



Gas Metal Arc Welding (Vertical and Overhead Welding)

Project 1 – Specification and Print

| | |
|-------------------------|-------------|
| Weld Type | Fillet Weld |
| Welding Process | GMAW |
| Position | Vertical |
| Material | 1/4" Steel |
| Joint Type | Tee |
| 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+ | 50 | 7.0 | |
| | | | | | | | | | |
| | | | | | | | | | |





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Tee Joint use weave bead vertical up

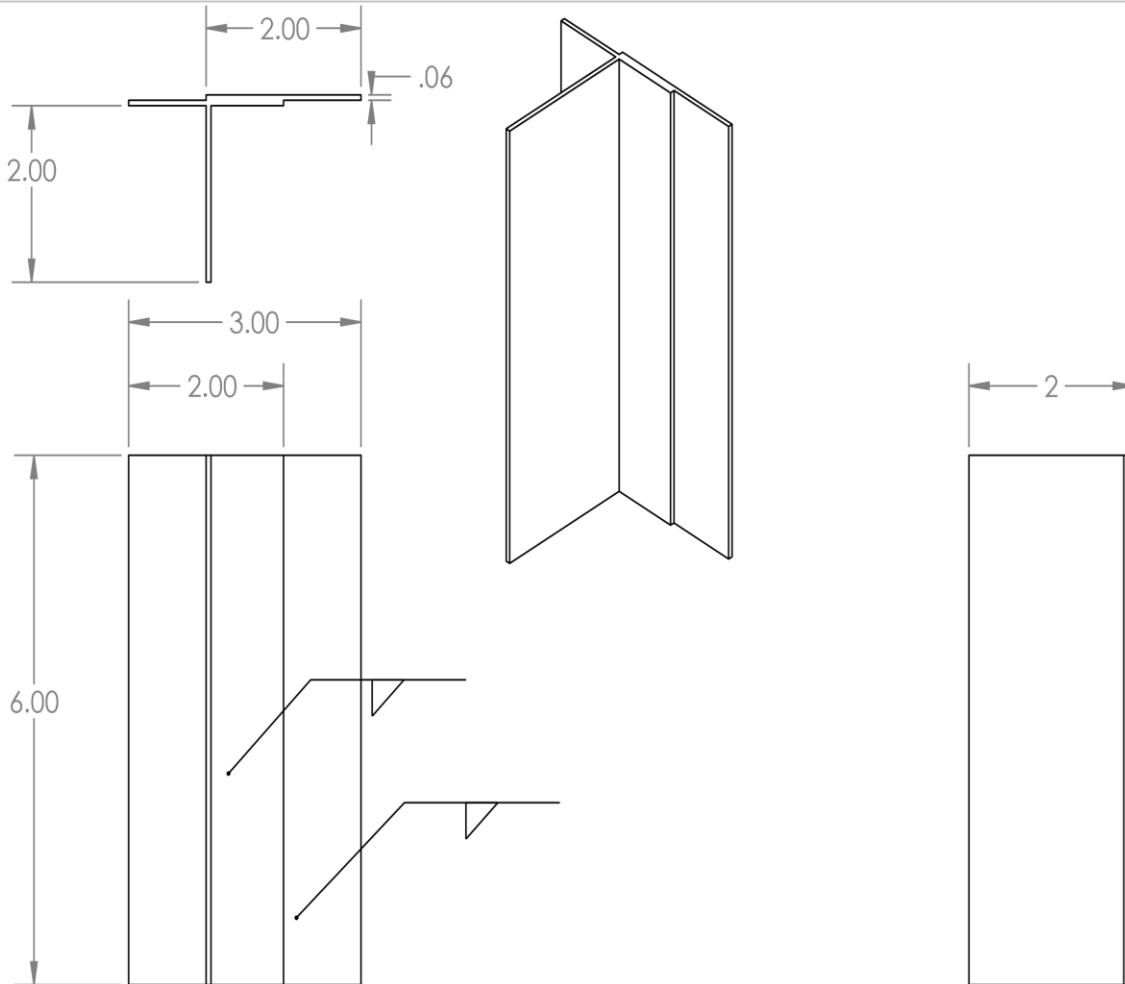
Additional Notes: Show instructor progress every 30 minutes minimum.





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1/8" Steel

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| | | | | | | |
|-------------|---|--------------------------------------|-----------|------|---------------------------------|--|
| | | UNLESS OTHERWISE SPECIFIED: | NAME | DATE | | |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | TITLE: | |
| | | TOLERANCES: | CHECKED | | CIMWD-131 Project 1 | |
| | | FRACTIONAL ± | ENG APPR. | | | |
| | | ANGULAR: MACH ± BEND ± | MFG APPR. | | | |
| | | TWO PLACE DECIMAL ± | Q.A. | | SIZE DWG. NO. REV | |
| | | THREE PLACE DECIMAL ± | COMMENTS: | | CIMWD 131 pr 1 | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | SCALE: 1:2 WEIGHT: SHEET 1 OF 1 | |
| | | MATERIAL | | | | |
| | | FINISH | | | | |
| 5 | 4 | 3 | 2 | 1 | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | | |





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