



Gas Metal Arc Welding (Vertical and Overhead Welding)

Project 6 – Specification and Print

Weld Type	Vee Groove Weld
Welding Process	GMAW
Position	Vertical
Material	1/4" Steel
Joint Type	Butt
Backing Option	CJP
Backing Material	

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

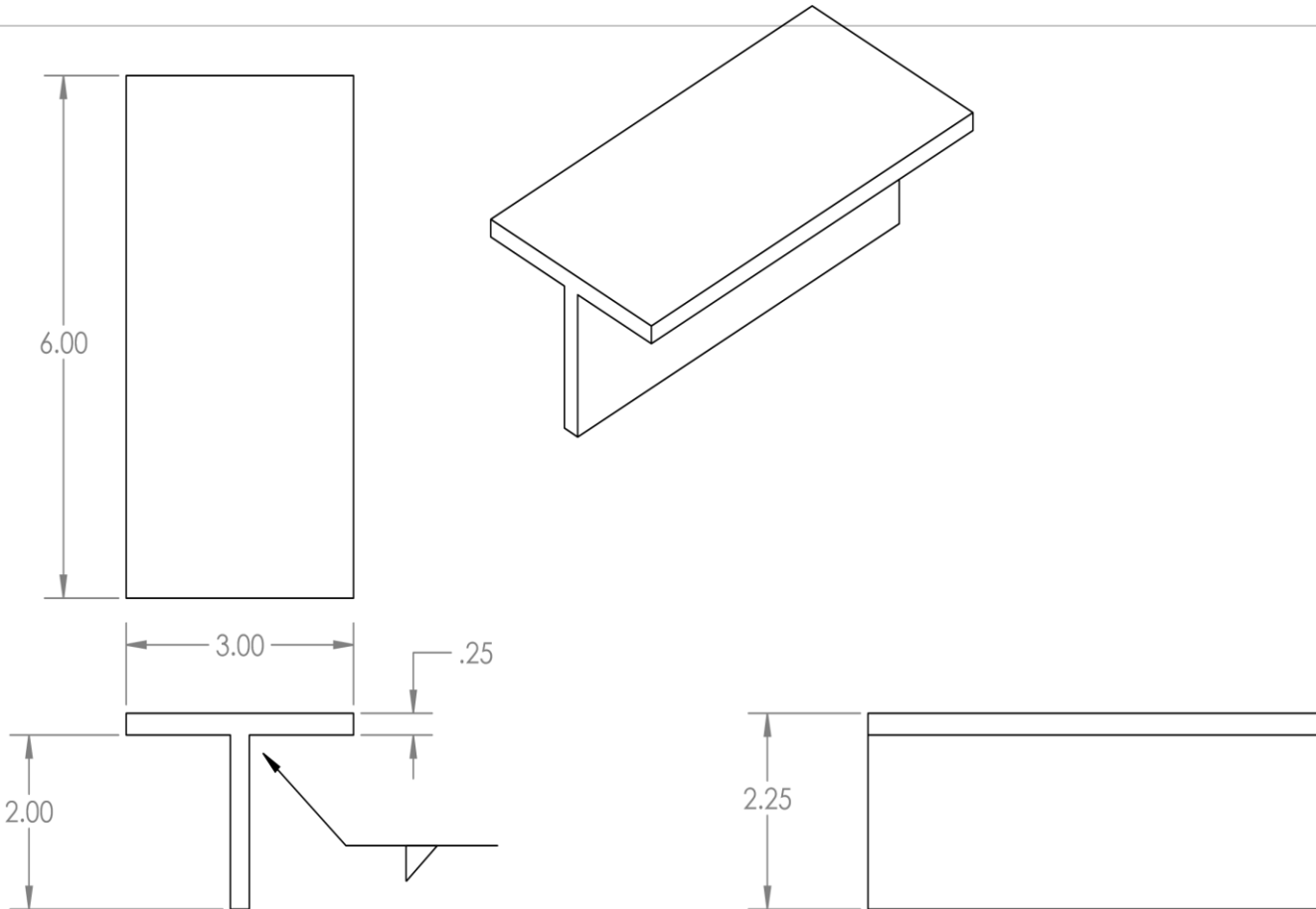
Additional Notes: Show instructor progress every 30 minutes minimum.





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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: CIMWD-131 Project 6
		DIMENSIONS ARE IN INCHES		DRAWN		
		TOLERANCES:		CHECKED		
		FRACTIONAL ±		ENG APPR.		
		ANGULAR: MACH ± BEND ±		MFG APPR.		SIZE DWG. NO. REV AIMWD 131 pr 6
		TWO PLACE DECIMAL ±		Q.A.		
		THREE PLACE DECIMAL ±		COMMENTS:		SCALE: 1:2 WEIGHT: SHEET 1 OF 1
		INTERPRET GEOMETRIC TOLERANCING PER:				
		MATERIAL				
		FINISH				
		APPLICATION				
		DO NOT SCALE DRAWING				





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