

WELDING PROCEDURE SPECIFICATION (WPS)

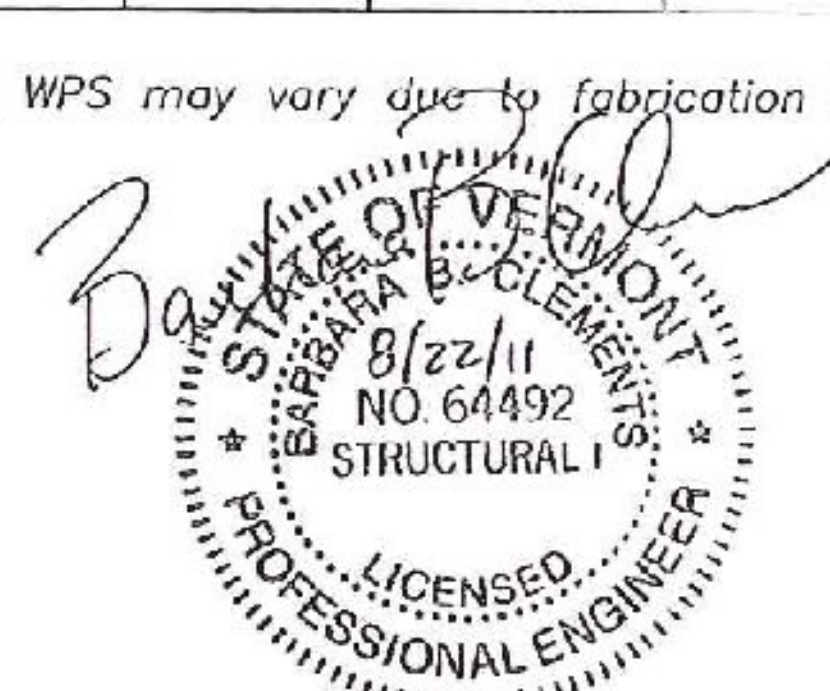
Project No. FEGC F 026-1(34) C/2 County Barre Date 8/22/11
 Material specification API-5L-X52, ASTM-A252, Gr. 3 or ASTM-A500, Gr. B (Mod. to 52 k.s.i.)
 Welding process GMAW
 Manual or machine Machine Semi-automatic
 Position of welding Flat, Horizontal
 Filler metal specification AWS A5.18
 Filler metal 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 Single
 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 (Fillet Weld)
		Amperes	Volts			
1	.045	260	25	N.A.	1	
		(±10%)	(±7%)			

RECEIVED
 OCT 04 2011
 APPROVED
 DATE 12/04/11

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