

For Steve:-

VTRANS RECEIVED
 OK'D BY _____ OK'D BY JWC
 JAN 20 2010
 RESUBMIT _____ APPROVED
 BY _____ DATE 01/29/10

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

Company Name ARC ENTERPRISES, INC.
 Welding Process(es) GMAW
 Supporting PQR No.(s) _____

Identification # ARC WPS 19
 Revision _____ Date _____ By _____
 Authorized by STEVE HOWARD Date 3/22/08
 Type - Manual _____ Semi-Automatic (X)
 Machine () Automatic ()

JOINT DESIGN USED		POSITION	
Type <u>B-U3-GF</u>	Position of Groove <u>1G</u>	Position of Groove <u>1G</u>	Position of Groove <u>1G</u>
Single Beveling YES ()	Double Weld (X)	Vertical Progression UP ()	Vertical Progression DOWN ()
Backing Material _____	Root Opening <u>0-1/8</u>	ELECTRICAL CHARACTERISTICS	
Root Face Dimension <u>0-1/8</u>	Groove Angle <u>60 (+10, -5)</u>	Transfer Mode (FCAM) _____	Short Circuiting ()
Back Gauging YES (X)	Radius (R) _____	Globular ()	Spray (X)
	Method _____	Current: AC ()	DCEP (X)
		Pulsed ()	DCEN ()
GASE METALS		OTHER: _____	
Material Spec <u>A709 A572</u>	TECHNIQUE		
Type or Grade <u>50</u>	Stringer or Weave Bead <u>Stringer</u>	Multi-pass or Single Pass (per side) <u>Multi</u>	
Thickness _____	Number of Electrodes <u>1</u>	Electrode Spacing _____	
Diameter _____	Electrode Spacing _____	Longitudinal _____	
		Lateral _____	
		Angle _____	
FILLER METALS		SHIELDING	
AWS Specification <u>A5.18</u>	Gas <u>88%Argon 2%O</u>	Flux _____	
AWS Classification <u>ER70S-7 ESAB 87 HP</u>	Composition _____	Electrode - Flux (Class) _____	
	Flow Rate <u>25-40 CFH</u>	Gas Cup Size <u>5/8</u>	
	Gas Cup Size <u>5/8</u>	Contact Tube to Work Distance <u>3/8-3/4</u>	
		Peening _____	
		Interpass Cleaning: <u>RECEIVED</u>	
		POSTWELD HEAT TREATMENT	
		Temp _____	
		Time _____	

Non-Structural Applications

Pass or Weld Layer(s)	WELD size	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
4	1/2"	ER70S-7	0.035	DCEP	180-220	26-27	7-11 ipm	

STATE OF MAINE
 DEPARTMENT OF TRANSPORTATION
 REVIEWED
 REVIEWED WITH COMMENTS
 REJECTED
 RETURNED FOR CORRECTIONS
 MAR 03 2008

ATTN: Bill Doukas

THIS DOCUMENT WAS REVIEWED IN ACCORDANCE WITH STATE OF MAINE SPECIFICATIONS SECTION 104.7 WELDING DRAWINGS
 William B. Doukas, P.E.