

WELDING CHARACTERISTICS:

Current: DCEP and DCEP Tungsten type: N/A Transfer Mode: N/A
 Ranges: Amps 70 to 160 Pulsing Cycle: 0 to 0
 Volts 14 to 24 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 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 Travel speed/ipm: 3 - 0 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- | E9018 | 3/32 | 70 140 | 14 24 | 3 9 | 0 | |
| 2 | SMAW- | E9018 | 1/8 | 90 160 | 14 24 | 0 0 | 0 | |
| 3 | | | 1/8 | | | | | |
| 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.