WELDING PROCEDURE SPECIFICATION (WPS) YES (x)
PREQUALIFIED ____ QUALIFIED BY TESTING _____
or PROCEDURE QUALIFICATION RECORD (PQR) YES (x)

Company Name ARC Ent. Inc.
Welding Process(es) GMAW
Supporting PQR No.(s) ARC PQR 5M3-2

Identification # ARC WPS 5T
Revision 3 **Date** 2/5/2015 **By** SVH
Autherized by **STEVE HOWARD** **Date** 3/14/2012
Type - Manual Semi - Automatic (x)
Machine ( ) Automatic ( )

JOINT DESIGN USED
Type FILLET
Single (X) Double Weld ( )
Backing ( ) NO
Backing Material N/A
Root Opening 0 **Root Face Dimension**
Groove Angle **Radius (J-U)**
Back Gouging **Method**

BASE METALS
Material Spec A709
Type or Grade 36 50 50W HPS50W HPS70W
Thickness **Groove** **Fillet** U
Diameter **(Pipe)**

FILLER METALS Lincoln L-56
AWS Specification A5.18
AWS Classification ER70S-6

SHIELDING
Flux **Gas** 98/2
Composition 98 argon 2 oxygen
Electrode - Flux (Class) **Flow Rate** 36-50 cfh
Gas Cup Size 5/8"

POSITION
Position of Groove **Fillet** 1F 2F 3F 4F
Vertical Progression ( )

ELECTRICAL CHARACTERISTICS
Transfer Mode (FCAW) **Short Circuiting** ( )
Globular ( ) **Spray** (X)
Current : **AC** ( ) **DCEP** (X) **DCEN** ( )
Pulsed ( )
OTHER :

TECHNIQUE
Stringer or Weave Bead tack
Multi-pass or Single Pass (per side) single
Number of Electrodes one
Electrode Spacing **Longitudinal**
Lateral
Angle
Contact Tube to Work Distance 5/8" - 3/4"
Peening
Interpass Cleaning :

POSTWELD HEAT TREATMENT
Temp
Time

WELDING PROCEDURE

Pass or Weld Layer(s)	S	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diameter	Type & Polartiy	Amps or Wire Feed Speed			
1	3/16"	ER70S-6	.035"	DCEP	209-255	24.9-28.5	TACK	TACK

APPROVED
By Ryan Foster at 6:24 am, Jun 11, 2015