



**WELDING CHARACTERISTICS:**

Current: DCEN and DCEN Tungsten type: EWTH-2 Transfer Mode: N/A  
 Ranges: Amps 75 to 180 Pulsing Cycle: 0 to 0  
 Volts 12 to 18 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  
 Single Pass of Multi Pass: M Striker or Weave bead (S/W): S Oscillation: N  
 GMAW Gun Angle °: 0 to 0 Forehand or Backhand for GMAW (F/B): N/A  
 Maximum K/J Heat Input 97200 Travel speed/ipm: 2 - 4 Gas Cup Size: #3 - 7

**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	GTAW-	ERCuNi-7	1/16	75 150	12 18	2 4	0	
2	GTAW-	ERCuNi-7	1/16	90 180	12 18	2 4	0	
3			3/32					
4			1/8					
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.