

Full Penetration Weld - Flanges
WELDING PROCEDURE SPECIFICATION (WPS)

Material specification HP12x84 A572 Gr 50
 Welding process SMAW
 Manual or machine Manual
 Position of welding HORIZONTAL
 Filler metal specification E7018 AWS A5.1
 Filler metal classification E7018
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass MULTIPLE
 Single or multiple arc SINGLE
 Welding current BELOW
 Polarity DC+
 Welding progression NA
 Root treatment MANUAL CLEANING
 Preheat and interpass temperature 50°F MIN.
 Postheat temperature NA
 Heat Input Min NA Max NA

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Travel Speed	Joint Detail
		Amperes	Volts		
1-6	1/8"	109-120	70	-	SINGLE BEVEL GROOVE
		OR	?		WHAT KIND OF POWER SOURCE?
1-6	5/32"	120-140	70	-	SINGLE BEVEL GROOVE

This WPS may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure no. FP1 Contractor REED & REED
 Revision no. 0 Authorized By MARK BUCKBEE
 Date 7/18/12

Form III-2

Form III-2—Sample Welding Procedure Specification