

WELDING CHARACTERISTICS:

Current: DCEP and DCEP Tungsten type: N/A Transfer Mode: Spary
 Ranges: Amps 270 to 300 Pulsing Cycle: to
 Volts 27 to 31 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:
 Single Pass of Multi Pass: M Stringer 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 52 Travel speed/ipm: 10 - 17 Gas Cup Size:

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-SF	ER100S-1	3/64	270 300	27 31	10 17	5	
2	MAW-SF	ER100S-1	3/64	270 300	27 31	10 17	15	
3			3/64					
4			3/64					
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.