

Welding Technology Program WLDG 275 Rotation Schedule Spring 2016



	Workdays	Job Number	
WEEK 1 Jan 25- Jan 29	5		275-1 Stringer Build-up plate (flat & horizontal) .045 E70C-6M H4
			275-10 2F T-Joint .045 E70C-6M H4, 1/4" Fillet
			275-11 2F Lap Joint .045 E70C-6M H4, 1/4" Fillet
			275-12 2F Skewed T-Joint .045 E70C-6M H4, 1/4" Fillet
WEEK 2 Feb 1- Feb 5	5		275-100 Stringer Build-up plate (flat & horizontal) .035 ER70S-6
			275-110 2F T-Joint .035 ER70S-6, 3/16" - 1/4", Full Fillet
			275-120 2F T-Joint (Circumferential) .035 ER70S-6, Full Fillet
			275-130 3F T-Joint .035 ER70S-6, 1/8 fillet max downhill on thin gauge steel
WEEK 3 Feb 8- Feb 12	5		275-140 3F T-Joint .035 ER70S-6, 3/16" to 1/4", Uphill Full Fillet
			275-150 2F T-Joint .035 ER308L, 3/16" - 1/4", Full Fillet
			275-160 1G .035 ER70S-6, 1/4" Plate-Complete Joint Penetration (Spray Transfer)
			275-165 1G .035 ER70S-6/ .045 E70C-6M H4, 3/8 plate with backing @ 1 each
WEEK 4 Feb 15- Feb 19	4		275-170 2F T-Joint uphill .035 ER70S-6, 1/4" Single Pass & 3/8 Multiple Pass
			275-180 PAC- Cut to specification from print
			275-190 1G .035 ER308L, 3/8" Plate w/o backing
			Welding
WEEK 5 Feb 22- Feb 26	5		275-205 2F T-Joint .035 ER4043 Aluminum Short Circuit Spool Gun
			275-210 2F T-Joint .035 ER70S-6, 3/16" to 1/4" Full Fillet (Spray Transfer)
			275-215 3G Outside Corner .035 ER70S-6, 11-16 gauge sheet metal, Downhill
			275-220 3G .035 ER70S-6 3/8 plate with backing, Downhill Root & Fill
WEEK 6 March 29- March 4	5		275-225 2F T-Joint .035 ER4043, 1/4 - 3/8 Plate (Pulse Transfer)
			275-230 2F .035 ER70S-6, Lateral Connection Branch on Header 2" Dia. x .120 Tubing
			275-235 2F T-Joint with 2595 Filler, 3/16" to 1/4" Full Fillet (Pulse Transfer) on 2507 plate
			Welding
WEEK 7 March 7- March 11	2		To be determined from WPS's from Harris Thermal Transfer Products and Coaster Pedicab for 275-240 thru 250
			275-245
			275-250
WEEK 7 March 14- March 16	3		Final Weld Test

END 1ST HALF OF SEMESTER

MACHINES USED:

DC-400 XMT 304

