

Welding process:	parent metal 1:
Product type:	parent metal 2:
welding position:	base thickness:
Weld joint preparation:	Pipe diameter:
weld preparation	
Remarks	
Drawing No.	
Component 1	Component 2
Creation of the sweat connection	welding sequence

sequence of weld	welding process	Transfer modes	Welding filler Dimensions	welding current [A]	welding voltage [V]	arc Current / polarity	wire feed rate [m/min]	welding speed [cm/min] [mm/s]	heat input [kJ/mm]

Welding filler	further information
Norm name 1:	root gap (b):
Manufacturer's name 1:	depth of root face (c):
Norm name 2:	included angle ( $\alpha$ ): °
Manufacturer's name 2:	bevel angle ( $\beta$ ): °
Welding flux:	Radius (r): °
Manufacturer's name:	
shielding gas 1:	<b>Information welding with pressure</b>
gas flow rate 1:	Basic volts : V
shielding gas 2:	background current : A
gas flow rate 2:	Pulse tension : V
backing gas:	Pulse stream : A
gas flow rate:	Pulse frequency : Hz
tungsten elektrode 1:	<b>Heat treatment</b>
Diameter:	preheating temperature :
<b>redrying temperature</b>	Preheat time :
Temperature:	interpass temperature :
Time:	cooling rate :

Date	Signature welding coordinator	Date	Signature Examiner
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