

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

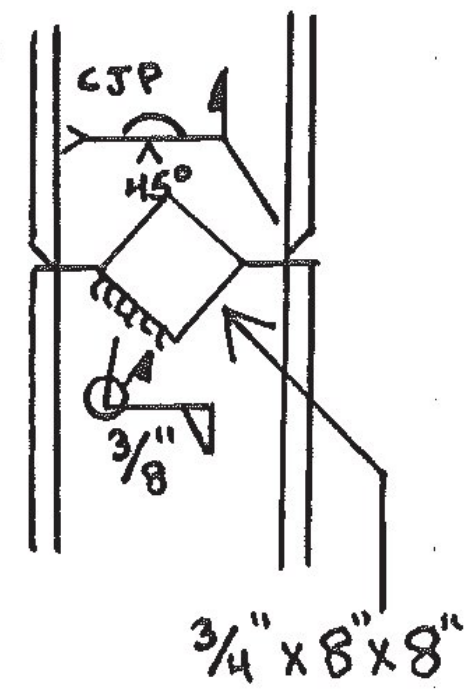
Time _____

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

Revised 09/07/2014(02) - File 916, Submittal 2-24-2014, per spec.pdf

CK'D BY _____ OK'D BY JWC

February 24, 2014

RESUBMIT NO Approved _____

BY KMH DATE 2-26-2014