

WeldOffice® printout sample - AWS Prequalified WPS



C-spec

P.O. Box 27604, Concord, California 94527 (877) 977-7999
AWS D1.1 Prequalified Welding Procedure Specification (pWPS)

Created with WeldOffice® WPS Module

Company name	C-spec
Welding process	GMAW
Process type	Semi-automatic

Joint design used

Joint type	B - Butt joint
Joint design	Single V groove (2)
Backing	Yes
Backing material	AWS D1.1 Table 3.1 Group I
Root opening (R)*	(in.) 3/16, +1/16, -0 (+1/4, -1/16)
Root face (f)*	(in.) n/a
Groove angle (a)*	(deg.) 30, +10, -0 (+10, -5)
Radius (J - U)*	(deg.) n/a
Back gouging	No
Back gouging method	n/a

Base metals

* Datum, As Detailed (As Fit-Up)

Spec., type or grade	AWS D1.1 Table 3.1 Group I
Thickness:	
Groove (in.)	T1:unlimited
Fillet (in.)	T1:unlimited
Diameter (Pipe) (in.)	Unlimited

Filler metals

AWS Specification	5.18
AWS Classification	ER70S-2

Shielding

Flux	-
Electrode-flux (class)	-
Gas composition	75% Argon, 25% CO2
Gas flow rate (cfh)	25 - 40
Gas cup size (in.)	5

Welding procedure

Layer	Pass	Process	Filler metal class	Filler metal diameter (in.)	Current type / polarity	Amps	Wire feed speed (in./min)	Volts	Travel speed (in./min)	Joint details
All	All	GMAW	ER70S-2	.035	DCEP	100-135	120-150	25-35	4-10	
Designation										

Notes

PREHEAT/INTERPASS
 For thickness 1/8 to 3/4(in.): 32(°F). Preheat to 70(°F) if the base metal temperature is below 32(°F).
 Over 3/4 thru 1-1/2(in.): 150(°F).
 Over 1-1/2 thru 2-1/2(in.): 225(°F).
 Over 2-1/2(in.): 300(°F).

Welding Engineer

Name	Signature
Nick Mossman	
Date	
3/30/01	

QA Manager

Name	Signature
Michal Bernasek	
Date	
3/30/01	

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Name	Signature
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