

WPS No. GTAW 01-REV 6 Date 11/11/98 By Peter Croby Type Manual Machine
 Authorized By William Burhoe Date 11/11/98 Revision 6 Semi-Auto Auto
 Welding Process(es) GTAW Prequalified
 Supporting PQR(s) 98-101WB-F

JOINT
 Type Lap Joint
 Backing Yes No Single Weld Double Weld
 Backing Material N/A
 Root Opening N/A Root Face Dimension N/A
 Groove Angle N/A Radius (R-U) N/A
 Back Gouge Yes No
 Method N/A

BASE METALS
 Material Spec. ASTM A240 to ASTM A338
 Type or Grade 304 to 30W
 Thickness: Groove (in) _____
 Fillet (in) 1/32
 Diameter (Pipe, in) _____

FILLER METALS
 AWS Specification E5.8 Harris-Welco
 AWS Classification ER309L
Harris-Welco

SHIELDING
 Gas Argon
 Composition 100%
 Electrode-Flux (Class) 45 CFH
 Gas Cup Size 3/8" (B)

PREHEAT
 Preheat Temp., Min. 80 F
 Thickness Up to 3/4" Temperature 80
 Over 3/4" to 1-1/2" 150
 Over 1-1/2" to 2-1/2" 225
 Over 2-1/2" _____
 Interpass Temp., Min. N/A Max. N/A

POSITION
 Position of Groove Flat Flat
 Vertical Progression: Up Down

ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW):
 Short-Circuiting Globular Spray
 Current: AC DCEP DCEN Pulsed
 Other _____
 Tungsten Electrode (GTAW):
 Size 3/32 Type EWTh2

TECHNIQUE
 Stringer or Weave Bead Stringer
 Multi-pass or Single Pass (per side) Single
 Number of Electrodes 1
 Electrode Spacing: Longitudinal N/A
 Lateral N/A
 Angle N/A
 Contact Tube to Work Distance 3/8
 Peening NOT ALLOWED
 Interpass Cleaning N/A
 POSTWELD HEAT TREATMENT PWHT Required
 Temp. N/A Time N/A

WELDING PROCEDURE

1	GTAW	ER309L	3/32	DCEN	180	23	8 11/16
V.A.O.T.							
RECEIVED							
OK'D BY <u>JWC</u>							
JUN 3 2000							
APPROVED							
APR 23 2000							
6-14-00							

QUALIFIED WELDER
 AWS
 CC 1
 GLENN A. MYRICK
 5607081
 CWI

APPROVED
 For PA TOLANKE
 APR 23 2000
 HOTTENSTETT
 89.06033
 CWI