



GTAW  
 ELECTRODE: ER70S-6  
 APPROXIMATE SETTINGS: 80-150A  
 PROGRESSION: VERTICAL UP

1. Acquire 2- 2"x4" plates from your instructor. Grind all areas where there will be weld.
2. Tack weld the plates into a "t" as shown.
3. Attach the plates to a welding grate in the vertical position as shown.
4. Run your root pass. submit to the instructor for approval.
5. Run the cover pass using a weave pattern.
6. Quench, clean and submit for evaluation.

Evaluation \_\_\_\_\_ Pts. Possible \_\_\_\_\_ Pts. Given \_\_\_\_\_

- |                       |   |
|-----------------------|---|
| a. Metal Preparation  | 5 |
| b. Root Pass          | 5 |
| c. Cover Pass         | 5 |
| d. Overall Appearance | 5 |

COMPANY NAME: WELDING FABRICATION      DRAWING NAME: GMAW VERTICAL UP INSIDE CORNER      SCALE: 1:1      NAME: