



Gas Tungsten Arc Welding (Safety and Technology)

Project 1 – Specification

Weld Type	
Welding Process	GTAW
Position	Flat
Material	1/8" Steel
Joint Type	
Backing Option	
Backing Material	

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	
Tungsten Electrode	2% Ceriated
Shielding Gas	100% Argon
Flow Rate	25 cfh
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
Pad		GTAW	ER70s-6	1/16"	130a	DC+	Pad		





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Practice a pad build up using stringer beads. Practice bead quality and bead placement.

Number of Electrodes:

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





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