



Shielded Metal Arc Welding – Overhead Welding

Project 2 – Specification and Print

Weld Type	Fillet
Welding Process	SMAW
Position	Overhead
Material	1/4" Steel
Joint Type	Lap
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+			





**Multi-State
Advanced Manufacturing
Consortium**

US DOL SPONSORED TAACCCT GRANT: TC23767

PRIMARY DEVELOPER: Kevin Ridge, Welding Instructor, Henry Ford College

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VERSION v 001

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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.

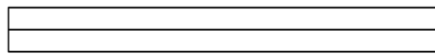
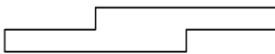
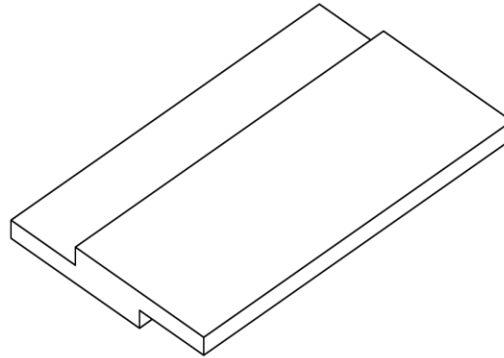
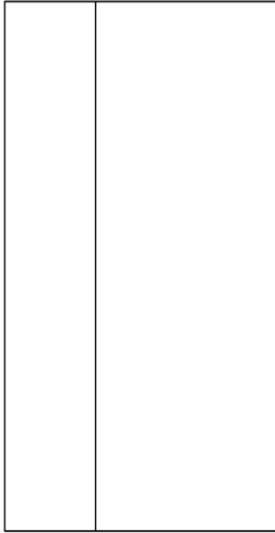
Number of Electrodes:

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





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN			TITLE: CIMWD-112 Project 2
		TOLERANCES:	CHECKED			
		FRACTIONAL ±	ENG APPR.			
		ANGULAR: MACH ± BEND ±	MFG APPR.			
		TWO PLACE DECIMAL ±	Q.A.			
		THREE PLACE DECIMAL ±	COMMENTS:			SIZE DWG. NO. REV
		INTERPRET GEOMETRIC TOLERANCING PER:				A Part 7
		MATERIAL				SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		FINISH				
		DO NOT SCALE DRAWING				
	APPLICATION					

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