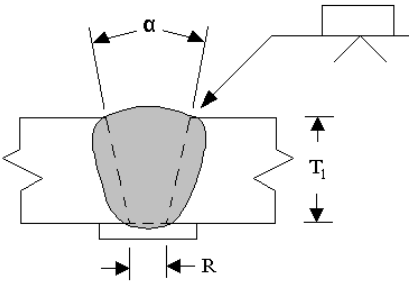


AWS D1.1 Prequalified Welding Procedure Specification (WPS)

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Prepared By: _____ Date 7/9/2008 Welding Engineer

Welding Process SAW Welding Method Machine

<p>Joint Design Used Weld Type <u>CJP Groove welds</u> Joint Type <u>Butt joint</u> Groove Type <u>Single-V groove</u> Double Welded <u>No</u> Backing <u>Yes</u> Material <u>Base Metal</u> Root Opening <u>5/8 in.</u> Root Face <u>0 in.</u> Groove Angle <u>20°</u> Radius <u>N/A</u> Back Gouging <u>No</u> Method <u>N/A</u></p> <p>Base Metals Base Metal <u>ASTM A 36</u> Thickness: Groove <u>1.0 in.</u> Thickness: Fillet <u>N/A</u> Pipe Diameter <u>n/a</u></p> <p>Filler Metals AWS Specification <u>5.17</u> AWS Classification <u>EM12K</u> Supplemental Filler Metal <u>None</u></p> <p>Shielding Gas <u>N/A</u> Flow Rate <u>-</u> Gas Cup Size <u>N/A</u> Electrode-Flux (Class) <u>F7A2-EM12K</u> Flux Trade Name <u>860</u> Recrushed Slag <u>none</u></p> <p>Preheat Preheat Temperature, Min. <u>150°F</u> Interpass Temperature, Min. <u>150°F</u> Max. <u>350°F</u></p>	<p>Joint Designation <u>B-U2-S</u></p> <div style="text-align: center;">  </div> <p>Position Weld Position: Groove <u>Flat only</u> Weld Position: Fillet <u>N/A</u> Vertical Progression <u>N/A</u></p> <p>Electrical Characteristics Current / Polarity <u>DCEP (reverse)</u> Transfer Mode <u>N/A</u> Tungsten Electrode: Type <u>N/A</u> Size <u>N/A</u></p> <p>Technique Stringer or Weave Bead <u>Stringer bead</u> Multi-pass or Single Pass (per side) <u>Multipass</u> Number of Electrodes <u>1</u> Electrode Spacing: Longitudinal <u>N/A</u> Lateral <u>N/A</u> Angle <u>N/A</u> Contact Tube to Work Distance <u>1-1/4"</u> Travel Angle <u>90°</u> Peening <u>none</u> Interpass Cleaning <u>Slag Removal</u></p> <p>Postweld Heat Treatment Temperature <u>None</u> Time (hr.) <u>None</u></p>
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Welding Procedure

Pass or Weld Layer(s)	Process	Filler Metal		Current		Wire Feed Speed (in/min)	Volts	Travel Speed (in/min)
		AWS Classification	Size (in.)	Type & Polarity	Amps			
1-n	SAW	EM12K	5/32	DCEP (reverse)	500 - 600	45	26-30	14 - 18

Additional Notes

JOINT NOTES:

(j) The orientation of the two members in the joints may vary from 135° to 180° for butt joints, or 45° to 135° for corner joints, or 45° to 90° for T-joints.