

**Standard Welding Procedure
Specification (SWPS) for**

**Gas Metal Arc Welding
(Short Circuiting
Transfer Mode) of
Galvanized Steel (M-1),
18 through 10 Gauge,
in the As-Welded
Condition, with or
without Backing**

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An American National Standard

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Prepared by the
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This standard contains the essential welding variables for welding galvanized steel in the thickness range of 18 through 10 gauge, using semiautomatic gas metal arc welding (short circuiting transfer mode). It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for groove welds and fillet welds.



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