

WELDING PROCEDURE SPECIFICATION (WPS) Yes
PREQUALIFIED _____ QUALIFIED BY TESTING _____
or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

Company Name Miller Construction, Inc.
 Welding Process(es) SMAW
 Supporting PQR No.(s) N/A

Identification # 1
 Revision 0 Date 4/19/13 By J. Ouelette
 Authorized by E. Murphy Date 4/19/13
 Type—Manual Semiautomatic
 Mechanized Automatic

JOINT DESIGN USED

Type:
 Single Double Weld
 Backing: Yes No
 Backing Material:
 Root Opening _____ Root Face Dimension _____
 Groove Angle: 45 Radius (J-U) _____
 Back Gouging: Yes No Method _____

POSITION
 Position of Groove: 2G Fillet: 1,2,3,4F
 Vertical Progression: Up Down

BASE METALS

Material Spec. HP 12 X 84
 Type or Grade GR 50
 Thickness: Groove 0.68 Fillet 0.75
 Diameter (Pipe) _____

ELECTRICAL CHARACTERISTICS

E7018
 Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Power Source: CC CV
 Other _____
 Tungsten Electrode (GTAW)
 Size: N/A
 Type: _____

FILLER METALS

AWS Specification A5.5
 AWS Classification E7018

TECHNIQUE

Stringer or Weave Bead: Stringer
 Multi-pass or Single Pass (per side) MULTI-PASS
 Number of Electrodes _____
 Electrode Spacing Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening _____
 Interpass Cleaning: _____

SHIELDING

Flux X Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

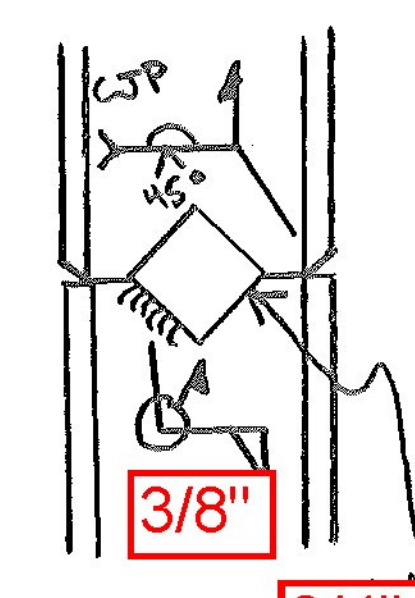
PREHEAT

Preheat Temp., Min. 70 F
 Interpass Temp., Min. N/A Max. N/A

POSTWELD HEAT TREATMENT

Temp. N/A
 Time _____

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			
3 Layers	SMAW	E7018	1/8	DC	132	22/26	As Req.	

Vermont Agency of Transportation
RECEIVED

CK'D BY JWC OK'D BY JTS

April 19, 2013

RESUBMIT NO Approved AsNoted
 BY KMH DATE 04/23/13