

WELDING PROCEDURE SPECIFICATION (WPS)

Company Name Cosmec, Inc. By M. Aucisallo
 Welding Procedure Specification No. GTAW F1 Rev. 4 Date 5/18/95
 Supporting Procedure Qualification Test Record(s) No. 100 MJA
 Welding Process(es) GTAW Type Manual
 (Automatic, manual, etc.)
 Mode of Transfer for GMAW _____
 (short circuiting, spray, etc.)

JOINTS (Table 8.1)
 Type of Welded Joint(s) LAP COATING(S):
 Type N/A
 Backing (Yes) _____ (No) X Thickness N/A
 Backing Material Type _____
 Groove Welded From: Sketch of Joints
 one side _____ both sides _____ CKD BY CKD BY KBM

BASE METAL (1.2)
 Material specification type and grade: JAN 17 1996
 Sheet steel ASTM A588: A572 G=50; A36
 Support steel ASTM A588: A572 G=50; A36
 Thickness Range: _____
 Sheet Steel 1/8" to 1/4"
 Support Steel ASTM A588: A572 G=50; A36
 Thickness Unlimited
 Base Metal Preparation None

RESUBMITTED APPROVED
 BY JTA DATE 1-24-96

* FILLER METAL (Table 5.1):
 Specification AWS 5.9
 Classification ER 309

POSITIONS (Table 1.1) _____ PREHEAT (1.1.1 and 4.1.3):
 Position of Groove _____ Preheat Temperature Min 50°
 Position of Fillet Flat & HORIZONTAL Preheat Temperature Max 150° for max 1/4"
 Progression L to R

GAS (6.6)
 Shielding Gas Argon Flow Rate 45 CFH
 Percent Mixture 100%

FLUX (6.6) _____

Pass No.	Electrode Size	Welding Current (20°C)		Travel Speed	Welding Rate	Wire Feed Speed
		Amperes	Volts			
1	1/16" dia	70-100	24-26	10"-12"/min		

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in AWS/AWS D1.3 (1991), Structural Welding Code - Steel, Part 1.
 Authorized by Michael J. Aucisallo Date 5/18/95

* USE ONLY WHEN REQUIRED