



PROCESS:	GTAW
ELECTRODE CLASSIFICATION:	ER70S-2
ELECTRODE SIZE:	must be smaller than base metal
POSITION:	2F
WELD SIZE/ # OF BEADS:	Equal to base metal thickness
AMPERAGE/WFS:	1amp for every .001" base metal thickness
VOLTAGE:	N/A

ROOT FACE:	N/A
ROOT OPENING:	N/A

TITLE: Lap Joint		
SIZE A	DWG. NO.	REV
SCALE: 1:2	SHEET 1 OF 1	

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 FRACTIONAL ±
 ANGULAR: MACH ± BEND ±
 TWO PLACE DECIMAL ±
 THREE PLACE DECIMAL ±

