WELDING PROCEDURE SPECIFICATION (WPS)

PREQUALIFIED YES ***QUALIFIED BY TEST*** _____

Company Name HUB Foundation
Welding Process(es) SMAW
Supporting PQR # (s) N/A

Identification # SMAW
Revision N/A N/A By N/A
Authorized COMPANY Date 3/23/2012

Type-				
	Manual	YES	Semi-Auto	N/A
	Machine	N/A	Automatic	N/A

JOINT DESIGN USED

Single YES B-U2
Backing Yes / No None
Backing Material None
Root Opening and Face Dimension 3/16"
GROVE ANGLE 45 DEG INC.
Back Gouge Y/N/Type Yes grind

POSITION

Position of Groove 3G Fillet N/A
Verticle up Down N/A

ELECTRICAL CHARACTERISTICS

Transfer Mode
Short-Circuiting / Globular / Spray SHORT-CIRCUIT
Current AC, DCEP, DCEN, Pulsed DCEP
Other none

Size 300
Type Miller 302 DC Engine drive

BASE METALS

Material Spec. ASTM A-252 grade 2
Type or Grade carbon steel
Material Thickness 3/4"
Fillet N/A
Pipe Diameter N/A

TECHNIQUE

Stringer or Weave Bead Pass 1-3 STRINGER Pass 4-5 WEAVE
Multi or Single Pass (per side) MULTI ONE SIDE
Number of Electrodes N/A
Electrode Spacing: Longitudinal N/A
Lateral N/A
Angle 45-90
Contact Tube to Work Distance N/A
Peening YES
Interpass Cleaning YES

FILLER METALS

A.W.S. Specification AWS A5.1
A.W.S. Classification E7018

SHIELDING

Flux
Electrode-flux Class N/A
Composition N/A
Flow Rate N/A
GAS CUP N/A

PREHEAT

Preheat Temp., Min. N/A
Interpass Temp. Min. 70 deg
Interpass Temp. Max. 60-350 deg

POSTWELD HEAT TREATMENT

Temp. none
Time N/A

WELDING PROCEDURE

Pass or Weld Layer Layer(s)	Process	FILLER METALS Class	FILLER METALS Diam.	CURRENT Type & Polarity	CURRENT Amps.	Volts	Travel Speed	JOINT DETAIL SEE ATTACHED
#1	SMAW	E7018	0.092	DCEP	68	N/A		
#2	SMAW	E7018	0.125	DCEP	115			
#3	SMAW	E7018	0.125	DCEP	118			
#4	SMAW	E7018	0.125	DCEP	118			
#5	SMAW	E7018	0.125	DCEP	118			
#6								
#7								