

FILLET WELD - COVER PLATES

WELDING PROCEDURE SPECIFICATION (WPS)

Material specification HP 12x84 A572 Gr 50 / 3/4" PL A572 Gr 50
 Welding process SMAW
 Manual or machine MANUAL
 Position of welding HORIZONTAL/VERTICAL/OVERHEAD
 Filler metal specification E7018 AWS A5.1
 Filler metal classification E7018
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass MULTIPLE PASS
 Single or multiple arc SINGLE
 Welding current BELOW
 Polarity DC+
 Welding progression NA
 Root treatment MANUAL CLEANING
 Preheat and interpass temperature NO PREHEAT REQ'D
 Postheat temperature NA
 Heat Input Min NA Max NA

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Travel Speed	Joint Detail
		Amperes	Volts		
1-3	1/8"	109-120	70	-	FILLET
		OR	? WHAT KIND OF POWER SOURCE?		
1-3	5/32"	120-140	70	-	FILLET

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

Procedure no. FW1 Contractor REED & REED
 Revision no. 0 Authorized By MARK BUCKBEE
 Form III-2 Date 7-18-12