



Tool and Die Welding (GTAW)

Project 1 – Specification and Print

Weld Type	Pad Build-Up
Welding Process	GTAW
Position	Flat
Material	1/4" Steel
Joint Type	
Backing Option	
Backing Material	

Polarity	DC+
Electrode	ER70s-6
Transfer Mode	
Tungsten Electrode	2% Ceriated
Shielding Gas	100% Argon
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
Pad		GTAW	ER70s-6	1/16"	130a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature:

Stress Relieving:

Technique: A pad build up using stringer beads. Looking for bead quality and bead placement. 2"x2"x1" high.

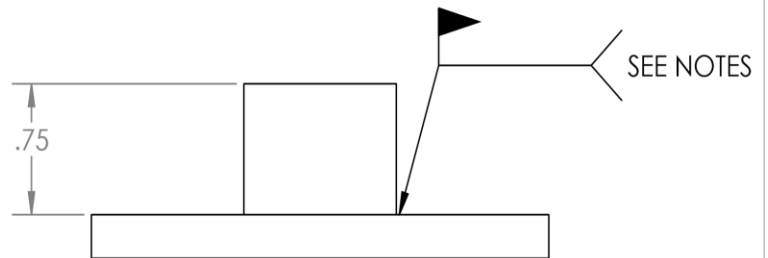
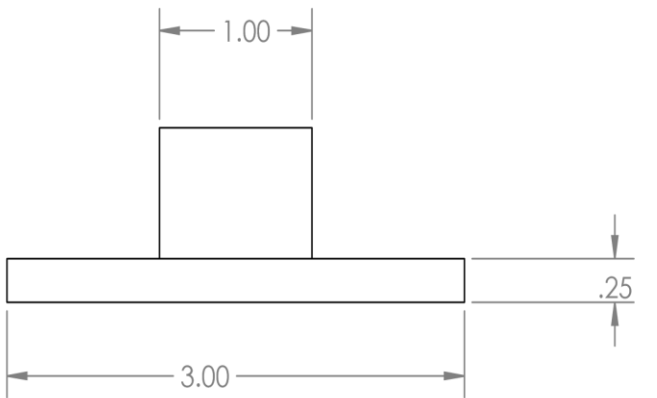
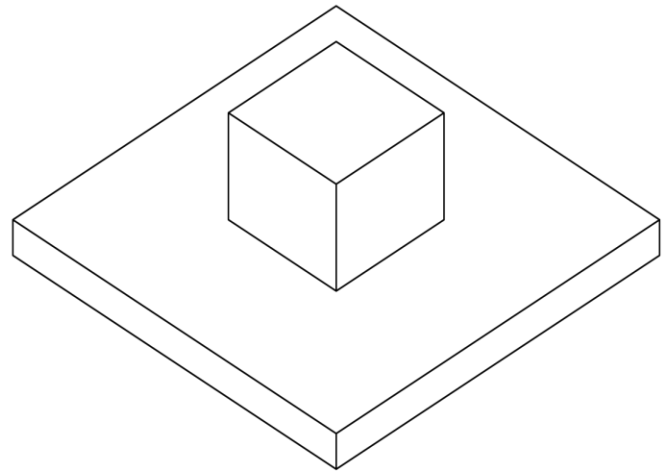
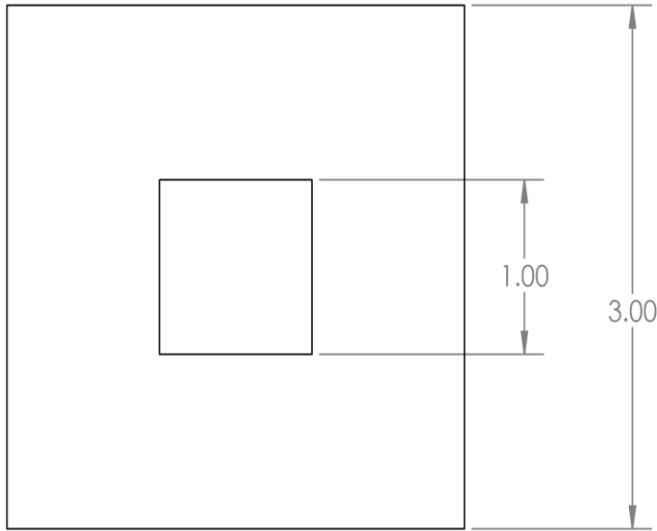
Additional Notes: Show instructor progress every 30 minutes minimum.





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NOTES:
PAD BUILD UP
GTAW PROCESS

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		UNLESS OTHERWISE SPECIFIED:	NAME	DATE		
		DIMENSIONS ARE IN INCHES	DRAWN	J.SIBERT	5/5/15	TITLE: CIMWD-221 Project 1
		TOLERANCES:	CHECKED			
		FRACTIONAL ±	ENG APPR.			
		ANGULAR: MACH ± BEND ±	MFG APPR.			
		TWO PLACE DECIMAL ±	Q.A.			SIZE DWG. NO. REV A PART 15 D
		THREE PLACE DECIMAL ±	COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:				SCALE: 1:1 WEIGHT: SHEET 1 OF 1
		MATERIAL				
		FINISH				
		DO NOT SCALE DRAWING				
5	4	3	2	1		





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