

WELDING PROCEDURE SPECIFICATION (WPS)

PREQUALIFIED QUALIFIED BY TESTING

Company Name: PREMIERE, Inc. Welding Process(es): SMAW Supporting PQR No(s): 106-1 Applicable Code(s): AWS D1.1-96	WPS No.: 106 Revision: 3 Date: 11/6/96 Authorized By: Type: <input checked="" type="checkbox"/> Manual <input type="checkbox"/> Semi-Automatic <input type="checkbox"/> Machine <input type="checkbox"/> Automatic
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JOINT DESIGN USED Type: Single "V" Groove Single: <input checked="" type="checkbox"/> Double Weld: <input type="checkbox"/> Backing: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Backing Material: N/A Root Opening: 1/8" - 5/32" Root Face Dimension: 0" Groove Angle: 40° - 45° Back Gouging: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	POSITION Position of Groove: 2G Fillet: All Vertical Progression: <input type="checkbox"/> Up <input type="checkbox"/> Down <input checked="" type="checkbox"/> N/A ELECTRICAL CHARACTERISTICS Transfer Mode (GMAW) Short-Circuiting <input type="checkbox"/> Globular <input type="checkbox"/> Spray <input type="checkbox"/> Current: AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/> Tungsten Electrode (GTAW): Size: N/A Type: N/A
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BASE METALS Material Spec: Premiere Lite Type or Grade: (API 5L X-65 - Equal) Thickness Groove: .375" to Unlimited Fillet: Unlimited Diameter (Pipe): 26" OD & Over	TECHNIQUE String/Weave Bead: String Multi or Single Pass: Multiple Number of Electrodes: Single Electrode Spacing: Longitudinal: N/A Lateral: N/A Angle: N/A Contact Tube to Work Distance: N/A Peening: None allowed. Interpass Cleaning: Chip, brush or grind slag as necessary.
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FILLER METALS AWS Specification: A5.5 A5.1 AWS Classification: E-7010-G E-7018-1	SHIELDING Gas: N/A Composition: N/A Flow Rate: N/A Gas Cup Size: N/A Flux: N/A
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PREHEAT Preheat Temp. (Min.) 50°F ≤ 3/4" 150°F > 3/4" ≤ 1-1/2" 225°F > 1-1/2" ≤ 2-1/2" 300°F > 2-1/2" Interpass Temp. (Min.) 50°F (Max.) 550°F	POSTWELD HEAT TREATMENT Temperature: None Time: N/A
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WELDING PROCEDURE

PASS OR WELD LAYERS	PROCESS	FILLER METALS		CURRENT		VOLTS	TRAVEL SPEED (IPM)	NOTES
		CLASS	DIA.	TYPE AND POLARITY	AMPS OR WIRE FEED SPEED			
1 or 2	SMAW	E-7010-G	5/32"	DCEP	120 - 180	25 - 29	6-11 IPM	
1 or 2	SMAW	E-7010-G	3/16"	DCEP	140 - 200	25 - 29	7-12 IPM	
Balance	SMAW	E-7018-1	5/32"	DCEP	140 - 200	24 - 28	6-11 IPM	
(or) Balance	SMAW	E-7018-1	7/32"	DCEP	260 - 330	22 - 26	11-16 IPM	

NOTE: Whenever Charpy Impact requirements are to be met, then the combination of Amps, Volts, and Travel Speed shall not exceed 33,000 Joules per inch (J/in). Calculate using this formula:
AMPS X VOLTS X 60 DIVIDED BY INCHES PER MINUTE TRAVEL SPEED = JOULES PER INCH