

CK'D BY TYLin, R. Foster OK'D BY TYLin, R. Foster

April 7, 2017

WELDING PROCEDURE SPECIFICATION (WPS)

AWS D1.5 Bridge Welding Code

RESUBMIT No Approved
BY Kristin Higgins DATE 4/11/2017

WPS No.: CPM-SM-Fillet/ Bridge Deck Forming

T.Y. LIN INTERNATIONAL

THE STAMPED DOCUMENTS ARE HEREBY:

- APPROVED
- APPROVED AS NOTED
- REVISE AND RESUBMIT

SEE TRANSMITTAL FOR ADDITIONAL INFORMATION AS APPLICABLE.

THIS REVIEW IS FOR GENERAL CONFORMANCE WITH DESIGN CONCEPT ONLY. ANY DEVIATION FROM THE PLANS OR SPECIFICATIONS NOT CLEARLY NOTED BY THE CONTRACTOR HAS NOT BEEN REVIEWED. REVIEW BY THE ENGINEER SHALL NOT RELIEVE THE CONTRACTOR OF THE CONTRACTUAL RESPONSIBILITY FOR ANY ERRORS OR DEVIATION FROM THE CONTRACT REQUIREMENTS.

JOSH OLUND
REVIEWER

April 11, 2017
DATE

Electrical Characteristics

Current: Direct Current (DCEP)

Polarity: Reverse

Pass or Weld Layers	Filler Metals		Current		
	Classification	Diameter	Type & Polarity	Amperage*	Voltage**
All	E7018 Lincoln Excalibur 7018 MR	3/32"	DCEP <i>Reverse Polarity</i>	Range 70 - 110	N/A
		1/8"		Range 90 - 160	
		5/32"		Range 130 - 210	

* **Note 1:** refer to the range of recommended operation by the filler metal manufacturer

** **Note 2:** Voltage is controlled by arc length and not considered a controllable variable

Technique

Stringer or Weave Bead: Stringer beads

Multi-pass or Single Pass (per side): Single or Multi-pass Number of Electrodes: Single

Peening: Not allowed

Pre Weld Cleaning: Paint shall be removed only from the top of top flange of the girders and only around the areas to be welded.

Interpass Cleaning: Before welding over previously deposited weld metal, all slag shall be removed and the weld and adjacent base metal shall be cleaned by brushing or other suitable means.

Post Weld Cleaning: When welding is completed and adequately cooled, all welds and adjacent surfaces shall be touched up with appropriate coatings.