



Gas Tungsten Arc Welding (Steel and Stainless Steel-Vertical)

Project 4 – Specification and Print

Weld Type	Square Groove
Welding Process	GTAW
Position	Vertical
Material	1/8" Stainless Steel
Joint Type	Butt
Backing Option	
Backing Material	

Polarity	DC+
Electrode	308
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	Butt	GTAW	308	1/16"	75a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: Butt Joint single pass weld in vertical up

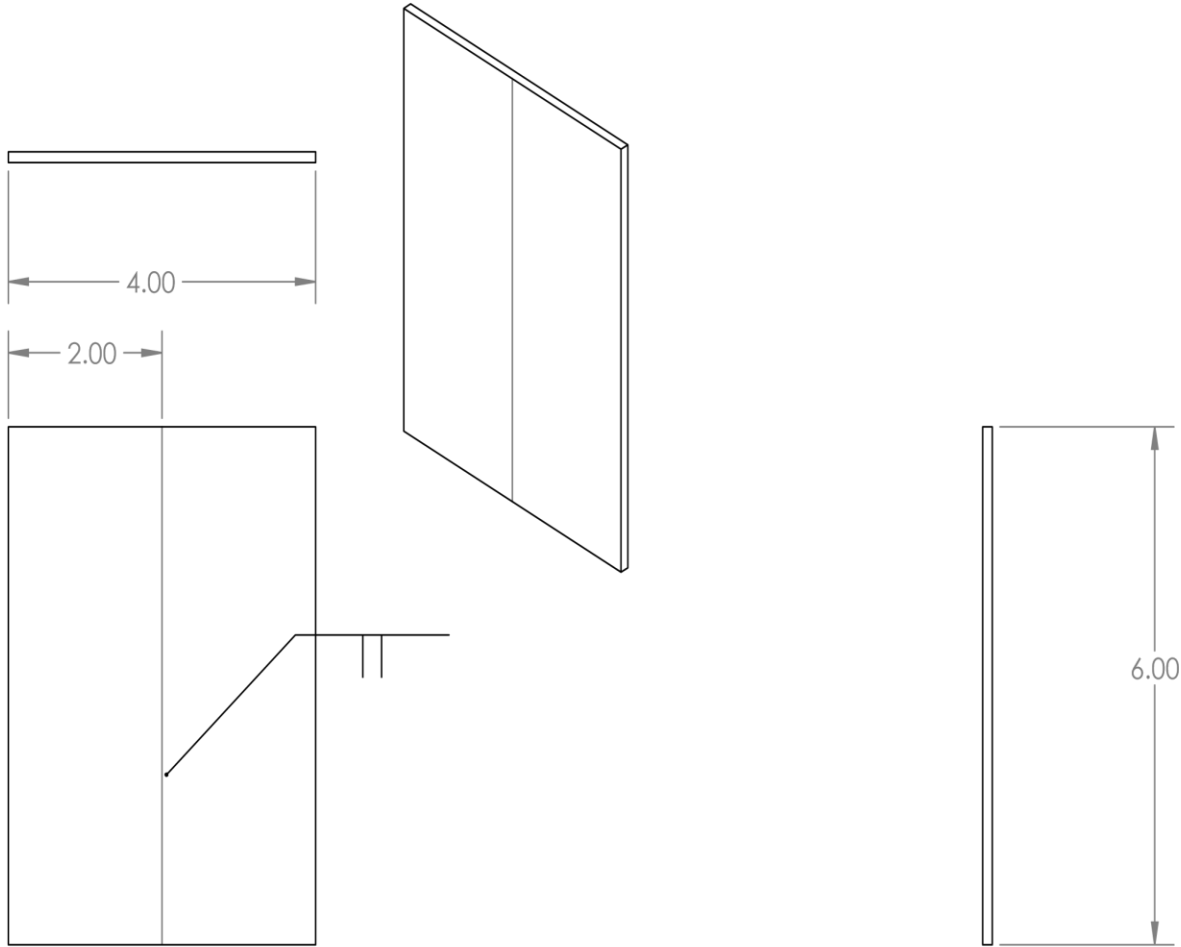
Additional Notes: Show instructor progress every 30 minutes, minimum.





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES		DRAWN		TITLE:	
		TOLERANCES:		CHECKED		CIMWD-122 Project 4	
		FRACTIONAL ±		ENG APPR.		SIZE DWG. NO. REV	
		ANGULAR: MACH ± BEND ±		MFG APPR.		Part 9 1 8 line Vert	
		TWO PLACE DECIMAL ±		Q.A.		SCALE: 1:2 WEIGHT: SHEET 1 OF 1	
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL					
		FINISH					
5	4	3	2	1			
APPLICATION		DO NOT SCALE DRAWING					





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