

US DOL SPONSORED TAACCCT GRANT: TC23767

RELEASE DATE 10/06/2015

VERSION PAGE v 001

1 of 4

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

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

Project 3 – 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% 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 | | |
| Stringer | Tee | GTAW | ER-70s-6 | 1/16" | 120a | DC+ | | | | | |





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PAGE

2 of 4

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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: Tee Joint single pass weld

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



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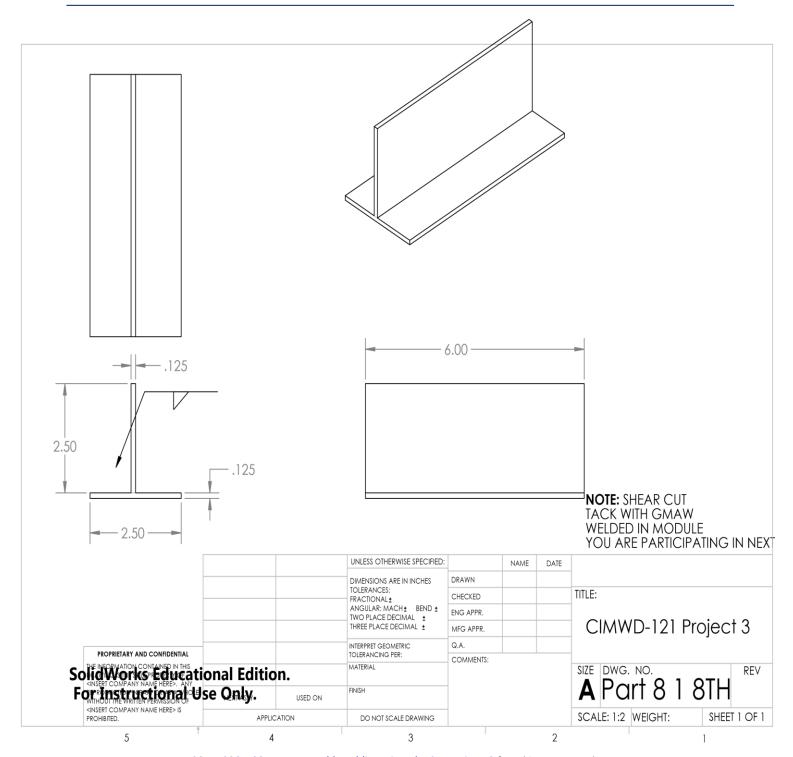
v 001

PAGE 3 of 4

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PAGE 4 of 4

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