

**AUCIELLO IRON WORKS INC.**

MISCELLANEOUS METALS FABRICATOR

WELDING PROCEDURE SPECIFICATION (WPS) 2009-01

Cleaning

Initial cleaning oxide SS WIRE BRUSH  
Initial cleaning oil and dirt SOLVENT  
Interpass cleaning ---

Postweld Heat Treatment

Original temper \_\_\_\_\_  
Final temper \_\_\_\_\_  
Temperature \_\_\_\_\_  
Time \_\_\_\_\_  
Quench \_\_\_\_\_

Process(es)

Process GMAW Type SEMI-AUTO  
Process \_\_\_\_\_ Type \_\_\_\_\_  
Electrode (GTAW) \_\_\_\_\_

Technique

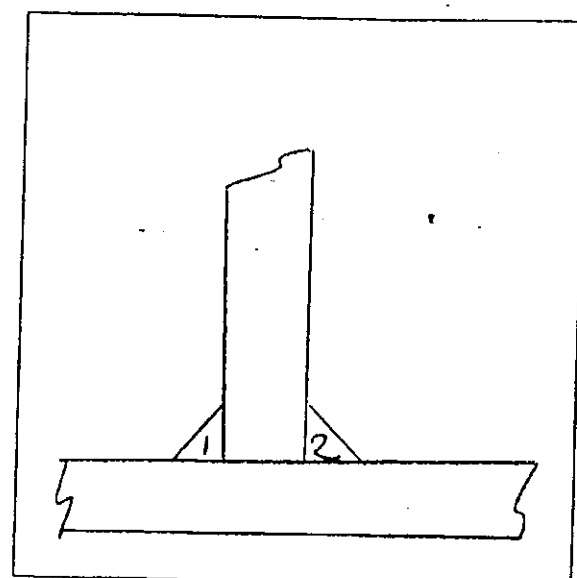
Stringer or weave bead STRINGER  
Orifice or gas cup size 5/8"  
Oscillation \_\_\_\_\_  
Contact tube to work distance 1/2"  
Single pass or multipass SINGLE per side  
Tungsten extension \_\_\_\_\_  
Method of backgouging \_\_\_\_\_  
Other \_\_\_\_\_

\*Manual, automatic, polarity, pulse, etc.

Pass No.	Welding Process	Amps	Volts	Travel Speed
<u>ALL</u>	<u>GMAW</u>	<u>148-200</u>	<u>22-30</u>	<u>24-36</u>

*VIRAK*  
**RECEIVED**  
CHK'D BY \_\_\_\_\_ OK'D BY JAC

AUG 24 2003  
REVIEWED \_\_\_\_\_ APPROVED ✓  
BY Virak DATE 8/25/03



Sketch of Welding Sequence