



Shielded Metal Arc Welding – Flat and Horizontal

Project 2 – Specification and Print

Weld Type	Plug Weld
Welding Process	SMAW
Position	Flat
Material	¼" Steel
Joint Type	
Backing Option	
Backing Material	

Polarity	DC+
Electrode	E7018 3/32
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
Till Filled		SMAW	E7018	3/32	75a	DC+			





**Multi-State
Advanced Manufacturing
Consortium**

US DOL SPONSORED TAACCCT GRANT: TC23767

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RELEASE DATE

09/09/2015

VERSION

v 001

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Technique: Stringer or Weave Bead- Stringer till filled

Initial/Interpass Cleaning: Chip and Brush

Number of Electrodes: 1 – 2

Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

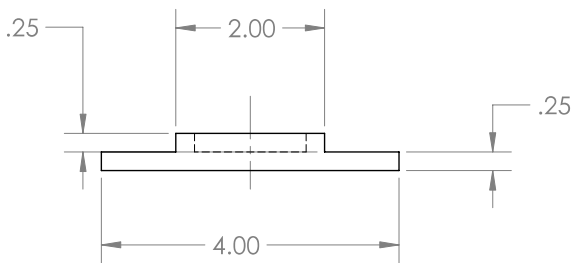
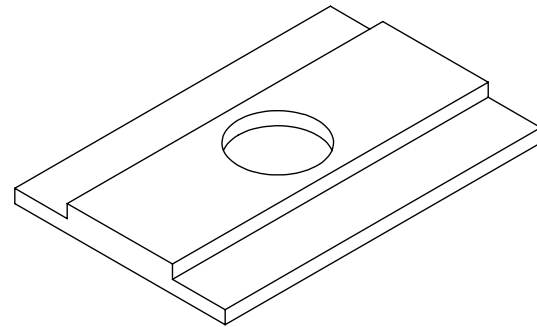
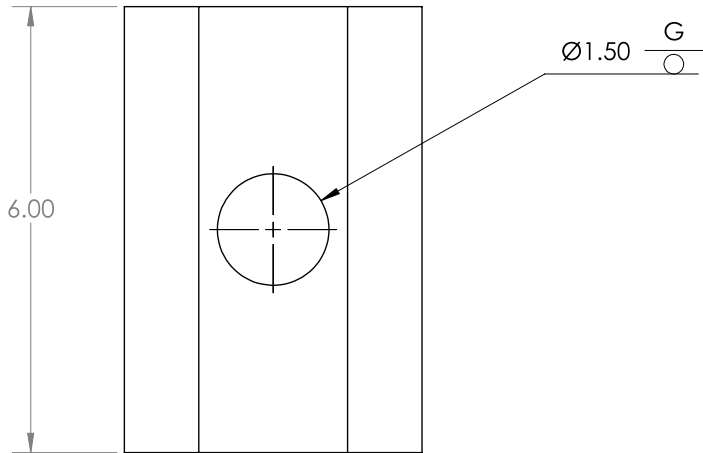
Interpass Temperature: Quench after 2-3 passes

Stress Relieving:





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NOTE: (OFC) PROCESS
TACK WITH GMAW
PLUG WELD SHAW 7018 3/32
CUT IN HALF WITH H. BANSHAW

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT 2/12/2015
TOLERANCES:		CHECKED	
FRACTIONAL: ±		ENG APPR.	
ANGULAR: MACH ±		MFG APPR.	
BEND ±		Q.A.	
TWO PLACE DECIMAL ±		COMMENTS:	
THREE PLACE DECIMAL ±			
INTERPRET GEOMETRIC TOLERANCING PER:			
MATERIAL			
FINISH			
APPLICATION			
DO NOT SCALE DRAWING			

TITLE:		
CIMWD-110 Project 2		
SIZE	DWG. NO.	REV
A	PART 1	0
SCALE: 1:2	WEIGHT:	SHEET 1 OF 1

5

4

3

2

1





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