

WELDING PROCEDURE SPECIFICATION (WPS) YES (X)
 PREQUALIFIED _____ QUALIFIED BY TESTING _____
 or PROCEDURE QUALIFICATION RECORD (PQR) YES (X)

Company Name ARC Ent. Inc. Identification # ARC WPS 45a
 Revision 1 Date 4/17/2012 By SVH
 Welding Process(es) SAW Authorized by STEVE HOWARD Date 3/13/2012
 Supporting PQR No.(s) ARC PQR # 45 Type - Manual () Semi - Automatic ()
 Machine () Automatic (X)

DART Welder

JOINT DESIGN USED Type <u>FILLET</u> Single <u>(X)</u> Double Weld <u>()</u> Backing <u>()</u> NO Backing Material _____ Root Opening <u>0</u> Root Face Dimension _____ Groove Angle <u>NA</u> Radius (J-U) _____ Back Gouging _____ Method _____		POSITION Position of Groove _____ Fillet <u>1F 2F</u> Vertical Progression <u>()</u>	
BASE METALS Material Spec <u>A709</u> Type or Grade <u>50W</u> Thickness _____ Groove _____ Fillet <u>U</u> Diameter (Pipe) _____		ELECTRICAL CHARACTERISTICS Transfer Mode (FCAW) _____ Short Circuiting <u>()</u> Globular <u>()</u> Spray <u>(X)</u> Current: AC <u>()</u> DCEP <u>(X)</u> DCEN <u>()</u> Pulsed <u>()</u> OTHER: _____	
FILLER METALS AWS Specification <u>A5.23 Lincoln LA-75</u> AWS Classification <u>ENi1K-Ni1-H8</u>		TECHNIQUE Stringer or Weave Bead <u>STRINGER</u> Multi-pass or Single Pass (per side) <u>SINGLE</u> Number of Electrodes _____ Electrode Spacing _____ Longitudinal _____ Lateral _____ Angle _____	
SHIELDING Flux <u>960</u> Gas _____ Electrode - Flux (Class) _____ Composition _____ <u>F8A2-ENi1K-Ni1</u> Flow Rate _____ Gas Cup Size _____		Contact Tube to Work Distance <u>1 1/4" Stickout +/- 1/4"</u> Peening _____ Interpass Cleaning: _____	
Preheat <u>75 degrees F.</u>		POSTWELD HEAT TREATMENT Temp _____ Time _____	

WELDING PROCEDURE								
Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polarity	Amps or Wire Feed Speed			
	SAW	ENi1K	3/32"	DCEN	360-440	28-32	12-16.2 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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