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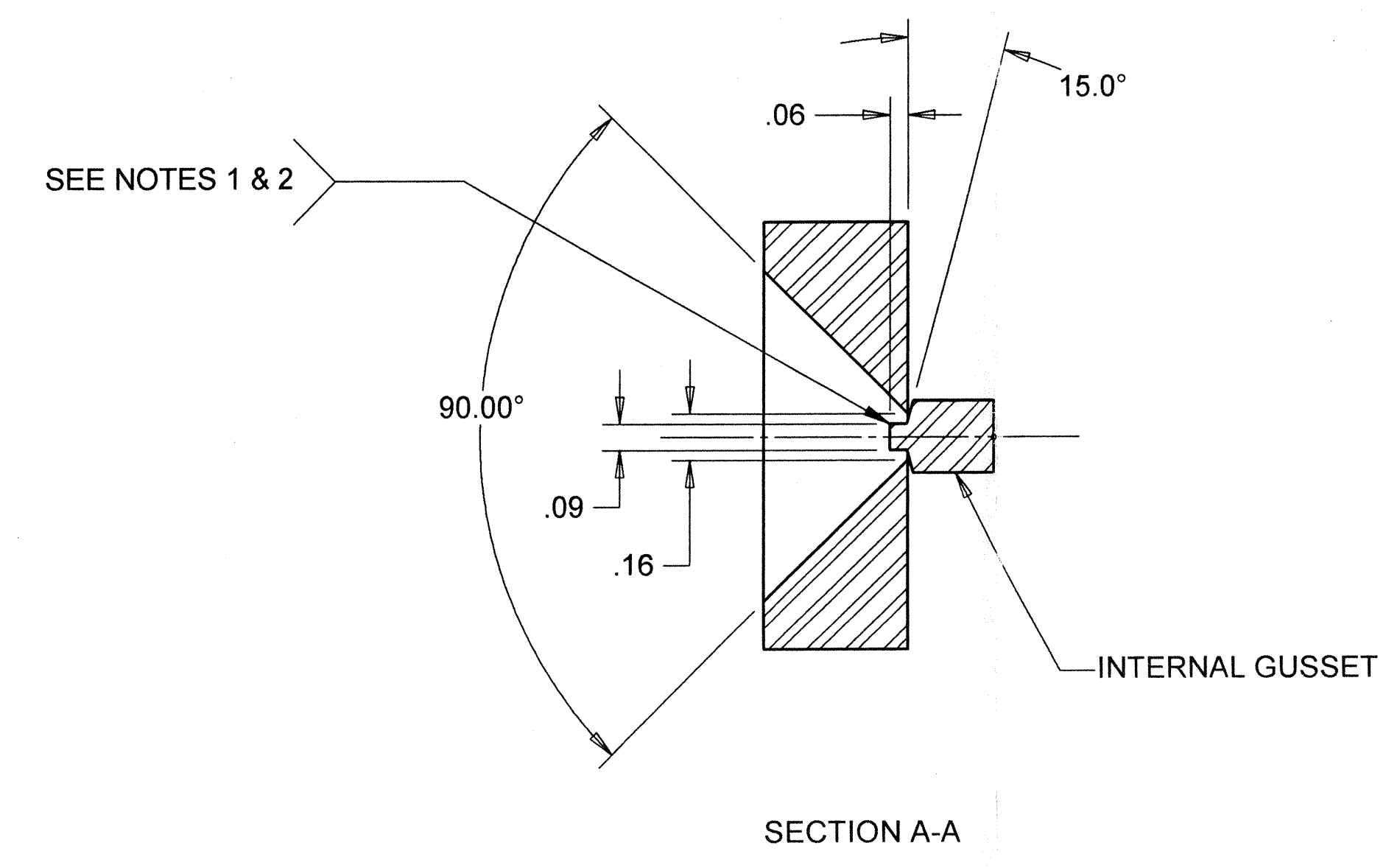
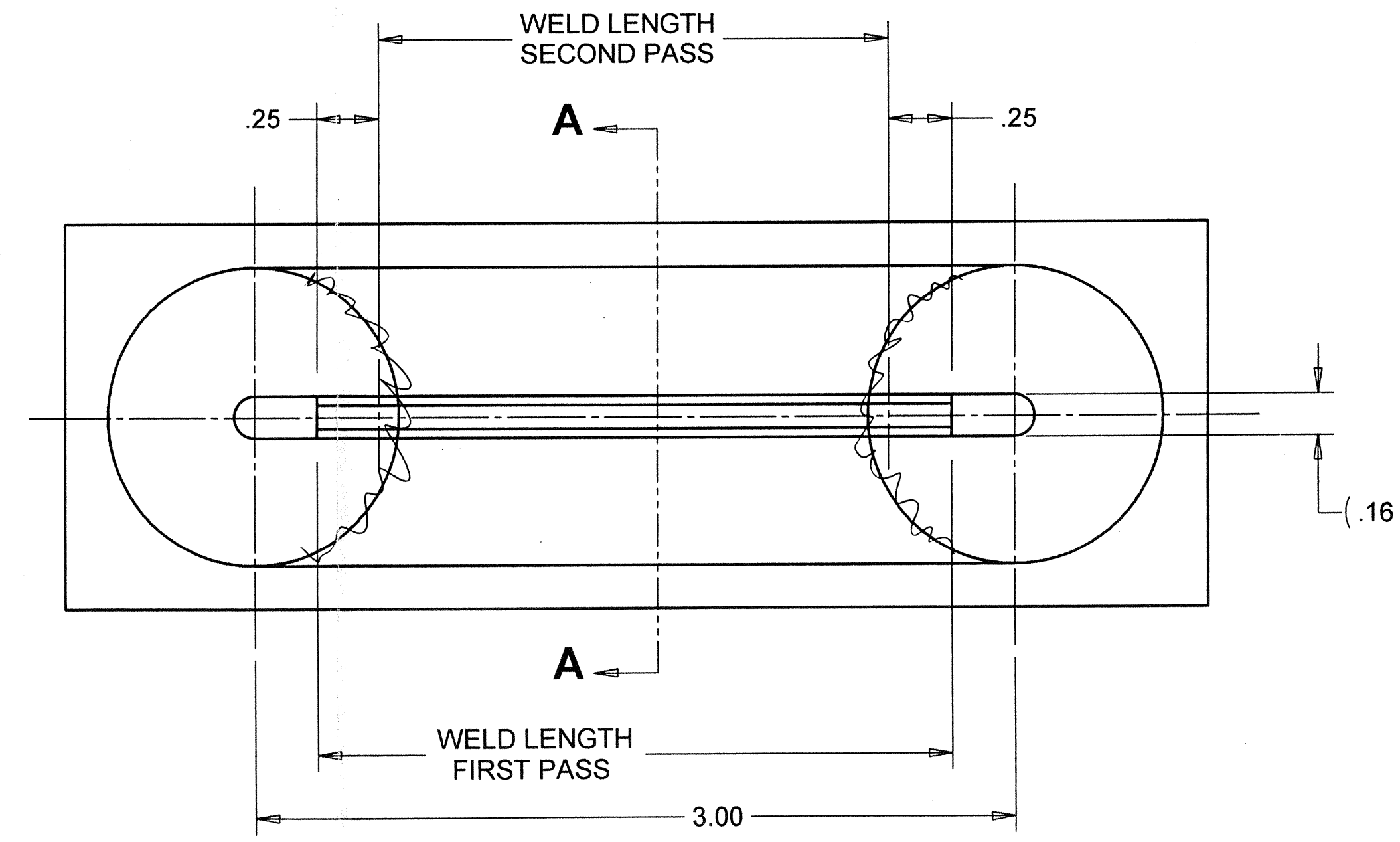
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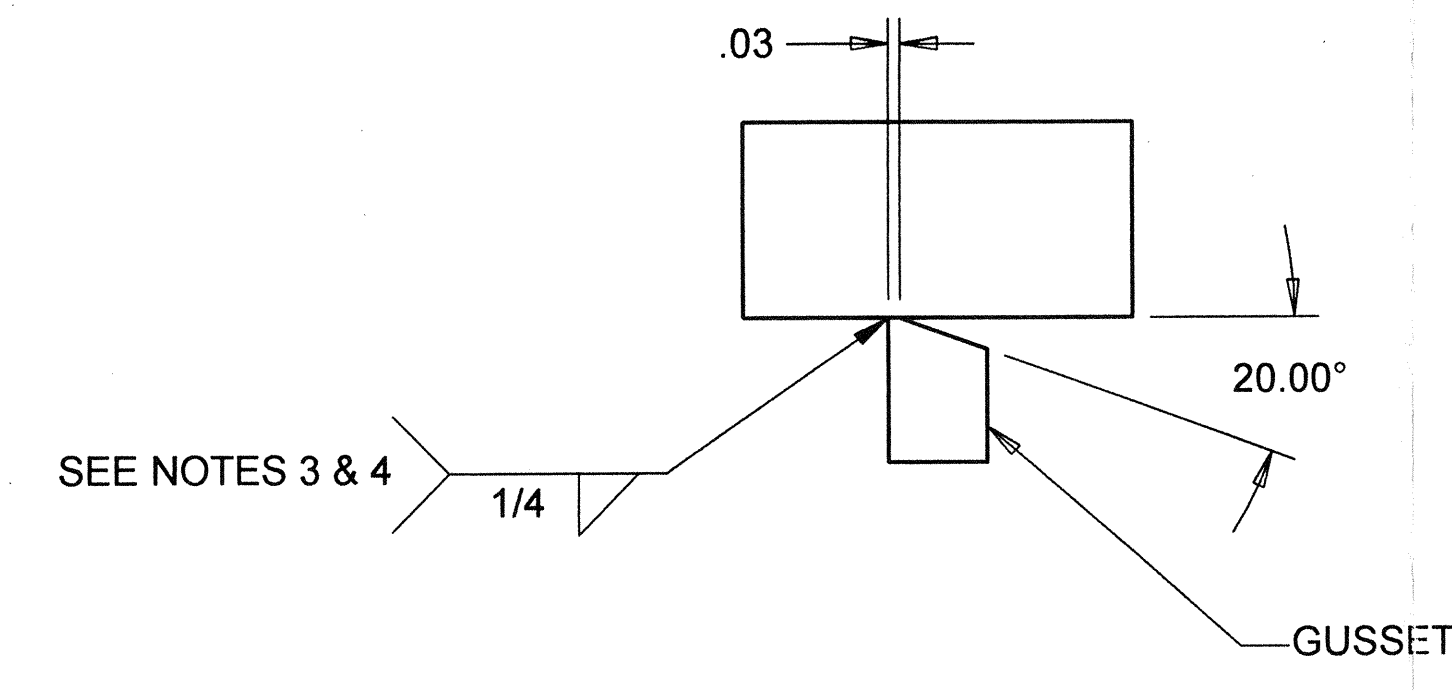
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REVISIONS			DATE	APPROVED
REV.	DESCRIPTION			



TYPICAL PLUG WELD



TYPICAL FILLET WELD

NOTES:

1. FIRST 2 PASSES FULL PENETRATION AUTOGENOUS WELD USING 100% ARGON SHIELD, DC, POLARITY OPTIONAL.
2. NEXT 2 PASSES TO BE AC WITH 4043 FILLER, SHIELD GAS MIXTURE OPTIONAL. DO NOT FILL GROOVE.
3. FIRST PASS FULL PENETRATION AUTOGENOUS DC STRAIGHT POLARITY WITH 100% Ar TO 50/50 Ar/He SHIELD & 100% ARGON BACK PURGE.
4. SECOND PASS AC WITH 4043 FILLER. SHIELD GAS MIXTURE OPTIONAL. STAY BACK FROM FIRST PASS BY .25".

PARTS LIST									
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING							
DECIMALS	ANGULAR = +/- .30°	<b>HYTEC, INC</b> TITLE <b>LIGO WELD PREP &amp; WELD PROCEDURE</b>							
XX = +/- .03	SURFACE FINISH = 250								
XXX = +/- .010		DESIGNED	ROGER L. SMITH	DATE	5-28-97	DWG. NO.		SIZE	SHEET NO.
FINISH		DRAWN	ROGER L. SMITH	5-28-97	D972202		D		1 of 1
PART NO.		CHECKED	HARRY SALAZAR	6-6-97	D972202		D		1 of 1
D972202-1		ENGR.	T. THOMPSON	7-10-97	SCALE 2/1				REVISION
		APPROVED	T. THOMPSON	7-10-97					

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