

Company Name		ARC Enterprises, Inc.		Identification #	ARC WPS 832A	
Welding Process(es)		GMAW		Revision	5	Date 1/6/2011 By SVH
Supporting PQR No.(s)				Authorized by	STEVE HOWARD Date 12-5-05	
				Type -	Manual	Semi-Automatic (X)
				Machine	()	Automatic ()

WELDING PROCEDURE							Joint Details	
Pass or Layer(s)	S	Class	Filler Metal Diameter	Type & Polarity	Amperage or Wire Feed Speed	Volts	Torch Speed	Sketch
1 1	3/16"	ER70S-6	.035"	DCSP	160-220	25-27	7-9 in.	
1 1	1/4"	"	"	"	"	25-27	5-6	
1 1	5/16"	"	"	"	"	25-27	4-5	
1 1	3/8"	"	.035"	"	"	"	3-4	
1 2	7/16"	"	"	"	"	"	2-3	