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AASHTO/AWS D1.1

WELDING PROCEDURE SPECIFICATION (WPS)

Project No. FEGC F 026-1(34) C/2 County Barre Date 8/22/11
 Material specification API-5L-X52, ASTM-A252, Gr. 3 or ASTM-A500, Gr. B (Mod. to 52 k.s.i.)
 Welding process GMAW
 Manual or machine Machine Semi-automatic
 Position of welding Flat, Horizontal
 Filler metal specification AWS A5.18
 Filler metal classification ER 70S-6
 Flux N/A Manufacturer Lincoln Trade name SuperArc L56 Term. qual. date 11/12/10
 Shielding gas 98% argon, 2% oxygen Flow rate 40 CFH Dew point -65° F
 Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current D.C.
 Polarity Reverse
 Welding progression N.A.
 Root treatment Machine cleaned
 Preheat and interpass temperature 50° F
 Post heat temperature N/A
 Angle of electrode Varies
 Electrode stickout 1" ($\pm 1/4$ ")

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Travel Speed	Proc. No.	Joint Detail ($1/4$ " Fillet Weld)
		Amperes	Volts			
1	.045	260	25	N.A.	6	
		($\pm 10\%$)	($\pm 7\%$)			

TRANS RECEIVED

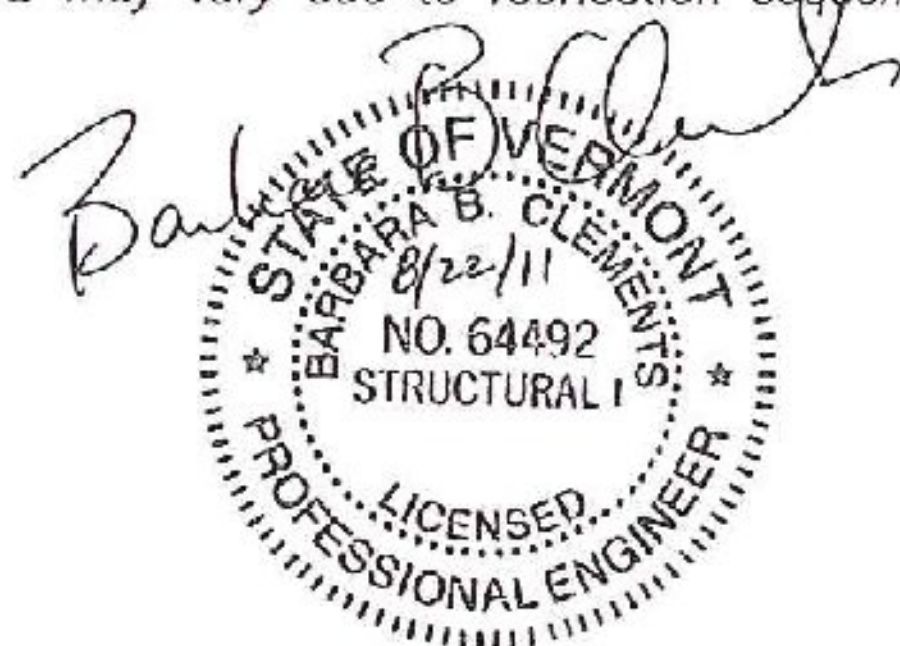
CK'D BY _____ OK'D BY JWC

OCT 04 2011

RESUBMIT _____ APPROVED ✓

BY _____ DATE 10/04/11

This WPS may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 3.



Fabricator WALPAR, LLC S.O. No. C1181
 Authorized By Michael Dempsey
 Date 8/22/11