# Gas Metal Arc Welding (Vertical and Overhead Welding)

*Project 5 – Specification and Print*

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

| | |
|---|---|
| **Polarity** | DC+ |
| **Electrode** | ER70s-6 |
| **Transfer Mode** | Short Circuit |
| **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 or Weave | | GMAW | ER70s-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 or weave beads till just over flush in Vertical Up position

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

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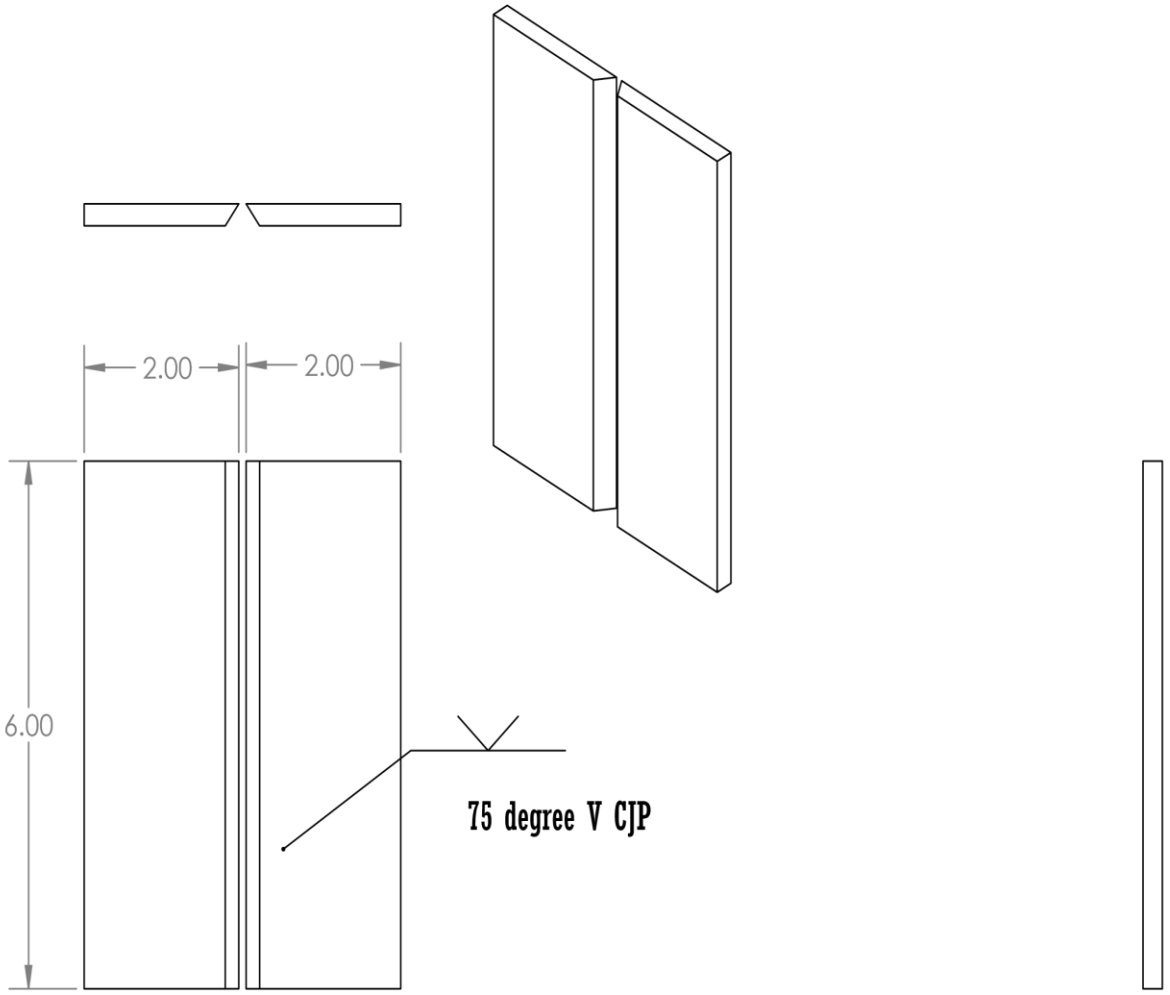


| | | | | | |
|---|---|---|---|---|---|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ±<br>ANGULAR: MACH ± BEND ±<br>TWO PLACE DECIMAL ±<br>THREE PLACE DECIMAL ± | DRAWN | | |
| | | | CHECKED | | |
| | | | ENG APPR. | | |
| | | | MFG APPR.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

TITLE: CIMWD-131 Project 5

SIZE A | DWG. NO. CIMWD 131 pr 5 | REV

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1



5 4 3 2 1

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