



**WELDING CHARACTERISTICS:**

Current: DCEP and DCEP Tungsten type: N/A Transfer Mode: Spary  
 Ranges: Amps 280 to 310 Pulsing Cycle: to  
 Volts 26 to 30 Background Current:  
 Fuel Gas: N/A Flame: N/A Braze temp. F 0 to 0

**WELDING TECHNIQUE:** For cleaning, grinding, and inspection criteria refer to Volume 2, Welding Fabrication Procedures

Technique: Manual Cleaning Method: Wire Brush, File, Grind  
 Single Pass of Multi Pass: M Striker or Weave bead (S/W): S Oscillation: N  
 GMAW Gun Angle °: 5 to 15 Forehand or Backhand for GMAW (F/B): F  
 Maximum K/J Heat Input Travel speed/ipm: 8 - 14 Gas Cup Size:

**PROCEDURE QUALIFIED FOR:**

Charpy "V" Notch: N Nil-Ductil Transition Temperature: N Dynamic Tear: N

Comments:

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel ipm	Nozzel Angle	Other
1	GMAW-	ER100S-1	1/16	280 310	26 30	8 10	5	
2	GMAW-	ER100S-1	1/16	280 310	26 30	10 14	15	
3			1/16					
4			1/16					
5								
6								
7								
8								

REM. \* Weld layers are representative only - actual number of passes and layer sequence may vary due to variations in joint design, thickness and fitup.