

AASHTO/AWS D1.5 QUALIFICATION

ANNEX L

WELDING PROCEDURE SPECIFICATION (WPS)
 PREQUALIFIED QUALIFIED BY TESTING
 or PROCEDURE QUALIFICATION RECORDS (PQR) Yes
 AASHTO/AWS D1.5 Qualification Type 5.12.1 - 5.12.2 - 5.13

Contractor
 Organization CCS Constructors
 Welding Process(es) GMAW-P
 Type: Manual Semiautomatic
 Machine Automatic
 Tandem Parallel

Identification CCS-WPS-GMAWP
 Revision 1st Date 1/13/2010 BER
 Authorized by Tim Prevost Date 1/13/2010
 Supporting PQR No.(s) CCS-PQR-GMAWP

JOINT DESIGN USED
 Single Double Weld
 Backing: Yes No Material A36
 Root Opening 5/8 Root Face Dimension _____
 Groove Angle 20 Radius (J-U) _____
 Backgouging: Yes No Method _____
 Root Treatment _____

POSITION
 Position of Groove 3G Fillet _____
 Vertical Progression: Up Down
 ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW): Globular Spray
 Current: AC DCEP DCEN Pulsed
 Electrical Stick Out 3/8
 Other _____

BASE METALS
 Material Spec. A572
 Type or Grade 50
 Thickness: Groove 1" Fillet _____
 Diameter (Pipe) _____

TECHNIQUE
 Stringer or Weave Bead Stringer
 Multi-pass or Single Pass (per side) Multi
 Number of Electrodes one
 Electrode Spacing: Longitudinal _____
 Lateral _____ Angle _____
 Interpass Cleaning Chip & Wire Brush

FILLER METALS
 AWS Specification A5.28
 AWS Classification ER80S-NiL
 Manufacturer Trade Name Lincoln

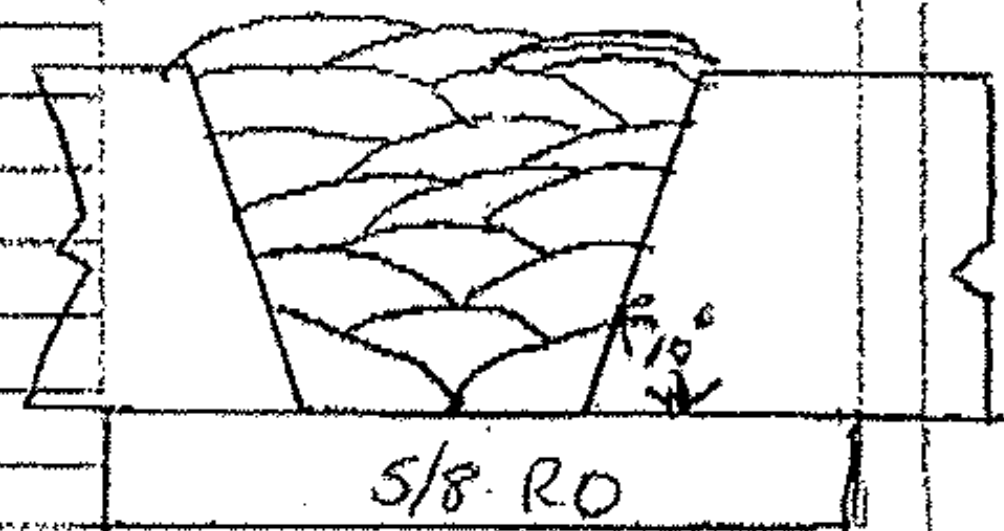
PREHEAT
 Preheat Temp., Min. 70
 Interpass Temp., Min. 70
 Interpass Temp., Max. 400F

SHIELDING
 Flux _____ Mfg. Trade Name _____
 Electrode Flux (Class) _____
 Gas Composition 84%Ar 16%CO2
 Flow Rate 40CFH Gas Cup Size 5/8

POSTWELD HEAT TREATMENT
 Temp. N/A Hold Time N/A
 Heating/Cooling Rate _____
 HEAT INPUT
 Calculated Heat Input Value: kJ/in kJ/mm
 Max. Heat Input _____ Min. Heat Input _____

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals Diam.	Current		Volts	Travel Speed	Joint Details
			Type & Polarity	Amps or Wire Feed Speed			
1-5	GMAW	045	DCEP	111-115a	21-22	3.5 to 7IPM	20°
5-17	GMAW	045	DCEP	110-130	21-23		



Form L-2—Sample Welding Procedure Specification

ad
2/26/10