



Gas Metal Arc Welding (Vertical and Overhead Welding)

Project 2 – Specification and Print

Weld Type	Fillet Weld
Welding Process	GMAW
Position	Vertical
Material	1/8" Steel
Joint Type	Tee
Backing Option	
Backing Material	

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	Tee	GMAW	ER-70s-6	.035"		DC+	50	6.0	





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Tee Joint use weave bead vertical down

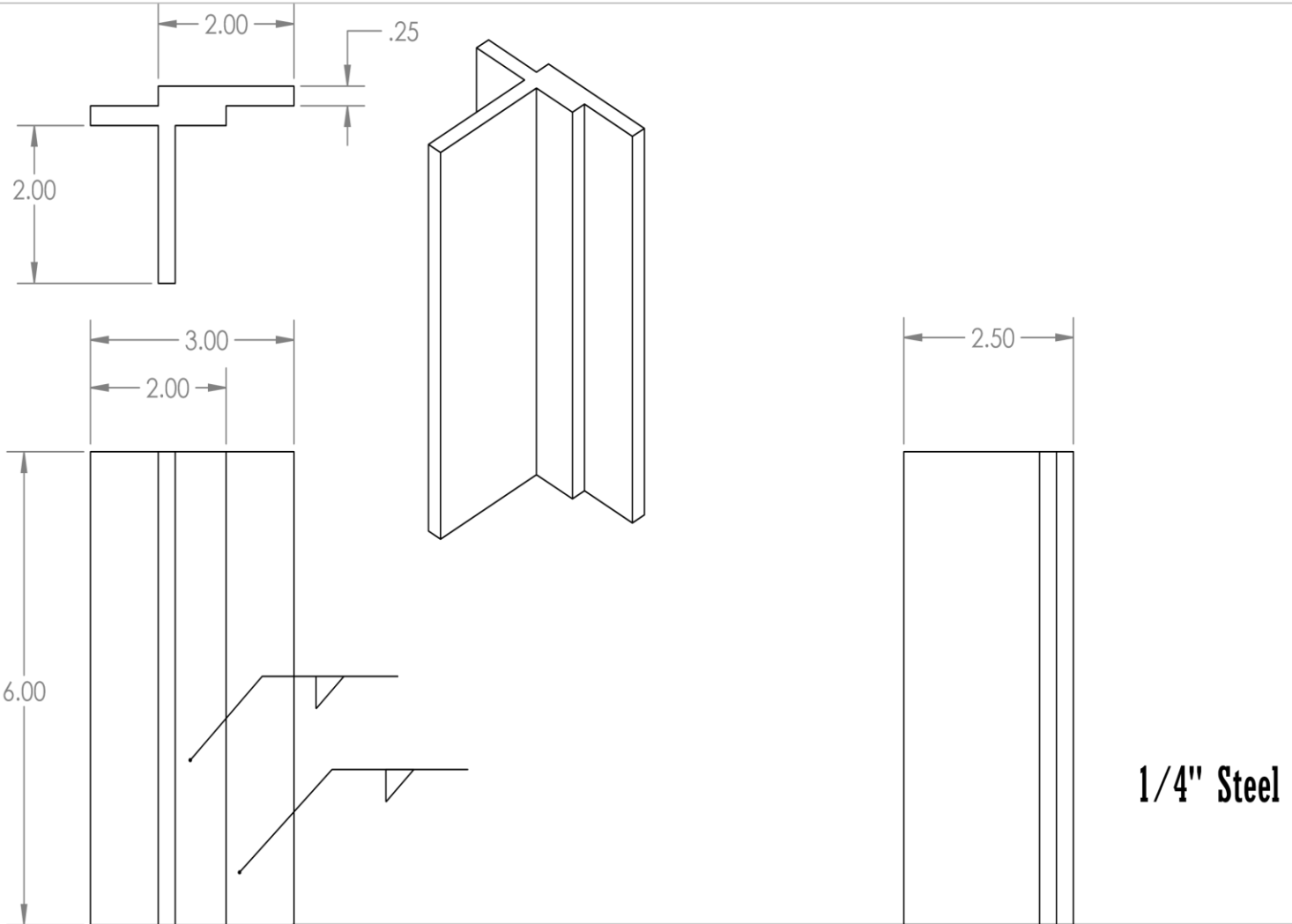
Additional Notes: Show instructor progress every 30 minutes minimum.





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1/4" Steel

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ±
ANGULAR: MACH ± BEND ±
TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±

INTERPRET GEOMETRIC
TOLERANCING PER:

MATERIAL

FINISH

DO NOT SCALE DRAWING

NAME DATE

DRAWN

CHECKED

ENG APPR.

MFG APPR.

Q.A.

COMMENTS:

TITLE:

CIMWD-131 Project 2

SIZE DWG. NO. REV
A **CIMWD 131 pr2**

SCALE: 1:2 WEIGHT: SHEET 1 OF 1

PROPRIETARY AND CONFIDENTIAL

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APPLY TO THIS ASSY USED ON

APPLICATION

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4

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