



## Pipe Welding (2G and 5G Welding)

### Project 2 – Specification and Print

<b>Weld Type</b>	CJP Groove
<b>Welding Process</b>	SMAW or GTAW
<b>Position</b>	5G
<b>Material</b>	3" Sch. 80 Pipe
<b>Joint Type</b>	Vee Butt
<b>Backing Option</b>	No Backer
<b>Backing Material</b>	

<b>Polarity</b>	DC+
<b>Electrode</b>	E6010 3/32, E7018 3/32
<b>Transfer Mode</b>	
<b>Tungsten Electrode</b>	Or 2% Ceriated
<b>Shielding Gas</b>	100% Argon
<b>Flow Rate</b>	25cfh
<b>Cup Size</b>	

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	root	SMAW	E6010	3/32	50a	DC+			
	fill	"	E7018	3/32	75a	"			
	cover	"	E7018	3/32	75a	"			
Stringer	Root & Fill	GTAW	ER70s-6	1/16 or 3/32	120a	"			





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#### **Heat Treatment:**

**Preheat Temperature:**

**Post Heat Temperature:**

**Interpass Temperature:** Quench between passes

**Stress Relieving:**

**Technique:** SMAW- Root Pass performed with E6010 3/32 for CJP. Fill and Cover Passes performed with E7018 3/32.

GTAW- Root/Fill/Cover use ER70s-6 1/16" or 3/32" filler metal

Initial/Interpass Cleaning- Chip and Brush

Number of Electrodes-

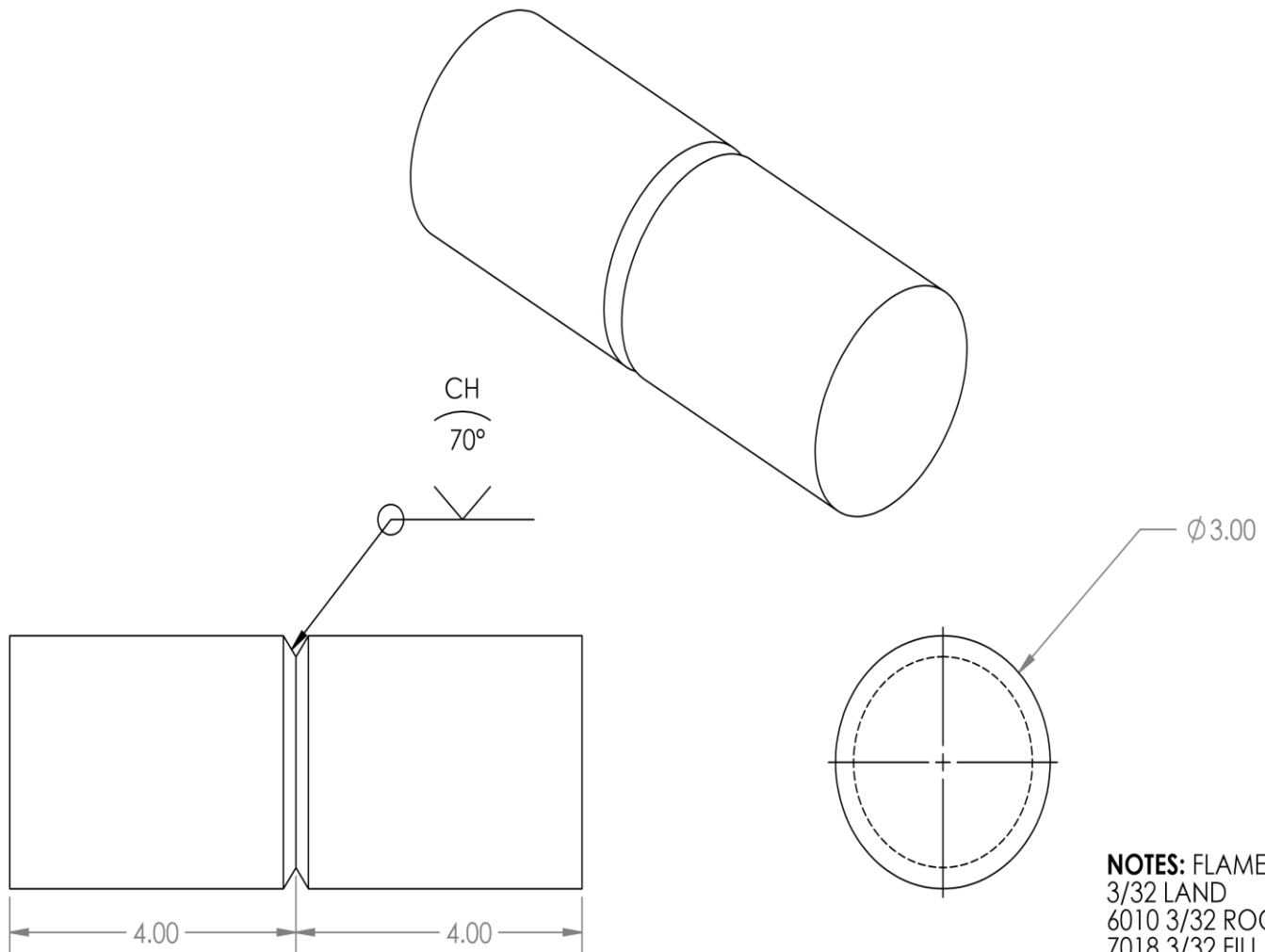
**Additional Notes:** Show instructor progress every 30 minutes minimum.





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**NOTES:** FLAME CUT BEVEL  
3/32 LAND  
6010 3/32 ROOT  
7018 3/32 FILL & COVER

		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	TITLE: CIMWD-210 Project 2	
		DIMENSIONS ARE IN INCHES	DRAWN	J.SIBERT		3/27/15
		TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	CHECKED			
		INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
		MATERIAL	MFG APPR.			
		FINISH	Q.A.			
		APPLICATION	COMMENTS:			
		DO NOT SCALE DRAWING				

SIZE	DWG. NO.	REV
	<b>A5G Drawing 0</b>	
SCALE: 1:2	WEIGHT:	SHEET 1 OF 1

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