

WELDING PROCEDURE SPECIFICATION (WPS) Yes (X)
 PREQUALIFIED YES QUALIFIED BY TESTING
 or PROCEDURE QUALIFICATION RECORDS (PQR) Yes ()

Welding Process(es): GTAW
 Type - Manual (X) Sent-Automatic ()
 Machine () Automatic ()
 Identification # VT-114 MAJ
 Revisions: 0 Date: 3/26/06 By: AR
 Authorized by: [Signature] Date: 3/26/06

JOINT DESIGN USED
 Type: Lap
 Single (X) Double Weld ()
 Backing: Yes () No (X)
 Backing Material: NA
 Root Opening: NA
 Root Face Dimension: NA
 Groove Angle: NA
 Radius (J-U): NA
 Back Gouging: Yes () No (X)
 Method: _____
BASE METALS
 Material Spec: A709 to A304 10 Ga. S.S.
 Type or Grade: Gr. 302
 Thickness: 3/16"
 Diameter (Pipe): NA
FILLER METALS
 AWS Specification: None Fusion
 AWS Classification: _____
SHIELDING
 Flux: NA Gas: Argon 100%
 Electrode-Flux (Class): _____
 Flow Rate: 45 CFH
 Cup Size: 1/2
PREHEAT
 Preheat Temp (MIN): 70°
 Interpass Temp (MIN): 70°
 MIN: 70° MAX: 200°

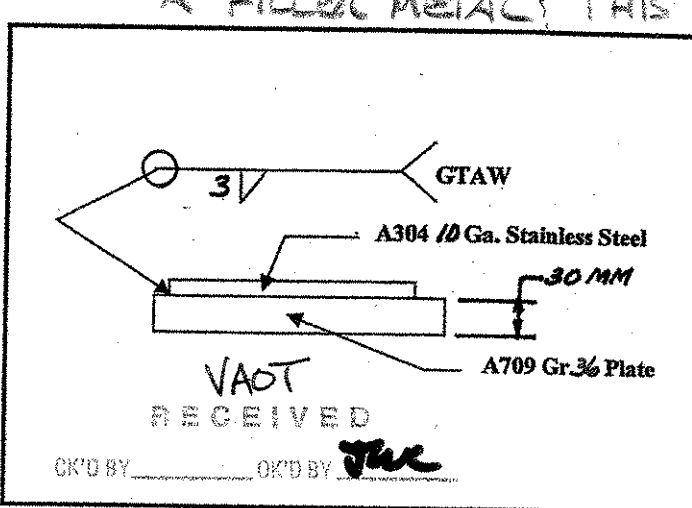
POSITION
 Position of Groove: NA Fillet: 2F
 Vertical Progression: Up () Down ()

ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW) Short-Circuiting ()
 Globular () Spray ()
 Current: AC () DCEP () DCEN (X) Pulsed ()
 Other: _____
 Tungsten Electrode (GTAW)
 Size: 1/8" (3MM)
 Type: 2% Thoriated Tungsten
 EWTR-3 AWS A5.12-97

TECHNIQUE
 Stringer or Weave Bead: _____
 Multipass or Single Pass: _____
 Number of Electrodes: _____
 Electrode Spacing: _____
 Longitudinal: _____
 Lateral: _____
 Angle: _____
 Contact Tube Work Distance: 1/2"
 Peening: _____
 Interpass Cleaning: _____

POSTWELD HEAT TREATMENT
 Temp: _____
 Time: _____

Pass or Weld Layers	Process	Filler Metal	
		Class	Diameter
1	GTAW		
Current		Volts	Travel Speed
Polarity	Amps		
DCEN	150 Amps ± 25%	10 V ± 25%	10 IPM ± 50%



MAP 1 D 2006
 RESUBMIT APPROVED
 BY [Signature] DATE 3/28/06

Do you have a procedure using a filler metal? This would be preferred.