



Gas Metal Arc Welding (Vertical and Overhead Welding)

Project 8 – Specification

Weld Type	Fillet Weld
Welding Process	GMAW
Position	Overhead
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	Tee	GMAW	ER-70s-6	.035"		DC+	50	7.0	





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench between passes

Stress Relieving:

Technique: Lap Joint use weave bead in overhead position

Additional Notes: Show instructor progress every 30 minutes minimum.





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