

WELDING PROCEDURE SPECIFICATION (WPS)
PREQUALIFIED _____ QUALIFIED BY TEST _____ YES _____

Company Name Merrimack Sheet Metal Identification # LA-5
 Welding Process(es) GMAW Revision NA Date N/A By N/A
 Supporting PQR # (s) LA-1/2016 Authorized Michael J. Smith Date 5/10/2016

Type- Manual Semi-Auto
 Machine Automatic

JOINT DESIGN USED
 Single Double Weld
 Backing Yes / No NO
 Backing Material NO
 Root Opening and Face Dimension N/A
 Groove Angle, U or J N/A
 Back Gouge Y/N/Type NO

POSITION
 Position of Groove N/A Fillet Flat & Horizontal
 Vertical Progression, up N/A Down _____

BASE METALS
 Base Metal A36:A588:A709
 Type or Grade B
 Thickness: Groove N/A
 Fillet Unlimited
 Pipe Diameter N/A

ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW): _____
 Short-Circuiting / Globular / Spray SPRAY
 Current AC, DCEP, DCEN, Pulsed DCEP
 Other none
 Tungsten Electrode (GTAW): _____
 Size N/A
 Type N/A

FILLER METALS
 A.W.S. Specification A5.28
 A.W.S. Classification ER80S-NI1
 Trade Name Lincoln Superarc LA-75

TECHNIQUE
 Stringer or Weave Bead Stringer
 Multi or Single Pass (per side) Multi Pass
 Number of Electrodes ONE
 Electrode Spacing: Longitudinal N/A
 Lateral N/A
 Angle 15 degree push angle

SHIELDING
 Flux N/A Gas Ar/Co2
 Electrode-flux Class Composition 90AR 10Co2
 NA Flow Rate 35-40 CFH
 Gas Cup Size 1/2 inch

Contact Tube to Work Distance 1/2" TO 3/4" ESO
 Peening none
 Interpass Cleaning none

PREHEAT
 Preheat Temp., Min. 70 deg. F
 Interpass Temp. Min. 100 deg. F
 Interpass Temp. Max. 350 deg. F

POSTWELD HEAT TREATMENT
 Temp. none
 Time N/A
 Heat Input Max KJ/in 37.8 Heat Input Min KJ/in 26

WELDING PROCEDURE

Pass or Weld Layer Layer(s)	Process	FILLER METALS		CURRENT			Travel Speed	JOINT DETAIL
		Class	Diam.	Type & Polarity	Amps or WFS	Volts		
ALL	GMAW	ER80S-NI1	.045 dia	DCEP	250-270	27-28	13-15 IPM	SINGLE SIDED FILLET 