



CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Recommended Textbook:

Welding: Principles and Applications 8th Edition

Course Description:

Explores the theory and operation of shielded metal arc welding in a vertical welding position.

Course Topics

1. Safety protocols.
2. Vertical welding position.
3. Final weldment assembly.

Learning Objectives

1. Demonstrate proper safety practices for Shielded Metal Arc Welding.
2. Apply the proper welding machine settings for a given competency using the Shielded Metal Arc Welding process.
3. Demonstrate proper welding technique in vertical position using the Shielded Metal Arc Welding process.
4. *Perform welds using proper preparation and welding technique for a given weldment.

Competency-Based Education

The Welding Program at Henry Ford College uses a system of learning called Competency-Based Education (CBE). This competency-based welding program is centered on teaching specific job skills required in industry and mastery of these skills.

CBE is a very personalized teaching system that has the following characteristics:

- Ongoing Program
- Open entry - flexible schedule
- Credit granted for work completed
- Evaluation (grades) based on performance
- Fixed content in each course
- Variety of student levels served in each class
- Work at your own pace
- Live or taped lectures and demonstrations





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This competency-based program has several very important benefits for you:

- You will be given a list of the skills and knowledge needed to complete the program successfully.
- Your performance will not be compared to that of other students, but to a fixed standard, which has been set for the program.
- If you have already acquired certain skills required for this program, you may simply demonstrate this and begin focusing your attention on new skills.
- You will be able to review learning materials several times in order to attain the skill or knowledge.
- If you are able to attain the skills easily, you may progress through the program faster than the average person. If you progress through the program faster than average, you can graduate in a shorter time frame.

What's Required of You:

For this system to work, you will be expected to:

1. Assume the responsibility for your own learning. Your instructor will give you assistance, but the actual responsibility for learning rests with you, the student.
2. Utilize the materials provided for you. The program's resources have been carefully chosen and developed to help you learn.
3. Devote your energy to attaining the skills and knowledge required for your program.

The Instructor's Role:

The instructors in HFC's Welding Program work with students individually and guide them through the learning process with the help of many different learning resources. In CBE, instructors are often referred to as learning managers because they manage the activities in the program and facilitate the learning process. If you are having difficulty, you should go to your instructor with your problem. The instructor's goal is to find the most effective way to help you learn the tasks in the program.

How your grade is computed in this program:

If your class is a designated lecture module, your grade will be based off of an exit quiz. When a passing grade is complete, you will be able to move on to the next module.

If this class is a designated lab module, your grade will be based off of a grading matrix. You will evaluate your competencies along with the instructor. You will need a 3-ring binder to keep the finished and signed grading sheets. Those will be turned in when all projects are finished for the module your taking. The final grade will be entered when these are reviewed.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Welding Technology Grading Checklist

Check	Criteria	Points
	Safety (10 points)	
	PPE	
	Equipment in working order	
	Lab rules followed	
	Work areas cleaned and tools returned	
	Welding, Cutting, & Fabrication Set-Up (10 points)	
	Welding machine set correctly	
	Cutting machines set correctly	
	Fabrication machines set correctly	
	Followed Instructions (10 points)	
	Parts cut to correct size	
	Joints assembled correctly	
	Position of weld was correct	
	Correct filler metal was used	
	Visual Inspection of weld (20 points)	
	Bead width	
	Welding angle	
	Arc gap if applicable	
	Porosity	
	Fillet weld size if applicable	
	Groove weld under fill	
	Joint penetration	
	Incomplete fusion	
	Cracks	
	Cold lap	
	Undercut	
	Arc strikes	
	Fillet weld contour if applicable	
	Inclusions	
	Groove weld height (overfill)	





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Corrective Action Taken:

Student: _____

Instructor: _____

Grading Scale:

- A+ = 100-98
- A = 97-93
- A- = 92-90
- B+ = 89-87
- B = 86-83
- B- = 82-80
- C+ = 79-77
- C = 76-73
- C- = 72-70
- D+ = 69-67
- D = 66-63
- D- = 62-60
- E = 59-below

Chapters:

3, 4, 22, 23, 24, 25, 28

Estimated Time for Projects:

- Project 1: 8 hrs
- Project 2: 6 hrs
- Project 3: 4 hrs
- Project 4: 12 hrs





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

UNLESS OTHERWISE SPECIFIED:		DRAWN	CHECKED	ENG APPR.	MFG APPR.	G.A.	COMMENTS:
DIMENSIONS ARE IN INCHES							
TOLERANCES:							
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TITLE:		CIMWD-111 Project 1	
SIZE	DWG. NO.	REV	
	CIMWD111	pr1	
SCALE: 1:2	WEIGHT:	SHEET 1 OF 1	





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Welding Procedure Specification

WPS Name	CIMWD-111 Project 1
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Weld Type	4 Fillet Welds
Welding Process	SMAW
Position	Vertical
Material	¼" Steel
Joint Type	Tee
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
Multi Pass to top	Stringers	SMAW	E7018	3/32	70a	DC+			
	Weave	SMAW	E7018	3/32	70a				

Technique:

2 sides are to be done using stringer beads welding in vertical up.
2 sides are to be done using a weave technique welding in vertical up.

Number of Electrodes- whatever it takes





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Heat Treatment:

Preheat Temperature-

Post Heat Temperature-

Interpass Temperature- Quench after 2-3 passes

Stress Relieving-

Additional Notes:

Show the instructor progress every 30 minutes minimum.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

DRAWN	CHECKED	ENG APPR.	MFG APPR.	G.A.	COMMENTS:	TITLE: CIMWD-111 Project 2	
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						A	Vert 16
						SCALE: 1:4	WEIGHT: SHEET 1 OF 1

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TOLERANCES:
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ANGULAR MACH ± BEND ±
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THREE PLACE DECIMAL ±

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Shielded Metal Arc Welding – Vertical Welding

Welding Procedure Specification

WPS Name	CIMWD-111 Project 2
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Weld Type	2 Fillet welds and 1 Square Groove
Welding Process	SMAW
Position	Vertical
Material	¼" Steel
Joint Type	Tee, Lap, and Butt
Backing Option	
Backing Material	

Polarity	DC+
Electrode	E7018 3/32
Transfer Mode	
Tungsten Electrode	
Shielding Gas	
Flow Rate	
Cup Size	

Welding Procedure

Weld Layer s	Pass No.	Processes	Filler Metal Classification	Filler Metal Diameter in (mm)	Current Amps	Current Type and Polarity	Wire Feed Speed	Volts	Remarks
Tee	Stringer	SMAW	E7018	3/32	70a	DC+			
Lap	Stringer	SMAW	E7018	3/32	70a	"			
Butt	Stringer	SMAW	E7018	3/32	70a	"			

<p>Technique: Weld the joints using a vertical up stringer method.</p> <p>Number of Electrodes- whatever it takes</p>





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Heat Treatment:

Preheat Temperature-

Post Heat Temperature-

Interpass Temperature- Quench after each pass

Stress Relieving-

Additional Notes:

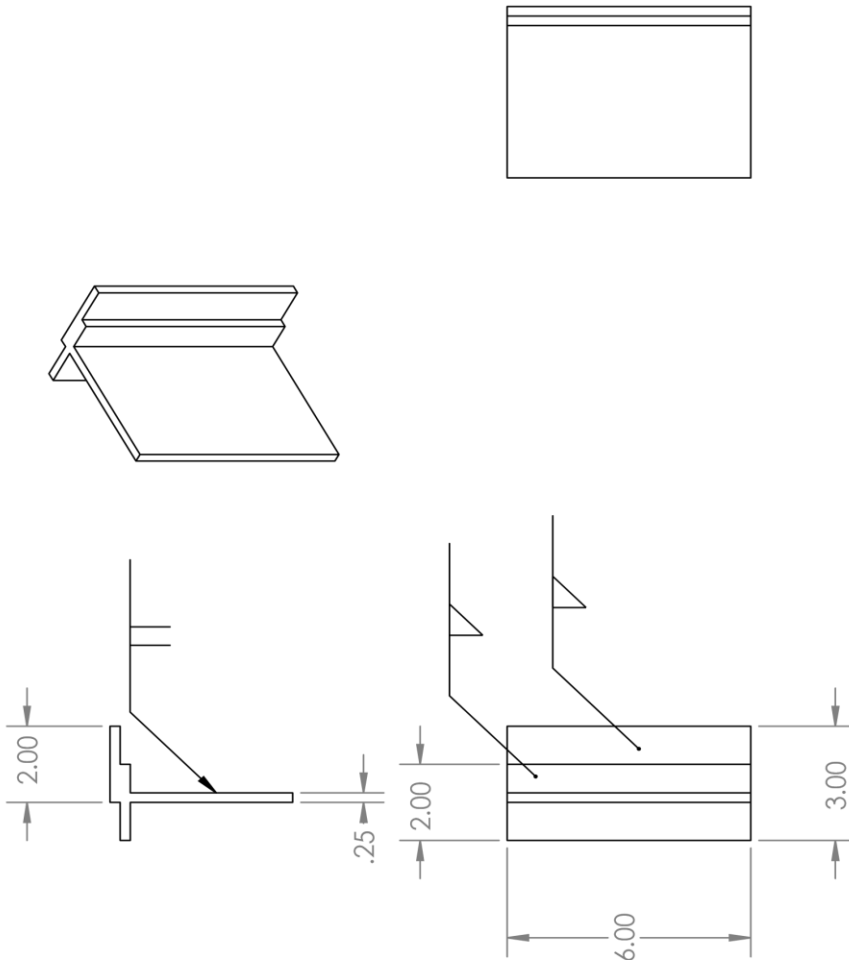
Show the instructor progress every 30 minutes minimum.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding



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Shielded Metal Arc Welding – Vertical Welding

Welding Procedure Specification

WPS Name	CIMWD-111 Project 3
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Weld Type	2 Fillet welds and 1 Square Groove
Welding Process	SMAW
Position	Vertical
Material	¼" Steel
Joint Type	Tee, Lap, and Butt
Backing Option	
Backing Material	

Polarity	DC+
Electrode	E7018 3/32
Transfer Mode	
Tungsten Electrode	
Shielding Gas	
Flow Rate	
Cup Size	

Welding Procedure

Weld Layer s	Pass No.	Processes	Filler Metal Classification	Filler Metal Diameter in (mm)	Current Amps	Current Type and Polarity	Wire Feed Speed	Volts	Remarks
Tee	Stringer	SMAW	E7018	3/32	80a	DC+			
Lap	Stringer	SMAW	E7018	3/32	80a	"			
Butt	Stringer	SMAW	E7018	3/32	80a	"			

Technique:
Weld the joints using a vertical down stringer method.

Number of Electrodes- whatever it takes





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Heat Treatment:

Preheat Temperature-

Post Heat Temperature-

Interpass Temperature- Quench after each pass

Stress Relieving-

Additional Notes:

Show the instructor progress every 30 minutes minimum.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

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CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Welding Procedure Specification

WPS Name	CIMWD-111 Project 4
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Weld Type	Vee Groove Weld
Welding Process	SMAW
Position	Vertical
Material	1/4" Steel
Joint Type	Butt
Backing Option	CJP
Backing Material	

Polarity	DC+
Electrode	E6010 3/32 and 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
Stringer	Root	SMAW	E6010	3/32	50	DC+			
	Fill	SMAW	E7018	3/32	70	"			
	Cover	SMAW	E7018	3/32	70	"			

Technique:

Root Pass using E6010 for CJP. Grind root on face side smooth. Fill and cover using E7018 with a stringer or weave in vertical up position.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

Heat Treatment:

Preheat Temperature-

Post Heat Temperature-

Interpass Temperature- Quench between passes

Stress Relieving-

Additional Notes:

Show the instructor progress every 30 minutes minimum.





CIMWD-111 Syllabus

Shielded Metal Arc Welding – Vertical Welding

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