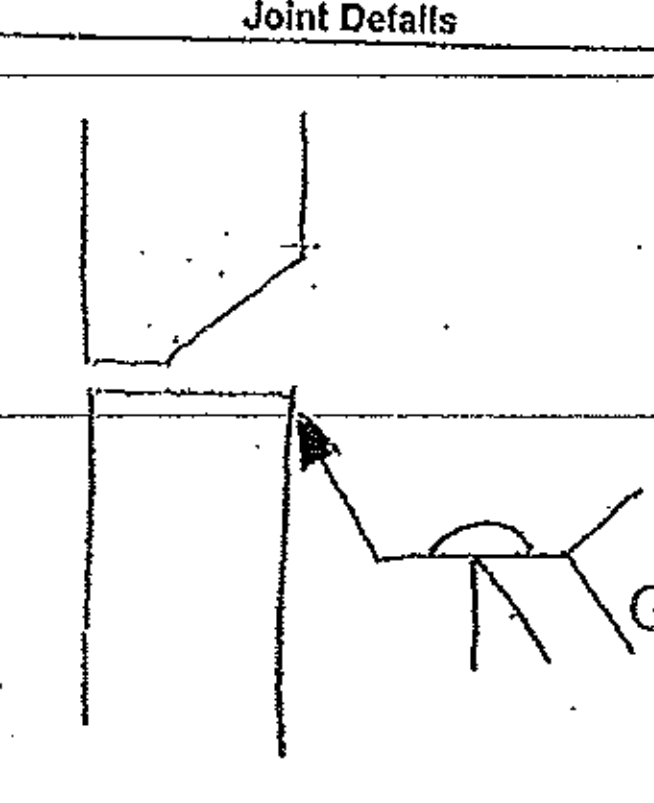


WELDING PROCEDURE SPECIFICATION (WPS) YES (X)
 PREQUALIFIED X QUALIFIED BY TESTING _____
 or PROCEDURE QUALIFICATION RECORD (PQR) YES ()

Company Name ARC Ent. Inc. Identification # ARC WPS 7M2
 Welding Process(es) GMAW Revision 5 Date 8/3/2012 By SVH
 Supporting PQR No.(s) _____ Authorized by STEVE HOWARD Date 8/3/2012
 Type - Manual Semi - Automatic
 Machine Automatic

D 1.1

JOINT DESIGN USED Type <u>B-U4b-GF</u> Single <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/> Backing <input type="checkbox"/> NO Backing Material _____ Root Opening <u>0 - 1/8"</u> Root Face Dimension <u>0 - 1/8"</u> Groove Angle <u>45 Degrees</u> Radius (J-U) _____ Back Gouging Method _____		POSITION Position of Groove <u>1G 2G</u> Fillet _____ Vertical Progression <input type="checkbox"/>	
BASE METALS Material Spec <u>A709 A500</u> Type or Grade <u>36 50</u> Thickness _____ Groove U _____ Fillet _____ Diameter (Pipe) _____		ELECTRICAL CHARACTERISTICS Transfer Mode (FCAW) _____ Short Circuiting <input type="checkbox"/> Globular <input type="checkbox"/> Spray <input checked="" type="checkbox"/> Current: AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/> OTHER: _____	
FILLER METALS Lincoln L-56 AWS Specification <u>A5.18</u> AWS Classification <u>ER70S-6</u>		TECHNIQUE 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 _____	
SHIELDING Flux _____ Gas <u>AR-2</u> Composition <u>argon 98 oxygen 2</u> Electrode - Flux (Glass) _____ Flow Rate <u>25 - 40</u> Gas Cup Size <u>5/8</u>		Contact Tube to Work Distance <u>5/8 - 3/4"</u> Peening _____ Interpass Cleaning: <u>brush or grind</u>	
		POSTWELD HEAT TREATMENT Temp _____ Time _____	

WELDING PROCEDURE								
Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
1-3		ER70S-6	.035"	DCEP	180-220	25-27	6-7 ipm	 BACK GOUGE
Vermont Agency of Transportation RECEIVED OK'D BY J. CLARK OK'D BY _____ 08/21/2012 RESUBMIT APPROVED AS NOTED BY C. CARLSON DATE 08/29/2012								