



Gas Tungsten Arc Welding (Steel and Stainless Steel-Flat and Horizontal)

Project 2 – Specification and Print

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

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	
Tungsten Electrode	2% Seriated
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
Stringer	Lap	GTAW	ER-70s-6	1/16"	120a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature

Stress Relieving:

Technique: Lap Joint single pass weld

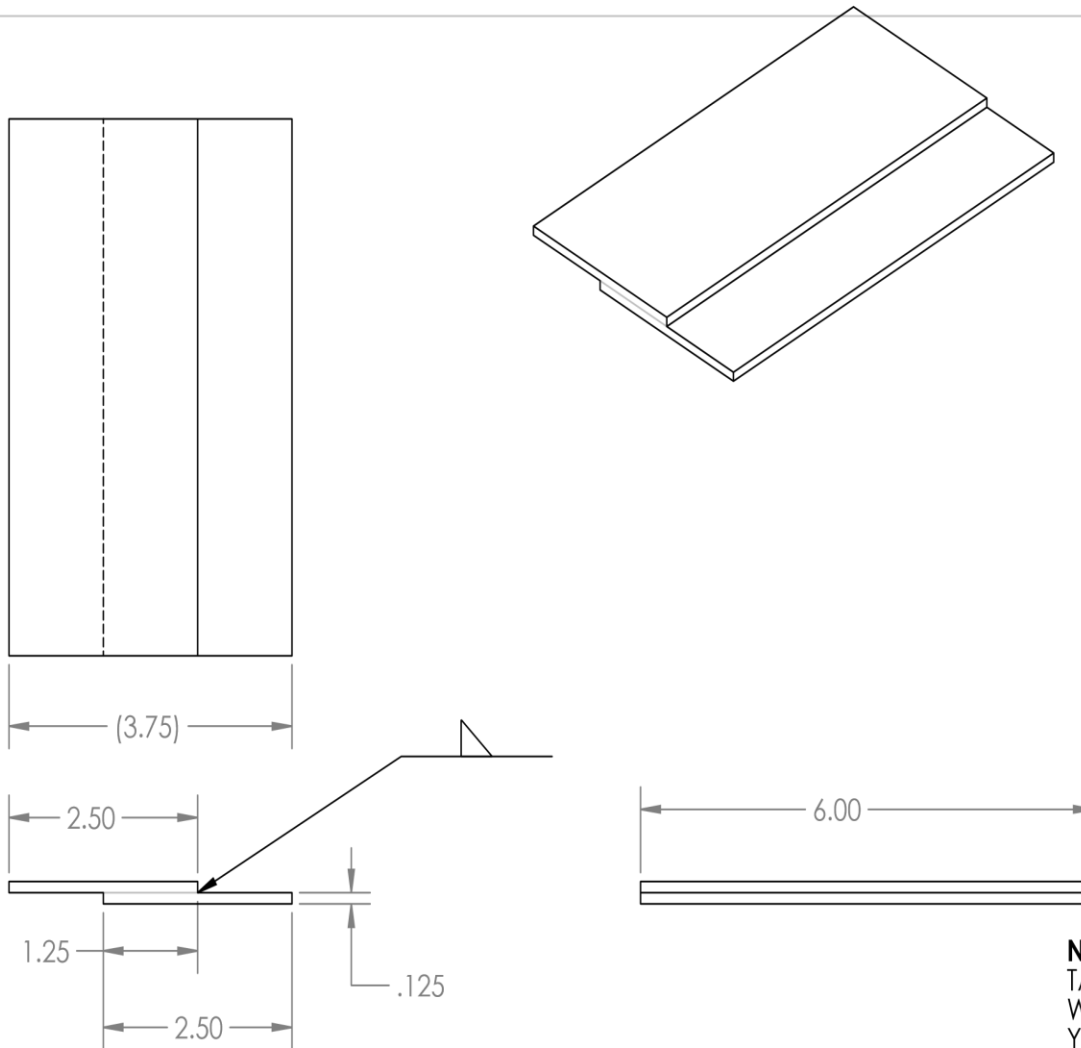
Additional Notes: Show instructor progress every 30 minutes, minimum.





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NOTE: SHEAR CUT
TACK WITH GMAW
WELDED IN MODULE
YOU ARE PARTICIPATING IN NEXT

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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN		TITLE: CIMWD-121 Project 2
		TOLERANCES:	CHECKED		
		FRACTIONAL ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±	Q.A.		
		THREE PLACE DECIMAL ±	COMMENTS:		
		INTERPRET GEOMETRIC TOLERANCING PER:			SIZE DWG. NO. REV
		MATERIAL			A PART 7
		FINISH			SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		DO NOT SCALE DRAWING			

5

4

3

2

1





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