



W E L D I N G				R E C I P E			
1. MATERIAL				5. MATERIAL			
1.1	GRADE	:-	S.S. TYPE 304 (1.4301)	5.1	GRADE	:-	S.S. TYPE 304 (1.4301)
1.2	SIZE	:-	102.5 ϕ x 6	5.2	SIZE	:-	102.5 ϕ x 6
2. LINE SPEED				6. LINE SPEED			
360 mm/MIN				360 mm/MIN.			
3. PLASMA TORCH				7. T.I.G. TORCH			
3.1	LOCATION	:-	65 mm BEFORE WELD JOINT	7.1	LOCATION	:-	MID POINT BETWEEN 2 - 3 WELD JOINTS
3.2	POSITION	:-	VERTICAL	7.2	POSITION	:-	VERTICAL
3.3	ELECTRODE DIA.	:-	6 mm	7.3	ELECTRODE HEIGHT	:-	6 mm
3.4	ELECTRODE REF.	:-	8 - 6549	7.4	ELECTRODE DIA.	:-	3.2
3.5	ELECTRODE POSITION	:-	6 mm ABOVE MAT.	7.5	NOZZLE DIA.	:-	
3.6	NOZZLE REF.	:-	8 - 6540				
4. WELDING PARAMETERS.				8. WELDING PARAMETERS			
4.1	WELDING MC MODE	:-	5.2 (TWO STEP)	8.1	WELDING MC MODE	:-	5.2 (TWO STEP)
4.2	INITIAL WELDING CURRENT	:-	25%	8.2	INITIAL WELDING CURRENT	:-	25%
4.3	UPSLOPE TIME	:-	3 SECS	8.3	UPSLOPE TIME	:-	5 SECS
4.4	MAIN WELDING CURRENT	:-	294/305 A.	8.4	MAIN WELDING CURRENT	:-	210 AMP.
4.5	DOWN SLOPE TIME	:-	MINIMUM	8.5	DOWN SLOPE TIME	:-	MINIMUM
4.6	PLASMA STREAM GAS	:-	ARGON	8.6	SHIELD GAS	:-	ARGON/H ₂ (5%)
4.7	PLASMA STREAM VOLUME	:-	3.75 LPM/MIN	8.7	SHIELD GAS VOLUME	:-	12 LPM/MIN
4.8	SHIELD GAS	:-	ARGON/H ₂ (5%)	8.8	POST WELD GAS SETTING	:-	20 SECS
4.9	SHIELD GAS VOLUME	:-	14 LPM/MIN	8.9	PIPE I.D. PURGE GAS	:-	
4.10	POST WELD GAS SETTING	:-	20 SECS.	8.10	PIPE I.D. PURGE GAS VOLUME	:-	(IF REQUIRED) 15/20 LPM/MIN
4.11	PIPE I.D. PURGE GAS	:-	ARGON				
4.12	PIPE I.D. PURGE GAS VOLUME	:-	15/20 LPM/MIN (IF REQUIRED)				