

WELDING CHARACTERISTICS:

Current: DCEP and DCEP Tungsten type: N/A Transfer Mode: N/A
 Ranges: Amps 115 to 155 Pulsing Cycle: 0 to 0
 Volts 23 to 30 Background Current: 0
 Fuel Gas: N/A Flame: N/A Braze temp. F to

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

Technique: Manual Cleaning Method: Wire Brush, File, Grind, Chip
 Single Pass of Multi Pass: M Stringer or Weave bead (S/W): S Oscillation: N
 GMAW Gun Angle °: to Forehand or Backhand for GMAW (F/B): N/A
 Maximum K/J Heat Input Travel speed/ipm: 2 - 5 Gas Cup Size: N/A

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	SMAW-	EXX18-X	3/32	115 155	23 30	2 5		
2	SMAW-	EXX18-X	1/8	115 155	23 30	2 5		
3			1/8					
4			5/32					
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.