

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

Company Name G&G Fabricating & Machining
 Welding Process(es) D1.1
 Supporting PQR No.(s) AWS

Identification # 93
 Revision 1 Date 4-21-18 By _____
 Authorized by [Signature] Date 4-21-18
 Type—Manual Semiautomatic
 Machine Automatic

JOINT DESIGN USED

Type:
 Single Double Weld
 Backing: Yes No
 Backing Material:
 Root Opening 1/8 Root Face Dimension 1/2"
 Groove Angle: 15 Degrees Radius (J-U) GMAW
 Back Gouging: Yes No Method _____

POSITION

Position of Groove: 3g Fillet: YES
 Vertical Progression: Up Down

BASE METALS

Material Spec. ASTM 500
 Type or Grade _____
 Thickness: Groove 1/2" Fillet 1/2"
 Diameter (Pipe) 6"

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Power Source: CC CV
 Other _____
 Tungsten Electrode (GTAW)
 Size: 3/32
 Type: 2 Percent

FILLER METALS

AWS Specification 70 S-6
 AWS Classification _____

TECHNIQUE

Stringer or Weave Bead: Stringer
 Multi-pass or Single Pass (per side) 3
 Number of Electrodes _____
 Electrode Spacing Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening N/A
 Interpass Cleaning: YES

SHIELDING

Flux _____ Gas C-10
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate 30
 Gas Cup Size T-30

PREHEAT

Preheat Temp., Min. 300
 Interpass Temp., Min. 300 Max. 300

POSTWELD HEAT TREATMENT

Temp. N/A
 Time _____

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			
1	gmaw	70 S-6	.035	straight	22-254	22	10"	fillets stack stack
2	gmaw	70 S-6	.035	straight	22-254	22	10"	
3	gmaw	70 S-6	.035	straight	22-254	22	10"	

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

Company Name _____
 Welding Process(es) D1.1
 Supporting PQR No.(s) AWS

Identification # _____
 Revision 1 Date 11-21-18 By _____
 Authorized by _____ Date _____
 Type—Manual Semiautomatic
 Machine Automatic

JOINT DESIGN USED

Type:
 Single Double Weld
 Backing: Yes No
 Backing Material: _____
 Root Opening 1/8 Root Face Dimension 1/8
 Groove Angle: 75° Radius (J-U) GMAW
 Back Gouging: Yes No Method _____

POSITION

Position of Groove: 3G Fillet: YES
 Vertical Progression: Up Down

BASE METALS

Material Spec. ASTM 500
 Type or Grade _____
 Thickness: Groove 1/2" Fillet 1/4"
 Diameter (Pipe) 6"

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Power Source: CC CV
 Other _____
 Tungsten Electrode (GTAW)
 Size: 3/32
 Type: 930

FILLER METALS

AWS Specification 705-6
 AWS Classification _____

TECHNIQUE

Stringer or Weave Bead: STRAIGHT
 Multi-pass or Single Pass (per side) 3
 Number of Electrodes _____
 Electrode Spacing _____
 Longitudinal _____
 Lateral _____
 Angle _____

SHIELDING

Flux _____ Gas E-10
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate 30
 Gas Cup Size T-30

Contact Tube to Work Distance _____
 Peening N/A
 Interpass Cleaning: YES

PREHEAT

Preheat Temp., Min. 300
 Interpass Temp., Min. 300 Max. 300

POSTWELD HEAT TREATMENT

Temp. N/A
 Time _____

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			
1	GMAW	705-6	.035	STRAIGHT	22-254	22	10"	STACK
2	"	"	"	"	22-254	22	10"	STACK
3	"	"	"	"	22-254	22	10"	STACK