



PROCESS:	SMAW
ELECTRODE CLASSIFICATION:	ER7018
ELECTRODE SIZE:	3/32"
POSITION:	1G
WELD SIZE/ # OF BEADS:	1.5-2x ROD DIA.
AMPERAGE/WFS:	90-100
VOLTAGE:	NA

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

TITLE: Surface Weld		
SIZE A	DWG. NO.	REV
SCALE: 1:2	SHEET 1 OF 1	

