WELDING PROCEDURE SPECIFICATION (WPS)

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

Company Name HUB FOUNDATION
Welding Process(es) SMAW
Supporting PQR # (s) _____

Identification # SMAW
Revision No N/A By N/A
Authorized Hub Foundation Date 3/28/2012

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

JOINT DESIGN USED

Single YES B-U4a
Backing Yes / No YES
Backing Material Mild Steel
Root Opening and Face Dimension 3/8"
GROVE ANGLE 30 deg
Back Gouge Y/N/Type N/A

POSITION

Position of Groove 2G Fillet N/A
Vertical N/A Down N/A

ELECTRICAL CHARACTERISTICS

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

Size 400 amp Engin drive
Type Miller CC/CV

BASE METALS

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

TECHNIQUE

Stringer or Weave Bead STRINGER
Multi or Single Pass (per side) MULTI
Number of Electrodes N/A
Electrode Spacing: Longitudinal N/A
Lateral N/A
Angle 15-20 deg
Contact Tube to Work Distance
Peening YES
Interpass Cleaning YES

FILLER METALS

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

SHIELDING

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

PREHEAT

Preheat Temp., Min. 70 deg
Interpass Temp. Min. 150 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. or W.F.S.	Volts	Travel Speed	JOINT DETAIL
ALL	SMAW	E7018	0.125	DCEP	115	N/A		
#2								
#3								
#4								
#5								
#6								
#7								