



**WELDING CHARACTERISTICS:**

Current: DCEN and DCEN Tungsten type: EWTH-2 Transfer Mode: N/A  
 Ranges: Amps 18 to 22 Pulsing Cycle: 45 to 50  
 Volts 5 to 8 Background Current: 10  
 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: Automatic Cleaning Method: Wire Brush, File, Grind  
 Single Pass of Multi Pass: S Stringer 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: 28 - 35 Gas Cup Size:

**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-AT	N/A	0/00	18 22	5 8	28 35	0	
2	GTAW-AT		0/00	18 22	5 8	0 35	0	
3			0/00					
4			0/00					
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.