type	Tee, Lap, and Butt
Backing Option	
Backing Material	

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	Short Circuit Transfer
Tungsten Electrode	
Shielding Gas	75% Argon/25% CO2
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
Weave	Tee	GMAW	ER-70s-6	.035"		DC+	40	5	
Stringer	Lap	"	ER-70s-6	.035"		"	40	4.5	
Stringer	Butt	"	ER-70s-6	.035"		"	40	4.5	





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Tee Joint use weave bead

Lap Joint use stringer bead

Butt Joint use stringer bead

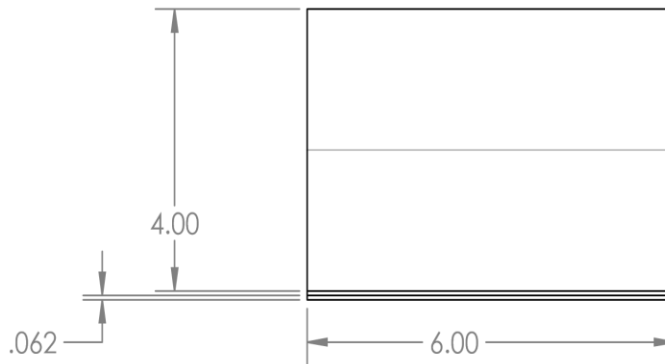
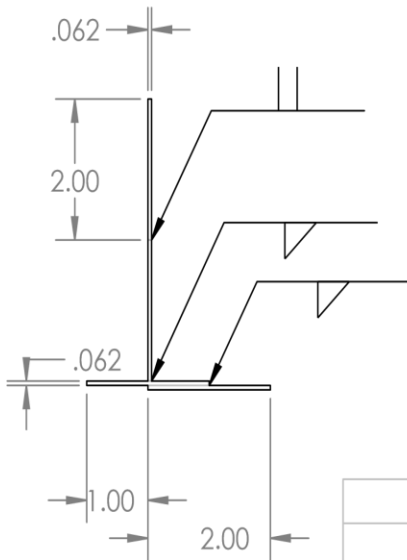
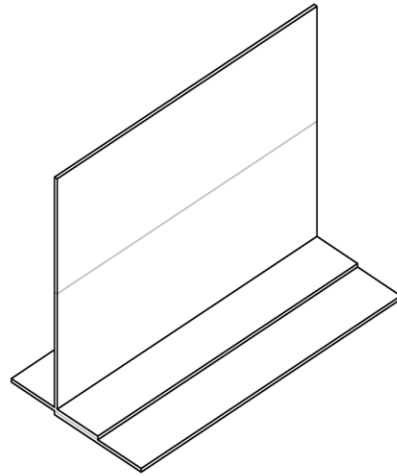
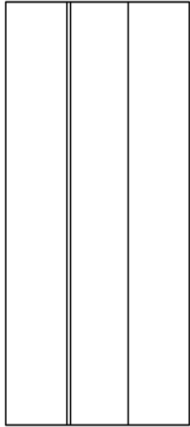
Additional Notes: Show instructor progress every 30 minutes minimum.





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NOTES:
CUT ON SHEAR
TACK USING GMAW
WELD UTILIZING
PROCESS IN MODULE

UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT 5/5/15
TOLERANCES:		CHECKED	
FRACTIONAL: ±		ENG APPR.	
ANGULAR: MACH ± BEND ±		MFG APPR.	
TWO PLACE DECIMAL ±		Q.A.	
THREE PLACE DECIMAL ±		COMMENTS:	
INTERPRET GEOMETRIC TOLERANCING PER:			
MATERIAL			
FINISH			
APPLICATION			
DO NOT SCALE DRAWING			

TITLE:		
CIMWD-130 Project 2		
SIZE	DWG. NO.	REV
A	PART 16 D	
SCALE: 1:4	WEIGHT:	SHEET 1 OF 1

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