



Robert H Parechanian, Jr.
CWI 90100111
QC1 EXP. 10/1/2014

RHP
1-26-2012

WELDING PROCEDURE SPECIFICATION (WPS) YES (X)
PREQUALIFIED _____ QUALIFIED BY TESTING (X) Fillet weld S. test 1-26-12
or PROCEDURE QUALIFICATION RECORD (PQR) YES (X)

Company Name ARC Ent. Identification # ARC WPS 5M3
Welding Process(es) GMAW Revision _____ Date _____ By _____
Supporting PQR No.(s) 5M3 Authorized by STEVE HOWARD Date 1/28/2012
Type - Manual _____ Semi - Automatic (X)
Machine () Automatic ()

JOINT DESIGN USED Type <u>Fillet</u> Single (X) Double Weld () Backing () NO (X) Backing Material _____ Root Opening <u>0</u> Root Face Dimension <u>NA</u> Groove Angle <u>NA</u> Radius (J-U) _____ Back Gouging <u>NA</u> Method _____		POSITION Position of Groove _____ Fillet <u>1F 2F</u> Vertical Progression ()	
BASE METALS Material Spec <u>A709</u> Type or Grade <u>36 50 50W</u> Thickness _____ Groove _____ Fillet <u>unfillet</u> Diameter (Pipe) _____		ELECTRICAL CHARACTERISTICS Transfer Mode (FCAW) _____ Short Circuiting () Globular () Spray (X) Current: AC () DCEP (X) DCEN () Pulsed () OTHER : _____	
FILLER METALS AWS Specification <u>A 5.18</u> AWS Classification <u>ER70S-6 Lincoln SuperArc L-56</u>		TECHNIQUE Stringer or Weave Bead <u>stringer</u> Multi-pass or Single Pass (per side) <u>single</u> Number of Electrodes <u>1</u> Electrode Spacing _____ Longitudinal _____ Lateral _____ Angle _____	
SHIELDING Flux _____ Gas <u>AR2</u> Composition <u>argon-98 oxygen-2</u> Electrode - Flux (Class) _____ Flow Rate <u>25-40 cfm</u> Gas Cup Size <u>5/8"</u>		Contact Tube to Work Distance <u>5/8" - 3/4"</u> Peening _____ Interpass Cleaning : _____	
Preheat : T < 3/4" = 50 degrees F. 3/4" - 1 1/2" = 70 degrees F. if steel temp < 15 degrees F. T < 3/4" = 70 degrees F.		POSTWELD HEAT TREATMENT Temp _____ Time _____	

WELDING PROCEDURE								Joint Details
Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
1	5/16"	ER70S-6	.035"	DCEP	216-264	25-29	7.8-9.8 ipm	

Vermont Agency of Transportation
RECEIVED

CK'D BY David Peterson OK'D BY JWC

Apr 26, 2012

RESUBMIT _____ APPROVED
BY C. CARLSON DATE 5/7/12

Steve Howard
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