



Tool and Die Welding (SMAW)

Project 1 – Specification and Print

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

Polarity	DC+
Electrode	E7018 3/32
Transfer Mode	
Tungsten Electrode	
Shielding Gas	
Flow Rate	
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		SMAW	E7018	3/32"	75a	DC+			





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Heat Treatment:

Preheat Temperature:

Post Heat Temperature:

Interpass Temperature: Quench every 2-3 passes

Stress Relieving:

Technique: A pad build up using stringer beads. Looking for bead quality and bead placement.
3"x3"x1 1/2" high.

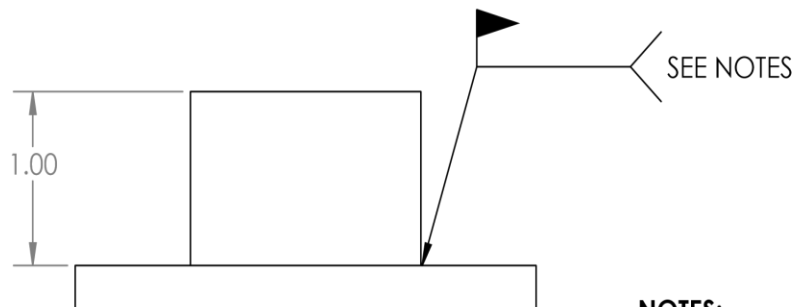
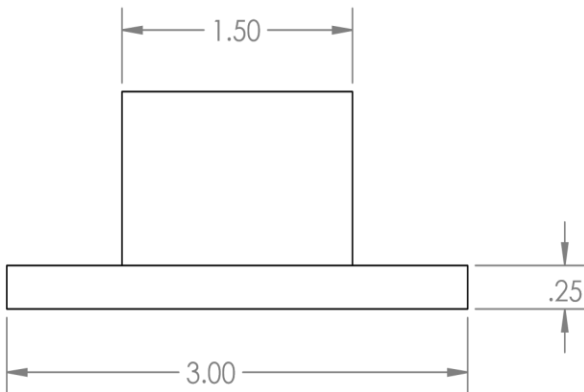
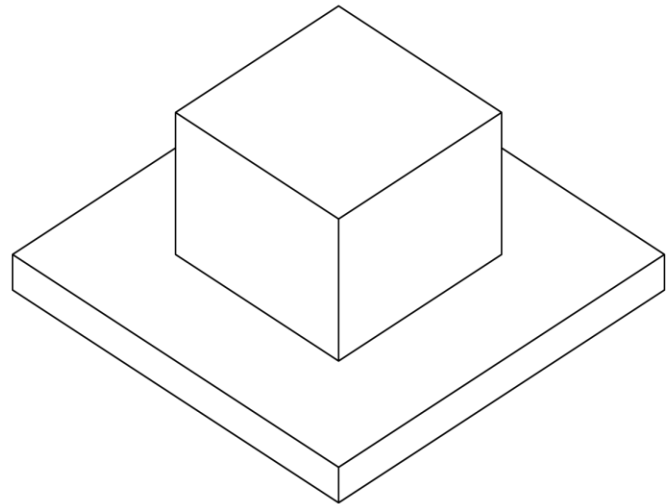
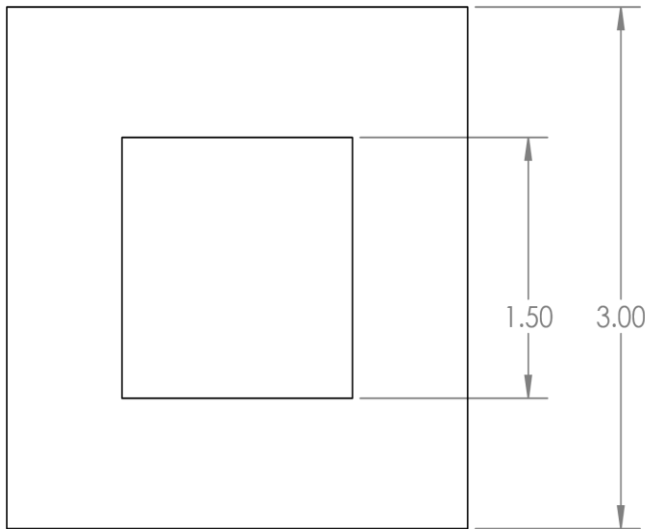
Additional Notes: Show instructor progress every 30 minutes minimum.





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NOTES:
PAD BUILD UP
SMAW PROCESS
7018 3/32

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE:
DIMENSIONS ARE IN INCHES		DRAWN	J.SIBERT	
TOLERANCES:		CHECKED		CIMWD-222 Project 1
FRACTIONAL ±		ENG APPR.		
ANGULAR: MACH ± BEND ±		MFG APPR.		
TWO PLACE DECIMAL ±		Q.A.		SIZE
THREE PLACE DECIMAL ±		COMMENTS:		DWG. NO.
INTERPRET GEOMETRIC TOLERANCING PER:				A
MATERIAL				PART 13
FINISH				REV
APPLICATION				SCALE: 1:1
DO NOT SCALE DRAWING				WEIGHT:
				SHEET 1 OF 1

5

4

3

2

1





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