



Gas Metal Arc Welding (Vertical and Overhead Welding)

Project 3 – Specification and Print

Weld Type	2 Fillet and 1 PJP Groove
Welding Process	GMAW
Position	Vertical
Material	1/4" Steel
Joint Type	Lap
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
Weave	Lap	GMAW	ER-70s-6	.035"		DC+	50	6.5	





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Lap Joint use weave bead vertical up

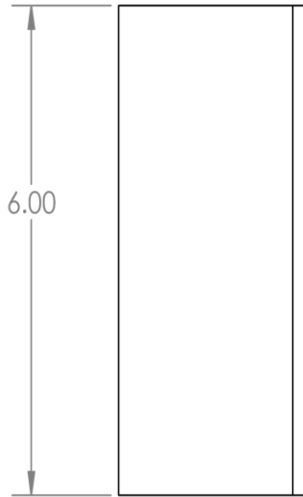
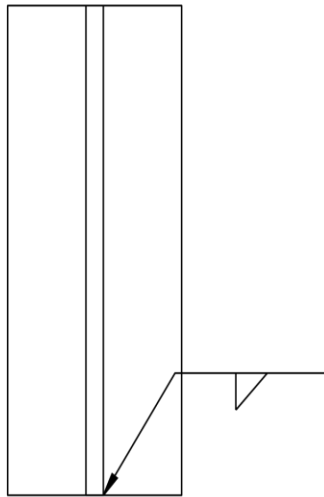
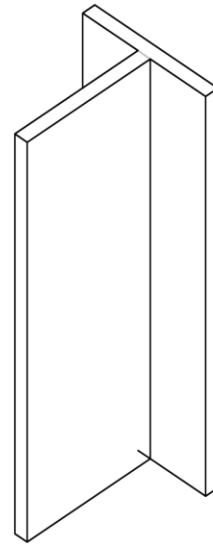
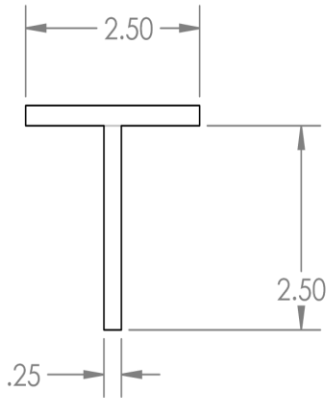
Additional Notes: Show instructor progress every 30 minutes minimum.





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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	J.SIBERT	2/19/2015	TITLE: CIMWD-131 Project 3
		TOLERANCES:		CHECKED			
		FRACTIONAL ±		ENG APPR.			
		ANGULAR: MACH ± BEND ±		MFG APPR.			
		TWO PLACE DECIMAL ±		Q.A.			
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL				SIZE DWG. NO. REV	
		FINISH				A PART 8 0	
		APPLICATION		DO NOT SCALE DRAWING		SCALE: 1:2 WEIGHT: SHEET 1 OF 1	

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