

**AUCIELLO IRON WORKS INC.**

MISCELLANEOUS METALS FABRICATOR

WELDING PROCEDURE SPECIFICATION (WPS) 2009-02

**Cleaning**

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

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 \_\_\_\_\_

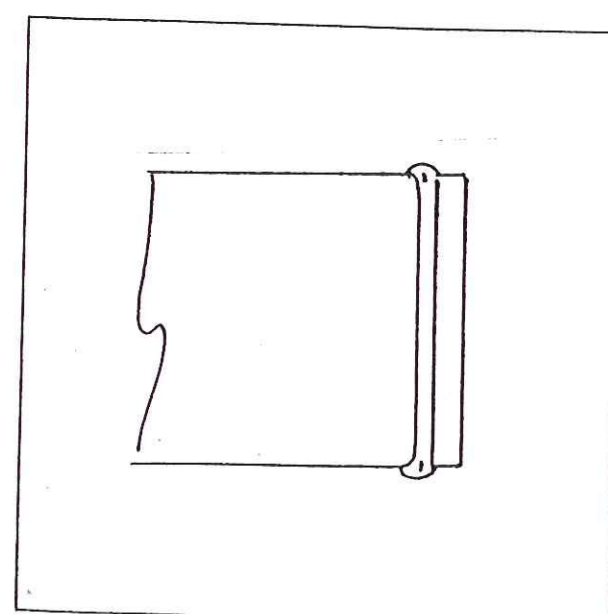
**Process(es)**

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

**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 MULTIPASS  
 Tungsten extension \_\_\_\_\_  
 Method of backgouging \_\_\_\_\_  
 Other \_\_\_\_\_

VT TRANS  
 RECEIVED  
 CK'D BY \_\_\_\_\_ OK'D BY JUC  
 AUG 24 2009  
 REQUESTED \_\_\_\_\_ APPROVED ✓  
 BY auc DATE 8/25/09



Sketch of Welding Sequence