



WELDING PROCEDURE SPECIFICATION (WPS)

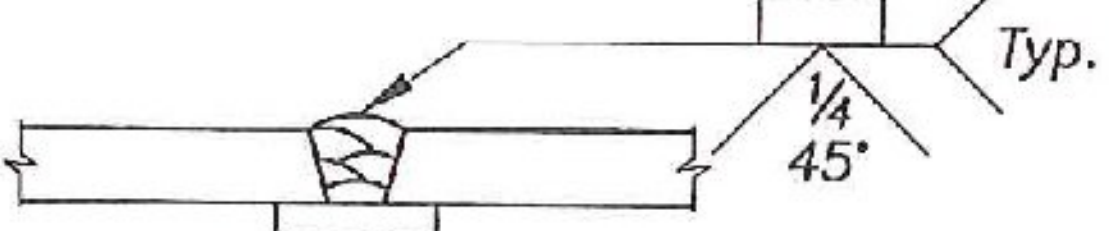
Project No. FECC F 026-1(34) C/2 County Barre Date 8/22/11  
 Material specification API-5L-X52, ASTM-A252, Gr. 3 or ASTM-A500, Gr. B (Mod. to 52 k.s.i.)  
 Welding process GMAW  
 Manual or machine Machine Semi-automatic  
 Position of welding Flat  
 Filler metal specification AWS A5.18  
 Filler metal 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" (±1/4")

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Travel Speed	Proc. No.	Joint Detail
		Amperes	Volts			
2	.045	260	25	N.A.	3	 Proc. #3 (Thru 1/4)
3	.045	260	25	N.A.	4	
5	.045	260	25	N.A.	5	
		(±10%)	(±7%)			

TRANS RECEIVED  
 OK'D BY \_\_\_\_\_ OK'D BY JAC  
 OCT 04 2011  
 RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
 BY \_\_\_\_\_ DATE 10/04/11

  
 Proc. #4 (>1/4 thru 3/8)

  
 Proc. #5 (>3/8 thru 1/2)

BU2a-GF

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

