

WELDING PROCEDURE SPECIFICATION (WPS) Yes
PREQUALIFIED _____ QUALIFIED BY TESTING _____
or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

Company Name Miller Construction, Inc.
 Welding Process(es) SMAW
 Supporting PQR No.(s) N/A

Identification # 1
 Revision 0 Date 1/20/14 By J. Ouelette
 Authorized by P. Holloway Date 1/20/14
 Type—Manual Semiautomatic
 Mechanized Automatic

JOINT DESIGN USED
 Type:
 Single Double Weld
 Backing: Yes No
 Backing Material:
 Root Opening _____ Root Face Dimension _____
 Groove Angle: ⁴⁵ _____ Radius (J-U) _____
 Back Gouging: Yes No Method _____

POSITION
 Position of Groove: 2G Fillet: 1,2,3,4F
 Vertical Progression: Up Down

BASE METALS
 Material Spec. HP 12 X 74
 Type or Grade GR 50
 Thickness: Groove 0.68 Fillet 0.75
 Diameter (Pipe) _____

ELECTRICAL CHARACTERISTICS
E7018
 Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Power Source: CC CV
 Other _____
 Tungsten Electrode (GTAW)
 Size: N/A
 Type: _____

FILLER METALS
 AWS Specification A5.5
 AWS Classification E7018

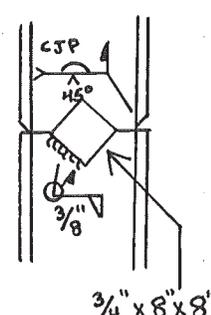
TECHNIQUE
 Stringer or Weave Bead: Stringer
 Multi-pass or Single Pass (per side) Multi-Pass
 Number of Electrodes _____
 Electrode Spacing Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening _____
 Interpass Cleaning: _____

SHIELDING
 Flux X Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

POSTWELD HEAT TREATMENT
 Temp. N/A
 Time _____

PREHEAT
 Preheat Temp., Min. 70 F
 Interpass Temp., Min. N/A Max. N/A

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			
3 Layers	SMAW	E7018	1/8	DC	132	22/26	As Req.	

Vermont Agency of Transportation
RECEIVED

CK'D BY _____ OK'D BY JWC
 February 24, 2014

RESUBMIT NO Approved _____
 BY KMH DATE 2-26-2014

WELDING PROCEDURE SPECIFICATION (WPS) Yes
PREQUALIFIED _____ QUALIFIED BY TESTING _____
or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

Company Name Miller Construction, Inc.
 Welding Process(es) SMAW
 Supporting PQR No.(s) N/A

Identification # 2
 Revision 0 Date 1/20/14 By J. Ouelette
 Authorized by P. Holloway Date 1/20/14
 Type—Manual Semiautomatic
 Mechanized Automatic

JOINT DESIGN USED

Type:
 Single Double Weld
 Backing: Yes No
 Backing Material:
 Root Opening _____ Root Face Dimension _____
 Groove Angle: _____ Radius (J-U) _____
 Back Gouging: Yes No Method _____

POSITION

Position of Groove: 2G Fillet: _____
 Vertical Progression: Up Down

BASE METALS

Material Spec. HP 12 X 74
 Type or Grade GR 50
 Thickness: Groove 0.68 Fillet 0.75
 Diameter (Pipe) _____

ELECTRICAL CHARACTERISTICS

E7018
 Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Power Source: CC CV
 Other _____
 Tungsten Electrode (GTAW)
 Size: N/A
 Type: _____

FILLER METALS

AWS Specification A5.5
 AWS Classification E7018

TECHNIQUE

Stringer or Weave Bead: Stringer
 Multi-pass or Single Pass (per side) Multi-Pass
 Number of Electrodes _____
 Electrode Spacing Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening _____
 Interpass Cleaning: _____

SHIELDING

Flux X Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

POSTWELD HEAT TREATMENT

Temp. N/A
 Time _____

PREHEAT

Preheat Temp., Min. 70 F
 Interpass Temp., Min. N/A Max. N/A

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			
3 Layers	SMAW	E7018	3/16	DC	185	22/26	As Req.	

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February 24, 2014

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 BY KMH DATE 2-26-2014