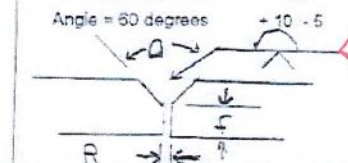


Welding Procedure Specification (WPS) Yes ( X )  
 PREQUALIFIED QUALIFIED BY TESTING  X   
 or PROCEDURE QUALIFICATION RECORD (PQR) YES ( )

Company Name A.S.C. Enterprises, Inc. Identification # ARC WPS #46  
 Welding Process(es) SAW Revision 1 Date 5/12/13 By SVH  
 Supporting PQR No.(s) ARC PQR #46 Authorized By STEVE HOWARD Date 5/12/13  
 Type - Manual ( ) Semi-Automatic ( ) Machine ( ) Automatic X

<b>JOINT DESIGN USED</b> Type <u>B-2c-S</u> Single ( ) Double Weld ( X ) Beading ( ) Backing Material ( X ) Root Opening <u>0"</u> Root Face Dimension <u>1/16" min</u> Groove Angle <u>60 degrees</u> Radius ( R ) Root Beveling ( YES ) Method <u>225°</u>		<b>POSITION</b> Position of Groove <u>1G</u> Fillet ( ) Vertical Progression ( )	
<b>BASE METALS</b> Material Spec <u>A705</u> Type or Grade <u>50W HRB50W</u> Thickness <u>1/2"</u> Groove ( ) Fillet ( ) Diameter ( Pipe )		<b>ELECTRICAL CHARACTERISTICS</b> Transfer Mode (FCW) Short Circuiting ( ) Globular ( ) Spray (X) Current: AC ( ) DCEP (X) DCEN ( ) Pulsed ( ) OTHER:	
<b>FILLER METALS</b> Lincoln LA-75 AWS Specification <u>A5.23</u> AWS Classification <u>ENiK-A1-H8</u>		<b>TECHNIQUE</b> Stringer or Weave Bead <u>STRINGER</u> Multi-pass or Single Pass (per side) <u>MULTI</u> Number of Electrodes <u>ONE</u> Electrode Spacing Longitudinal ( ) Lateral ( ) Angle ( )	
<b>SHIELDING</b> Flux <u>90 Lincoln</u> Gas <u>None</u> Electrode + Flux (Class) <u>ENiK-A1-H8</u> Composition <u>None</u> Flow Rate <u>None</u> Gas Cup Size <u>None</u>		Contact Tube to Work Distance <u>1 1/16" setback +/- 1/16"</u> Preheating <u>None</u> Interpass Cleaning: <u>Hand or Power tool</u>	
Preheat <u>0/4" = 50 degrees 3/4" - 1 1/2" = 70 degrees</u> <u>1 1/2" - 2 1/2" = 100 degrees Over 2 1/2" = 225 degrees F</u>		<b>POSTWELD HEAT TREATMENT</b> Temp	

Pass or Weld Layer(s)	S	Filler Metals				Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed	Volts	Travel Speed			
	SAW	ENiK	3/32"	DCEP	350-450	20-22	14-18.2 ipm			<b>B-2c-S</b> Root = 0" Face = > 1/2" - 1" = 1/4" > 1 - 1 1/2" = 3/8" > 1 1/2" - 2" = 1/2" > 2 - 2 1/2" = 1/2" Angle = 60 degrees ± 10 ± 5 

✓ Trans Received OK'd BY JWC

JAN 01 2013

Resubmit APPROVED BY AS DATE 1/30/13