Shielded Metal Arc Welding (Vertical Welding)

Project 4 – Specification and Print

Weld Type	Vee Groove Weld
Welding Process	SMAW
Position	Vertical
Material	1/4" Steel
Joint Type	Butt
Backing Option	CJP
Backing Material	

Polarity	DC+
Electrode	E6010 3/32 and 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**
Stringer	Root	SMAW	E6010	3/32	50	DC+			
	Fill	SMAW	E7018	3/32	70	"			
	Cover	SMAW	E7018	3/32	70	"			

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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Root Pass using E6010 for CJP. Grind root on face side smooth. Fill and cover using E7018 with a stringer or weave in vertical up position.

Number of Electrodes:

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

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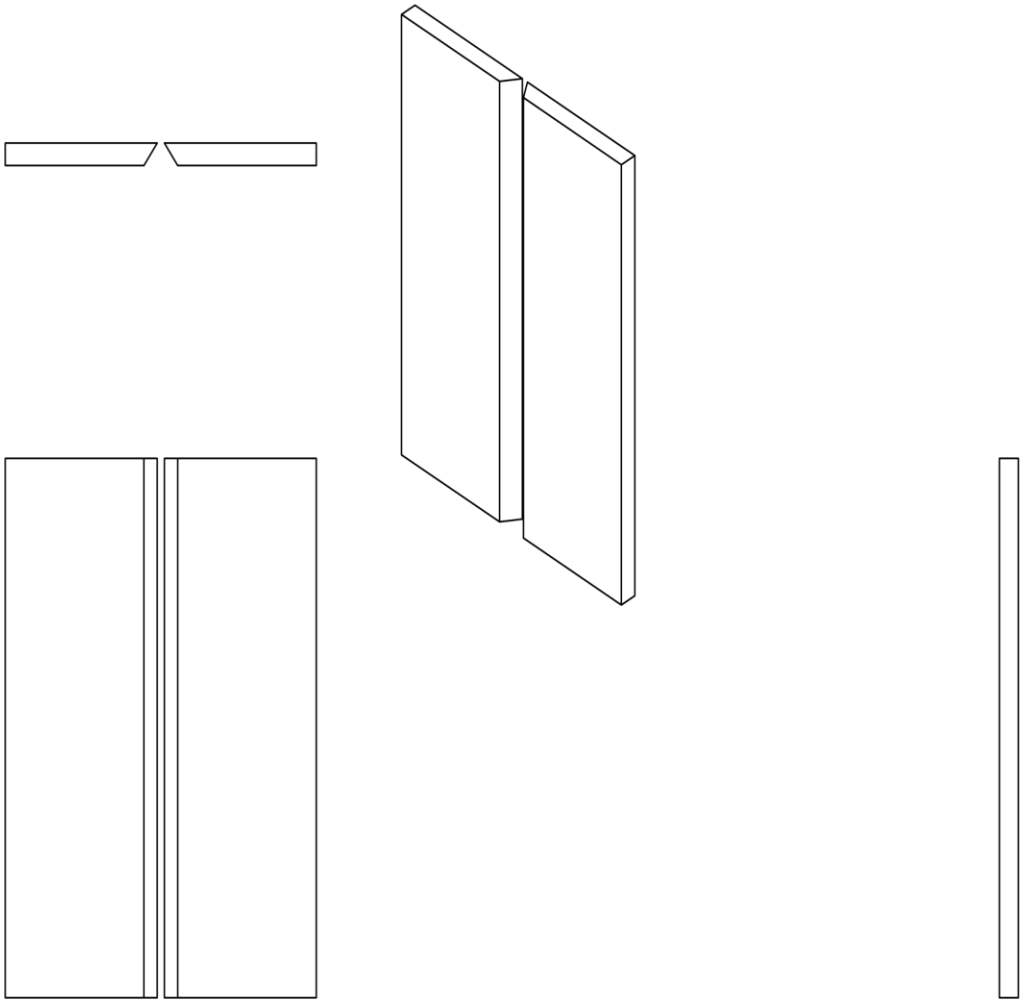

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN		
			CHECKED		
			ENG APPR.		
			MFG APPR.		
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
		MATERIAL	COMMENTS:		
NEXT ASSY	USED ON	FINISH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

TITLE: CIMWD-111 Project 4

SIZE A | DWG. NO. Part 10 | REV

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1

5 4 3 2 1

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