Gas Metal Arc Welding (Flat and Horizontal)

Project 5 – Specification and Print

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

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	Short Circuit Transfer
Tungsten Electrode	
Shielding Gas	75% Argon/25% CO2
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	GMAW	ER-70s-6	.035"		DC+	50	6	

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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

Additional Notes: Show instructor progress every 30 minutes minimum.

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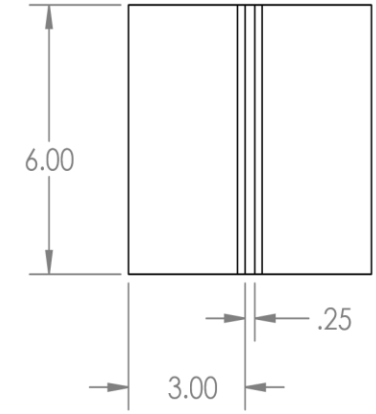

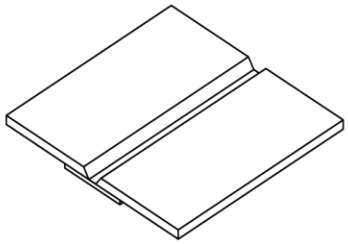

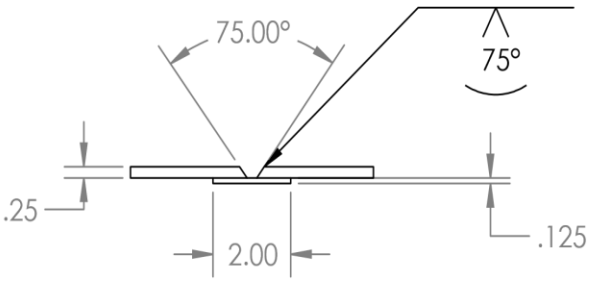

NOTE: OFC LINE BURNER
37 1/2° BEVEL CUT
1/8 BACKER WITH PAC PROCESS
TACK WITH GMAW
Weld per the WPS

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN	J.SIBERT	2/12/2015
			CHECKED		
			ENG APPR.		
			MFG APPR.		
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
		MATERIAL	COMMENTS:		
NEXT ASSY	USED ON	FINISH			
APPLICATION		DO NOT SCALE DRAWING			

TITLE: **CIMWD 130 Project 5**

SIZE	DWG. NO.	REV
A	PART 2	0

SCALE: 1:4 WEIGHT: SHEET 1 OF 1

5 4 3 2 1

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