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 JAN 20 2011
 RESUBMIT APPROVED WELDING PROCEDURE SPECIFICATION (WPS) YES (X)
 BY DATE 02/01/11 PREQUALIFIED QUALIFIED BY TESTING
 or PROCEDURE QUALIFICATION RECORD (PQR) YES ()

Company Name ARC Enterprises, Inc. Identification # ARC WPS 8824
 Revision 5 Date 1/8/2011 By SH
 Welding Process(es) GMW Authorized by STEVE HOWARD Date 12-5-09
 Supporting PQR No.(s) _____ Type - Manual Semi - Automatic
 Machine Automatic

AWS D1.1 2008

JOINT DESIGN USED		POSITION	
Type <u>Fillet</u>	Position of Groove <u>Fillet</u>	1F	2F
Single <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/>	Vertical Progression <input type="checkbox"/>		
Beckling <input type="checkbox"/>			
Beckling Material _____			
Root Opening <u>0</u> Root Face Dimension <u>N/A</u>	ELECTRICAL CHARACTERISTICS		
Groove Angle <u>N/A</u> Radius (J-U) <u>N/A</u>	Transfer Mode (FCAM) _____	Short Circuiting <input type="checkbox"/>	
Back Gouging YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	Method <u>N/A</u>	Global <input type="checkbox"/> Spray <input checked="" type="checkbox"/>	
BASE METALS		Current : AC <input type="checkbox"/> DCBP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/>	
Material Spec <u>A709</u>	OTHER : _____		
Type or Grade <u>50</u>			
Thickness _____ Groove _____ Fillet <u>UNLIMITED</u>	TECHNIQUE		
Diameter (Pipe) _____	Stringer or Weave Bead <u>STRINGER</u>	Multi-pass or Single Pass (per side) <u>SINGLE/MULTI</u>	
FILLER METALS		Number of Electrodes _____	Electrode Spacing _____
AWS Specification <u>A5.18</u>	Longitudinal <u>NA</u>	Lateral <u>NA</u>	Angle <u>NA</u>
AWS Classification <u>ERT05-B ESAB SPOOLARC 88</u>	Contact Tube to Work Distance <u>5/8" - 3/4"</u>	Peening <u>NA</u>	
SHIELDING		Interpass Cleaning : <u>HAND/POWER TOOLS</u>	
Flux _____ Gas <u>88MARGON 240</u>	POSTWELD HEAT TREATMENT		
Composition _____	Temp <u>NA</u>	Time <u>NA</u>	
Electrode - Flux (Class) _____ Flow Rate <u>25-35 cfm</u> Gas Cup Size <u>5/8</u>			
Preheat up to 3/4" - 32 degrees F; 3/4" - 1 1/2" - 50 degrees F; 1 1/2" - 2 1/2" - 150 degrees F; over 2 1/2" - 225 degrees F (when steel temp < 30F, minimum 70F)			

Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
1 1	3/16"	ERT05-B	.035"	DCBP	180-220	25-27	7-9 ipm	
1 1	1/4"	"	"	"	180-220	25-27	6-8	
1 1	5/16"	"	"	"	"	25-27	4-6	
1 1	3/8"	"	.035"	"	"	"	3-4	
1 2	7/16"	"	"	"	"	"	2-3	