Shielded Metal Arc Welding – Overhead Welding

Project 1 – Specification and Print

Weld Type	4 Fillet Welds
Welding Process	SMAW
Position	Overhead
Material	1/4 " Steel
Joint Type	Tee
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**
Slight Weave		SMAW	E7018	3/32	80	DC+			

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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Tee Fillet weld in overhead position using a slight weave technique.

Number of Electrodes:

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

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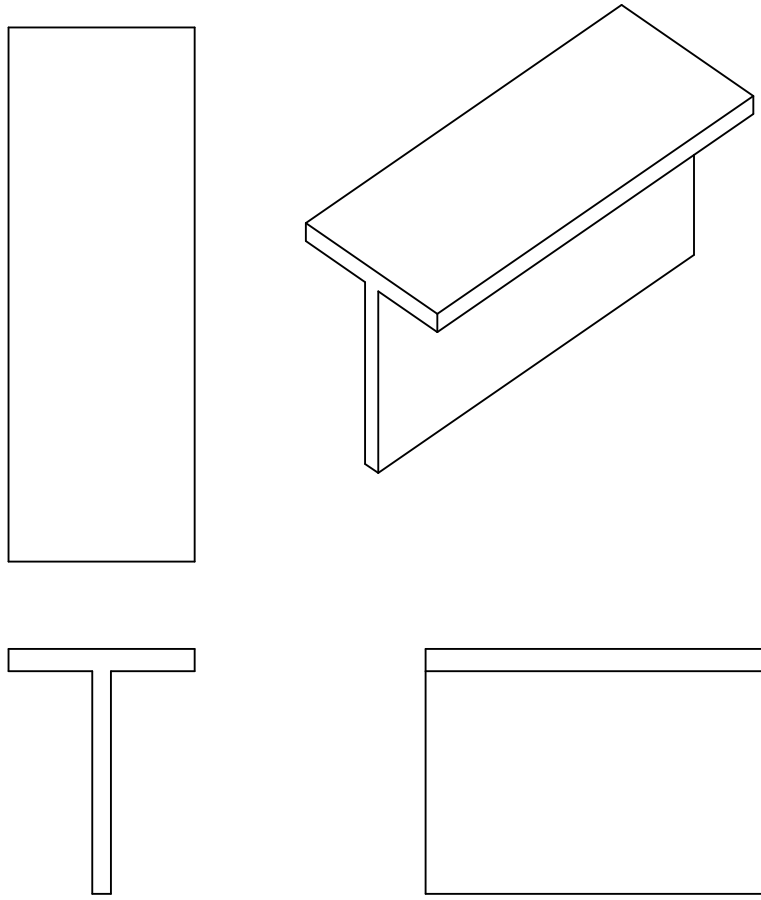

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES	DRAWN				
		TOLERANCES: FRACTIONAL ± ANGULAR: MACH BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	CHECKED			TITLE: CIMWD-112 Project 1	
			ENG APPR.				
			MFG APPR.				
		INTERPRET TOLERANCING	Q.A.				
		MATERIA	COMMENTS:			SIZE A	DWG. NO. Part 8 REV
		FINIS					
NEXT ASSY	USED ON					SCALE: 1:2	WEIGHT: SHEET 1 OF 1
		APPLICATION	DO NOT SCALE DRAWING				

5 4 3 2 1

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