Shielded Metal Arc Welding – Flat and Horizontal

Project 1 – Specification and Print

Weld Type	4 Fillet Welds
Welding Process	SMAW
Position	Flat
Material	¼" Steel
Joint Type	Tee Flat
Backing Option	
Backing Material	

Polarity	DC+
Electrode	E6013 1/8, E7024 1/8, E6010 1/8, E7018 1/8
Transfer Mode	
Tungsten Electrode	
Shielding Gas	
Flow Rate	
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**
Multi Pass to top		SMAW	E6013	1/8	90a	DC+			
			E7024	1/8	140a				
			E6010	1/8	80a				

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			E7018	1/8	120a				

Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench after 2-3 passes

Stress Relieving:

Technique: 4 Multi-pass fillet welds in flat positions using 4 different electrodes. Each side is to be filled to the top using multi-pass stringer technique.

Number of Electrodes: whatever it takes

Additional Notes: Show instructor progress every 30 minutes, minimum.

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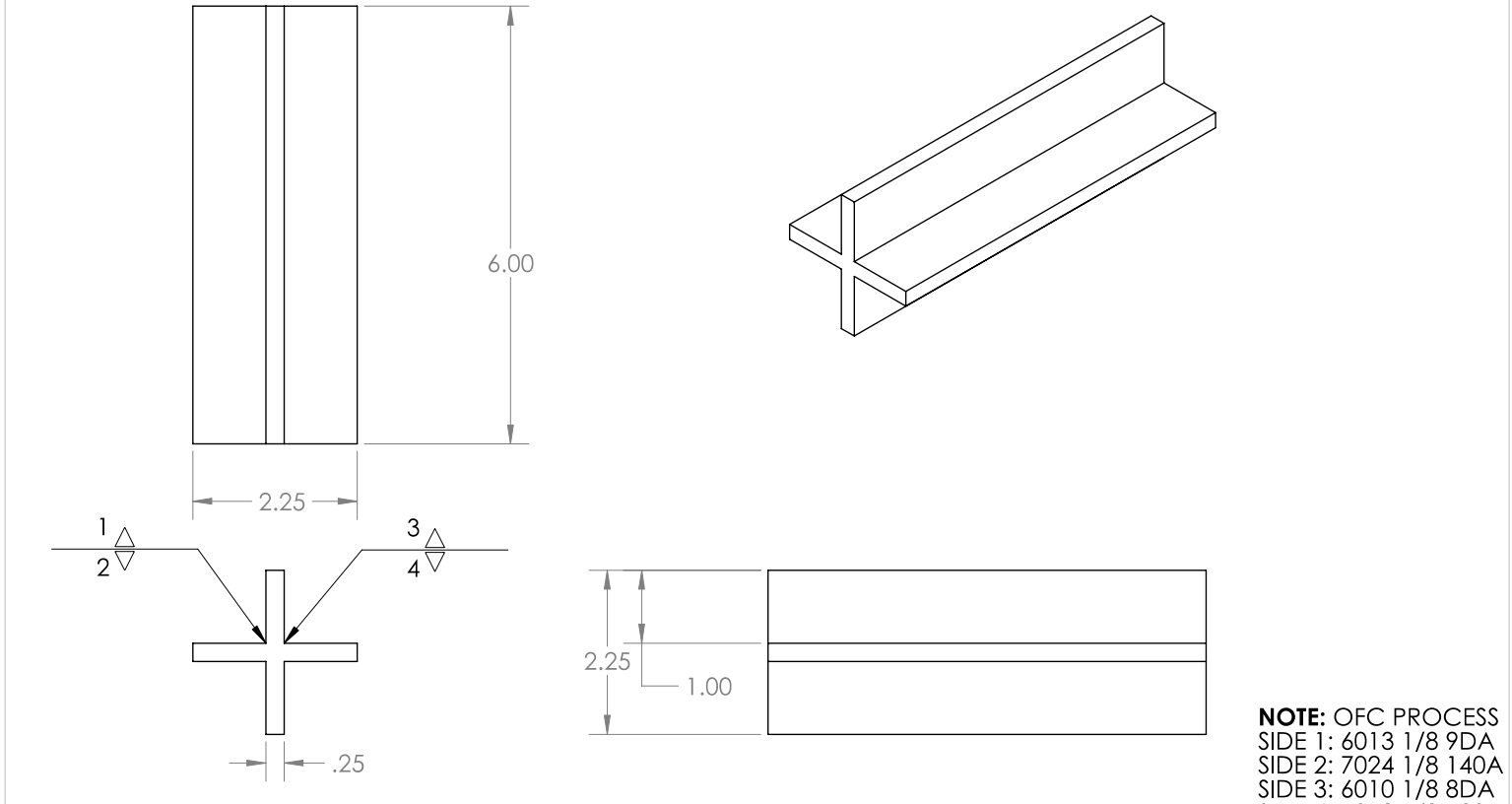

NOTE: OFC PROCESS
SIDE 1: 6013 1/8 9DA
SIDE 2: 7024 1/8 140A
SIDE 3: 6010 1/8 8DA
SIDE 4: 7018 1/8 120A

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN	J.SIBERT	2/12/2015	TITLE: CIMWD-110 Project 1
			CHECKED			
			ENG APPR.			
			MFG APPR.			
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			
		MATERIAL	COMMENTS:			SIZE A / DWG. NO. PART 3 / REV 0
	USED ON	FINISH				
	APPLICATION	DO NOT SCALE DRAWING				SCALE: 1:2 / WEIGHT: / SHEET 1 OF 1

5 4 3 2 1

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