

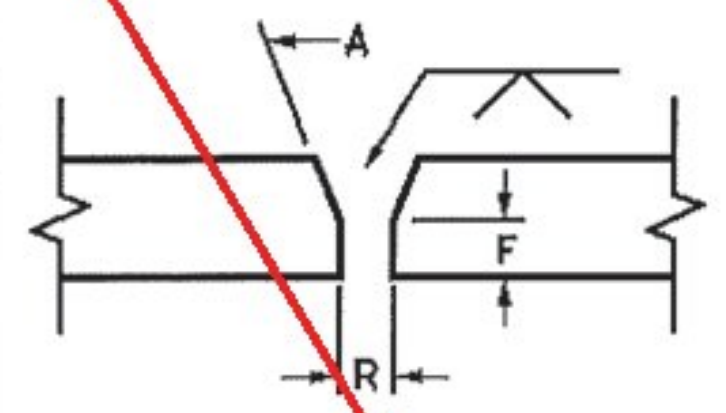
WELDING PROCEDURE SPECIFICATION (WPS) YES ( X )  
 PREQUALIFIED \_\_\_\_\_ QUALIFIED BY TESTING \_\_\_\_\_  
 or PROCEDURE QUALIFICATION RECORD (PQR) YES ( x )

Company Name ARC Ent. Inc.  
 Welding Process(es) SAW  
 Supporting PQR No.(s) PQR # 52

Identification # ARC WPS # 52  
 Revision 6 Date 1/10/2017 By SVH  
 Authorized by STEVE HOWARD Date 1/10/2017  
 Type - Manual  Semi - Automatic   
 Machine  Automatic

<b>JOINT DESIGN USED</b> Type <u>B - L2c - S</u> Single <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/> Backing Yes <input type="checkbox"/> NO <input type="checkbox"/> Backing Material _____ Root Opening <u>0 - 1/16"</u> Root Face Dimension _____ Groove Angle <u>60 degrees</u> Radius ( J-U ) _____ Back Gouging <input checked="" type="checkbox"/> Method _____		<b>POSITION</b> Position of Groove <u>1G</u> Fillet _____ Vertical Progression <input type="checkbox"/>	
<b>FILLER METALS</b> <u>Lincoln LA-85</u> AWS Specification <u>A 5.23</u> AWS Classification <u>ENi5</u>		<b>ELECTRICAL CHARACTERISTICS</b> Transfer Mode (FCAW) <u>Short Circuiting</u> <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>SHIELDING</b> Flux <u>MIL800-HPNi</u> Gas _____ Composition _____ Electrode - Flux (Class) <u>F8A8-ENi5-Ni5-H2</u> Flow Rate _____ Gas Cup Size _____		<b>TECHNIQUE</b> 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 <u>Longitudinal</u> _____ Lateral _____ Angle _____ Contact Tube to Work Distance <u>1" stickout +/- 1/4"</u> Peening _____ Interpass Cleaning : <u>hand or power tools</u>	
Preheat <u>3/4" = 50 degrees F</u> <u>3/4 to 1 1/2" = 125 degrees F</u> <u>1 1/2 to 2 1/2" = 175 degrees F</u> over <u>2 1/2" = 225 degrees F</u>		<b>POSTWELD HEAT TREATMENT</b> Temp _____ Time _____	

This isn't the latest version of this WPS, but this is not used on this project anyway. No need to re-submit

Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
	SAW	ENi5	3/32"	DCEP	360 - 410	28 - 31	14 - 15.1	

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY RSF, TAM OK'D BY JDG  
 February 9, 2017  
 RESUBMIT No  Rejected   
 BY Kristin Higgins DATE 2/14/17