

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

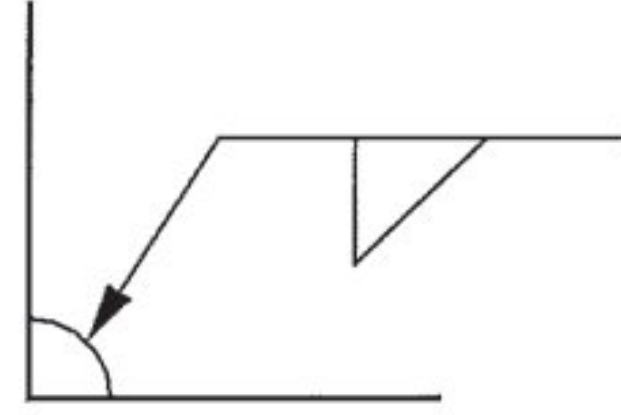
Company Name ARC Ent. Inc.
 Welding Process(es) SAW
 Supporting PQR No.(s) ARC PQR # 45a

Identification # ARC WPS 45a
 Revision 7 Date 1/10/2017 By SVH
 Authorized by STEVE HOWARD Date 1/10/2017
 Type - Manual Semi - Automatic
 Machine Automatic

DART Welder

JOINT DESIGN USED Type <u>FILLET</u> Single <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/> Backing <input type="checkbox"/> NO Backing Material _____ Root Opening <u>0</u> Root Face Dimension _____ Groove Angle <u>NA</u> Radius (J-U) _____ Back Gouging _____ Method _____	POSITION Position of Groove _____ Fillet <u>1F 2F</u> Vertical Progression <input type="checkbox"/>
BASE METALS Material Spec <u>A709</u> Type or Grade <u>50 50W HPS50W</u> Thickness _____ Groove _____ Fillet <u>U</u> 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 _____ DCEN <input checked="" type="checkbox"/> Pulsed <input type="checkbox"/> OTHER : _____
FILLER METALS AWS Specification <u>A5.23 Lincoln LA-75</u> AWS Classification <u>ENI1K-Ni1-H8</u>	TECHNIQUE Stringer or Weave Bead <u>STRINGER</u> Multi-pass or Single Pass (per side) <u>SINGLE</u> Number of Electrodes _____ Electrode Spacing _____ Longitudinal _____ Lateral _____ Angle _____
SHIELDING Flux <u>960</u> Gas _____ Electrode - Flux (Class) _____ Composition _____ <u>F8A2-ENI1K-Ni1-H8</u> Flow Rate _____ Gas Cup Size _____	Contact Tube to Work Distance <u>1 1/4" Stickout +/- 1/4"</u> Peening _____ Interpass Cleaning : _____
Preheat up to 3/4" = 50 degrees 3/4" - 1 1/2" = 70 degrees 1 1/2" - 2 1/2" = 150 degrees Over 2 1/2" = 225 degrees F.	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	SAW 5/16"	ENI1K	3/32"	DCEN	380-420	29-31	14.5-15.4 ipm	

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