

WELDING CHARACTERISTICS:

Current: DCEP and DCEP Tungsten type: N/A Transfer Mode: Globular
 Ranges: Amps 130 to 300 Pulsing Cycle: 0 to 0
 Volts 24 to 30 Background Current: 0
 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 Grind
 Single Pass of Multi Pass: M Striker or Weave bead (S/W): S/W Oscillation: N
 GMAW Gun Angle °: 5 to 15 Forehand or Backhand for GMAW (F/B): FB
 Maximum K/J Heat Input Travel speed/ipm: 7 - 18 Gas Cup Size: .5 - .875

PROCEDURE QUALIFIED FOR:

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

Comments:

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel ipm	Nozzel Angle	Other
1	MAW-FC	E7XT-x	3/64	130 300	24 30	7 18	5	
2	MAW-FC	E7XT-x	5/64	130 300	24 30	7 18	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.