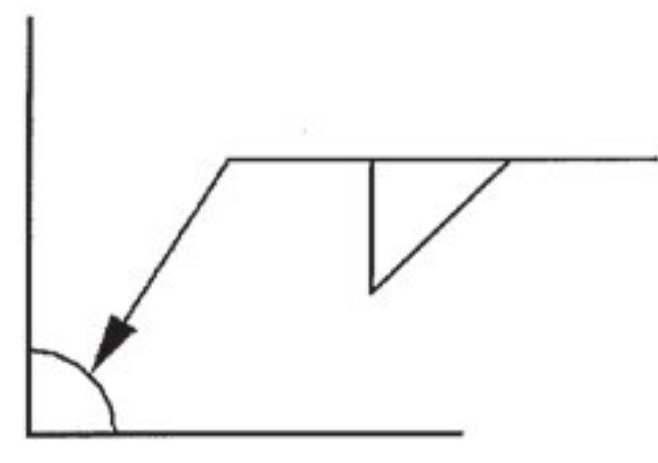


WELDING PROCEDURE SPECIFICATION (WPS) YES ( x )  
 PREQUALIFIED \_\_\_\_\_ QUALIFIED BY TESTING \_\_\_\_\_  
 or PROCEDURE QUALIFICATION RECORD (PQR) YES ( x )

Company Name ARC Ent. Inc. Identification # ARC WPS 5T  
 Welding Process(es) GMAW Revision 4 Date 1/12/2017 By SVH  
 Supporting PQR No.(s) ARC PQR 5M3-2 Authorized by STEVE HOWARD Date 1/12/2017  
 Type - Manual  Semi - Automatic   
 Machine  Automatic

<b>JOINT DESIGN USED</b> Type <u>FILLET</u> Single <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/> Backing <input type="checkbox"/> NO Backing Material <u>N/A</u> Root Opening <u>0</u> Root Face Dimension _____ Groove Angle _____ Radius ( J-U ) _____ Back Gouging _____ Method _____	<b>POSITION</b> Position of Groove _____ Fillet <u>1F 2F 3F 4F</u> Vertical Progression <input type="checkbox"/>
<b>BASE METALS</b> Material Spec <u>A709</u> Type or Grade <u>36 50 50W HPS50W</u> Thickness _____ Groove _____ Fillet <u>U</u> Diameter ( Pipe ) _____	<b>ELECTRICAL CHARACTERISTICS</b> 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 : _____
<b>FILLER METALS</b> _____ Lincoln L-56 AWS Specification <u>A5.18</u> AWS Classification <u>ER70S-6</u>	<b>TECHNIQUE</b> Stringer or Weave Bead <u>tack</u> Multi-pass or Single Pass (per side) <u>single</u> Number of Electrodes <u>one</u> Electrode Spacing _____ Longitudinal _____ Lateral _____ Angle _____
<b>SHIELDING</b> Flux _____ Gas <u>98/2</u> Composition <u>98 argon 2 oxygen</u> Electrode - Flux (Class) _____ Flow Rate <u>36-50 cfh</u> Gas Cup Size <u>5/8"</u>	Contact Tube to Work Distance <u>5/8" - 3/4"</u> Peening _____ Interpass Cleaning : _____
Preheat up to 3/4" - 50 degrees F 3/4" - 1 1/2" - 70 degrees F 1 1/2" - 2 1/2" - 150 degrees F over 2 1/2" - 225 degrees F	<b>POSTWELD HEAT TREATMENT</b> 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	3/16"	ER70S-6	.035"	DCEP	230-250	26-28	1" TACK	

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY RGF, TAM OK'D BY JDG  
 February 9, 2017  
 RESUBMIT No Approved  
 BY Kristin Higgins DATE 2/14/2017