



## Shielded Metal Arc Welding – Flat and Horizontal

### Project 4 – Specification and Print

<b>Weld Type</b>	CJP Groove
<b>Welding Process</b>	SMAW
<b>Position</b>	Horizontal
<b>Material</b>	¼" Steel
<b>Joint Type</b>	Vee Butt
<b>Backing Option</b>	No Backer
<b>Backing Material</b>	

<b>Polarity</b>	DC+
<b>Electrode</b>	E6010 3/32, E7018 3/32
<b>Transfer Mode</b>	
<b>Tungsten Electrode</b>	
<b>Shielding Gas</b>	
<b>Flow Rate</b>	
<b>Cup Size</b>	

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
Stringer	Root	SMAW	E6010	3/32	50a	DC+			
	Fill	"	E7018	3/32	75a	"			
	Cover	"	E7018	3/32	75a	"			





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**Number of Electrodes:** 1 – 2

**Technique:** Root Pass performed with E6010 3/32 for CJP. Fill and Cover Passes performed with E7018 3/32.

**Initial/Interpass Cleaning:** Chip and Brush

**Heat Treatment:**

**Preheat Temperature:**

**Post Heat Temperature:**

**Interpass Temperature:** Quench between passes

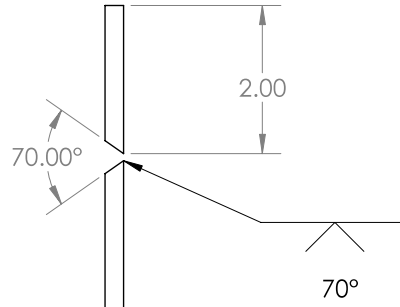
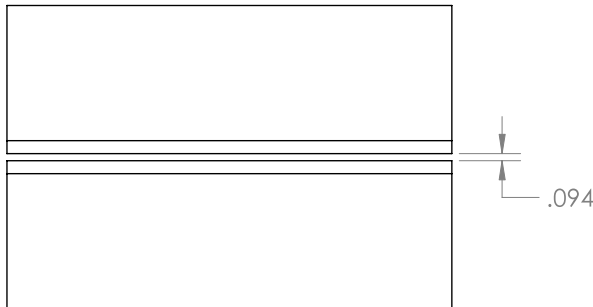
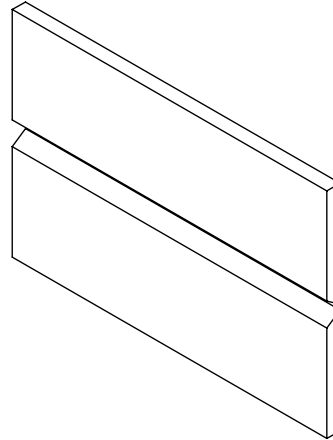
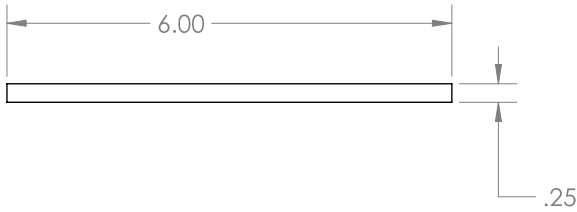
**Stress Relieving:**

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





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NOTE:  
LINE CUT BEVEL  
37 1/2 DEGREE  
ROOT PASS 6010 3/32  
FILL & COVER  
7018 3/32  
\*GTAW ROOT, FILL  
& COVER 3/32 FILLER

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: <b>CIMWD-110 Project 4</b>	
DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT		4/2/15
TOLERANCES:		CHECKED			
FRACTIONAL: ±		ENG APPR.			
ANGULAR: MACH ± BEND ±		MFG APPR.			
TWO PLACE DECIMAL ±		Q.A.			
THREE PLACE DECIMAL ±		COMMENTS:			
INTERPRET GEOMETRIC TOLERANCING PER:				SIZE DWG. NO. REV	
MATERIAL				<b>A PART 10.2 0</b>	
FINISH				SCALE: 1:2 WEIGHT: SHEET 1 OF 1	
APPLICATION		DO NOT SCALE DRAWING			

5

4

3

2

1





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