

WELDING PROCEDURE SPECIFICATION (WPS) 2009-01

Cleaning  
 Initial cleaning oxide SS WIRE BRUSH  
 Initial cleaning oil and dirt SOLENT  
 Interpass cleaning       

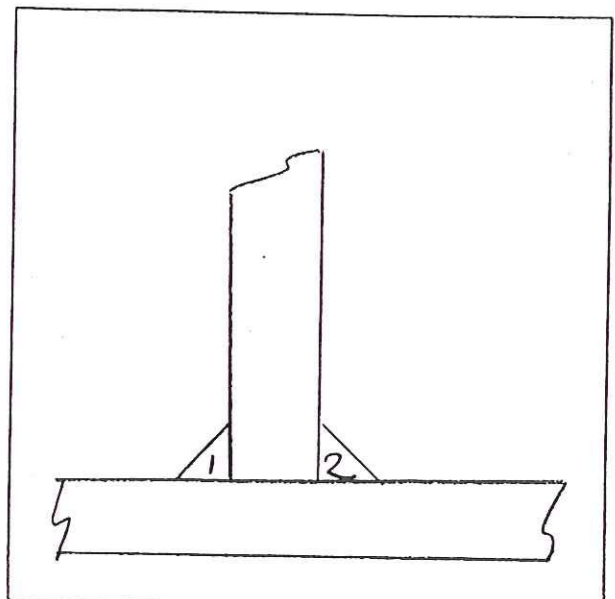
Pass No.	Welding Process	Amps	Volts	Travel Speed
ALL	GMAW	148-200	22-30	24-36

Postweld Heat Treatment  
 Original temper \_\_\_\_\_  
 Final temper \_\_\_\_\_  
 Temperature \_\_\_\_\_  
 Time \_\_\_\_\_  
 Quench \_\_\_\_\_

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

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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 \_\_\_\_\_



Sketch of Welding Sequence

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