



Shielded Metal Arc Welding – Overhead Welding

Project 3 – Specification and Print

Weld Type	Vee Groove Weld
Welding Process	SMAW
Position	Overhead
Material	1/4" Steel
Joint Type	Butt
Backing Option	PJP
Backing Material	1/8" Steel

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
Stringer		SMAW	E7018	3/32	75a	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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10/05/2015

VERSION

v 001

PAGE

2 of 4

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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Butt Joint filled with stringer beads till just over flush in Overhead position

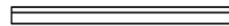
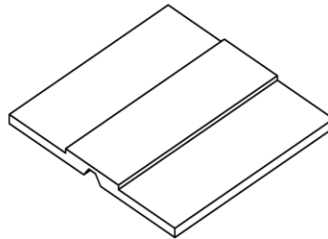
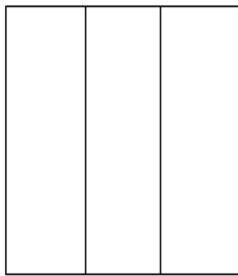
Number of Electrodes:

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





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN			TITLE: CIMWD-112 Project 3
		TOLERANCES:	CHECKED			
		FRACTIONAL ±	ENG APPR.			
		ANGULAR: MACH ± BEND ±	MFG APPR.			
		TWO PLACE DECIMAL ±	Q.A.			SIZE DWG. NO. REV
		THREE PLACE DECIMAL ±	COMMENTS:			A Part 2
		INTERPRET GEOMETRIC TOLERANCING PER:				SCALE: 1:4 WEIGHT: SHEET 1 OF 1
		MATERIAL				
		FINISH				
		APPLICATION				
		DO NOT SCALE DRAWING				

5

4

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2

1





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