

TITANIUM ARMOR WELDING DATA SHEET #1								Report Number					
WELDED ARMOR DATA								Sheet Number	of				
SUBMITTED BY													
TEST PLATE NUMBER													
DATE													
WPS NUMBER													
PLATE THICKNESS													
SPECIFICATION					AWS D1.9								
WELDED BY													
CONTRACT NUMBER													
<p>On a dimension sketch of the groove and weldment, indicate (1) the groove angle; (2) the root opening; (3) the root face; (4) the bead sequence; (5) additional sketch of spacer strip or back-up, if any; (6) width of masking, if any on edges of cast plate; and (7) average height of weld reinforcement.</p>													
<p>Weld reinforcement has <input type="checkbox"/> has not <input type="checkbox"/> been removed.</p>													
WELDING DATA													
PLATE PREPARATION													
POSITION OF WELDING: FLAT – HORIZONTAL – VERTICAL – OVERHEAD													
								POLARITY: DCEN – DCEP – PULSE					
								POSTHEAT (°F)					
PEENING						AUTOMATIC		MECHANIZED		SEMIAUTOMATIC		MANUAL	
PASS NO.	WELDING PROCESS	ELECTRODE		PASS TYPE <sup>a</sup>	AVG AMPS	AVG VOLTS	TRAVEL SPEED	WFS IPM	TEMPERATURE				
		SIZE	TYPE						PREHEAT °F	INTERPASS °F			
1													
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													
16													

<sup>a</sup>S = Stringer pass W = Weave pass

**Figure A.6—Welded Armor Data (Sheet 1) (see A4.5.1)**