Tool and Die Welding (SMAW)

Project 2 – Specification and Print

Weld Type	Line 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 line build up using stringer beads. Looking for bead quality and bead placement. 3 ½”x1 1⁄2” high.

Additional Notes: Show instructor progress every 30 minutes minimum.

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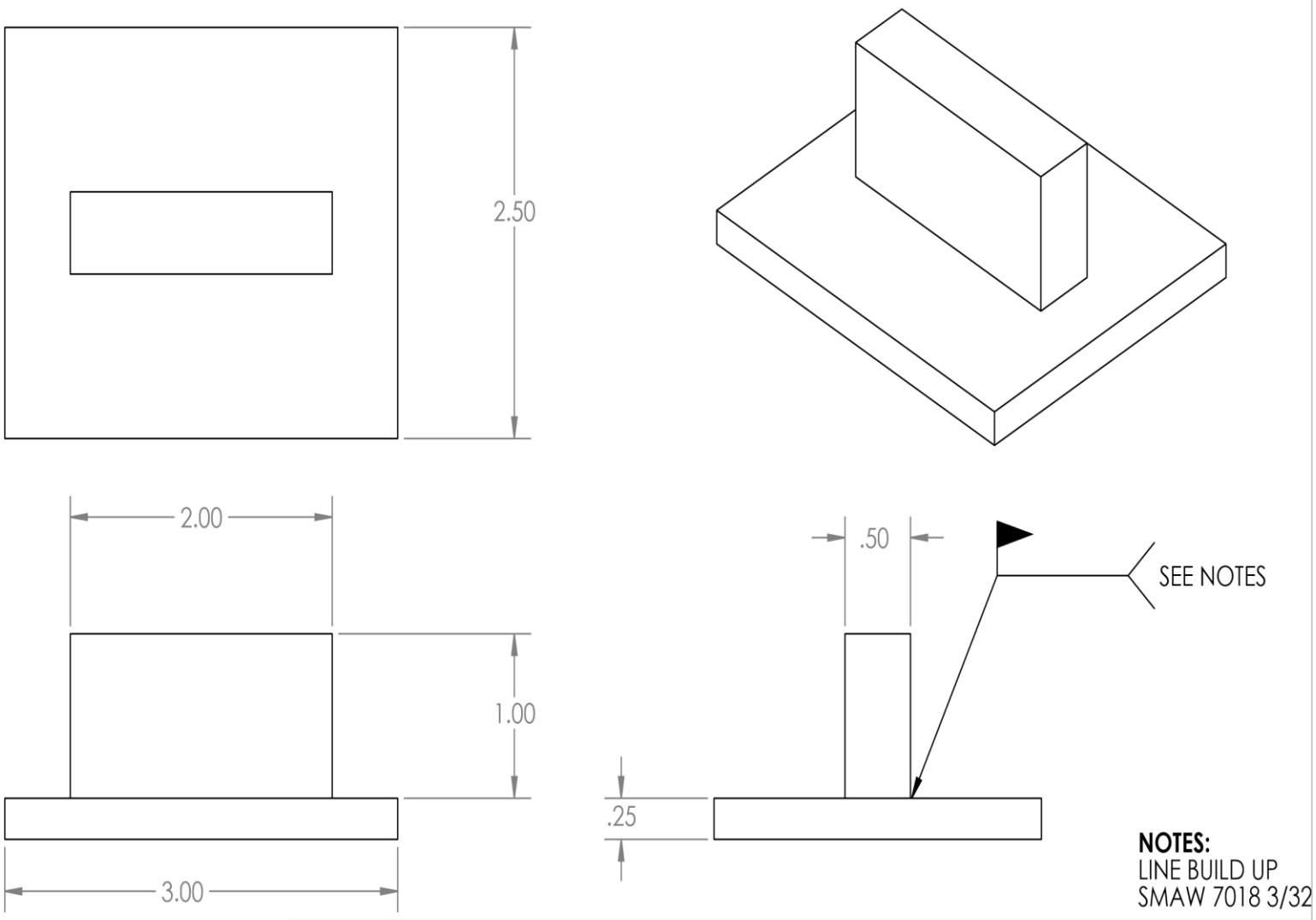

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