



Tool and Die Welding (GTAW)

Project 2 – Specification and Print

Weld Type	Line Build-Up
Welding Process	GTAW
Position	Flat
Material	1/4" Steel
Joint Type	
Backing Option	
Backing Material	

Polarity	DC+
Electrode	ER70s-6
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
Line		GTAW	ER70s-6	1/16"	130a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: A Line build up using stringer beads. Looking for bead quality and bead placement.
2 1/2"x1" high

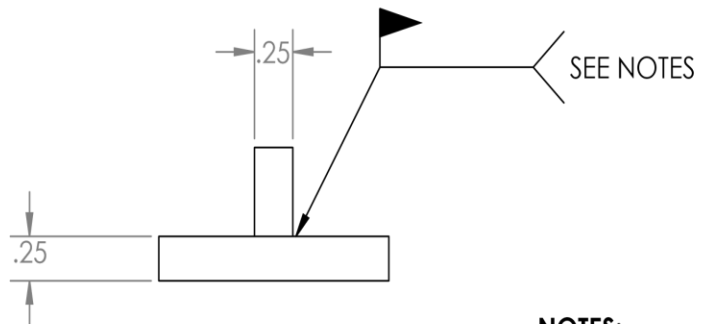
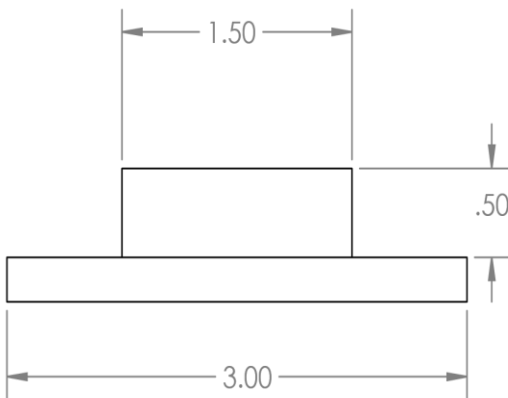
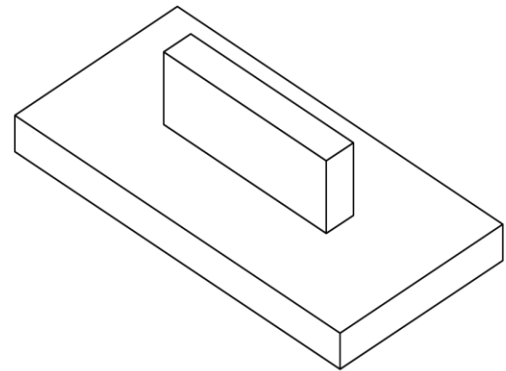
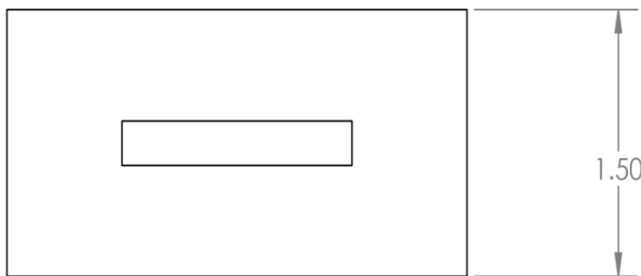
Additional Notes: Show instructor progress every 30 minutes minimum.





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NOTES:
LINE BUILD UP GTAW

UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT	5/5/15	TITLE: CIMWD-221 Project 2
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					
DO NOT SCALE DRAWING					
USED ON	APPLICATION				

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SIZE DWG. NO. REV
A PART 14 D

SCALE: 1:1 WEIGHT: SHEET 1 OF 1

5

4

3

2

1





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