



Pipe Welding – 6G Welding

Project 1 – Specification and Print

Weld Type	CJP Groove
Welding Process	SMAW or GTAW
Position	6G
Material	3" Sch. 80 Pipe
Joint Type	Vee Butt
Backing Option	No Backer
Backing Material	

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

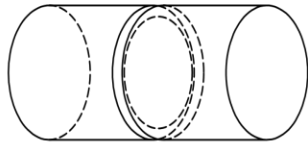
Additional Notes: Show instructor progress every 30 minutes minimum.



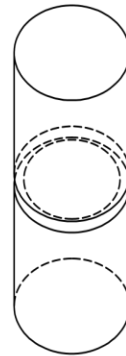
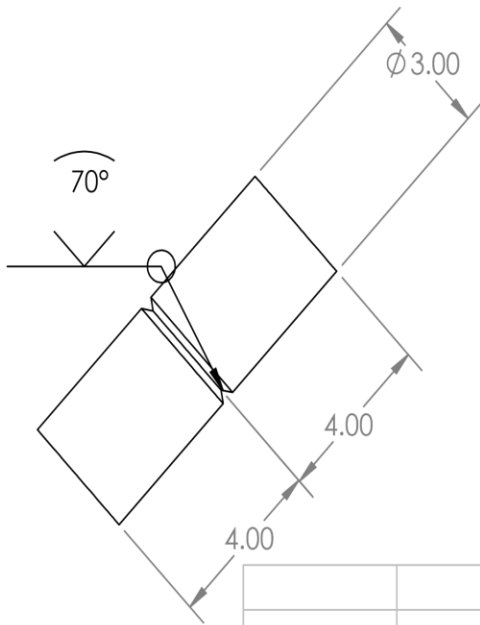


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NOTES: FLAME CUT BEVEL
3/32 LAND
6010 3/32 ROOT
7018 3/32 FILL & COVER

		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	TITLE: CIMWD-211 Project 1
		DIMENSIONS ARE IN INCHES	DRAWN	J.SIBERT	
		TOLERANCES:	CHECKED		
		FRACTIONAL \pm	ENG APPR.		
		ANGULAR: MACH \pm BEND \pm	MFG APPR.		
		TWO PLACE DECIMAL \pm	Q.A.		
		THREE PLACE DECIMAL \pm	COMMENTS:		
		INTERPRET GEOMETRIC TOLERANCING PER:			SIZE DWG. NO. REV
		MATERIAL			A 6G Drawing 0
		FINISH			SCALE: 1:4 WEIGHT: SHEET 1 OF 1
		USED ON			
		APPLICATION			
		DO NOT SCALE DRAWING			

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