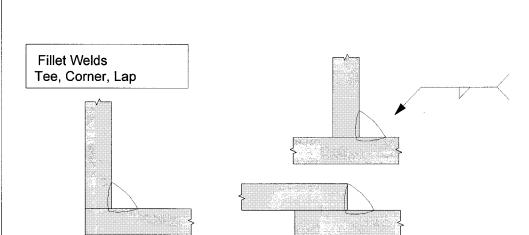
GIBBONS ERECTORS

Welding Procedure Specification

GE-AWS D1.6 NO.2

WPS No.	GE-AWS		evision	Date	Date		ByPrequalified ⊠				
	-	,			•						
Welding Pro		SMAW			Type: Man	ual 🖂	Machine Semi-A	Auto 🗌 Auto 🔲			
Supporting	PQR(s)										
JOINT						ginet ta	felds				
Type T -		oint, Corner			-	Fillet Welds Tee, Corner, Lap					
Backing		☐ Single Weld	⊠ Doub	ele Weld 🗆		If root opening is greater than 1/16", the leg of the fillet shall be increased by the amount of the root opening. Base Male Thickness Tolerances Permitted Walid					
Backing N	/laterial N	Α									
Root Ope	ning NA	Root Face Di	mension I	NA	_						
Groove A	ngle SEE T	ABLE Radius (J-	U) NA								
Back Gou	ige Yes	□ No □				Welding Process	Joint (U=unlimited) As	Detailed As Fit Up Welding Size a 3.12.3) (see 3.12.3) Positions (E1+E2) Notes			
Meti	hod NA					SMAW NA UB min to U - 1MAX = 3/16" See AWS D1.6 See AWS D1.6 All NA					
BASE ME	TALS				POSITION						
Material S	Spec. AWS	S D1.6 GRP A to	AWS D1	.6 GRP A	Position of C	3roove	NA Fille	et ALL			
Type or G	irade <u>ie. 3</u>	04, 308 to			Vertical Pro	gression:	: ⊠ Up □ I	Down			
Thickness: Groove () NA - NA					ELECTRICAL	ELECTRICAL CHARACTERISTICS					
Fillet (in).063 - ALL					Transfer Mo	Transfer Mode (GMAW):					
Diameter (Pipe, in) 0VER 2-7/8 - Unlimited					Short-0	Short-Circuiting ☐ Globular ☐ Spray ☐					
FILLER METALS				Current: /	Current: AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐						
	cification A	WS A5.4	AWS A5	.4	Other NA	Other NA					
AWS Clas	ssification E	308L	E308, E3	08L	Tungsten El						
	_				Size NA	\	Type NA				
SHIELDING					TECHNIQUE						
SHIELDING Flux Gas NA						Stringer or Weave Bead Both					
NA	Composition N	IA			Multi-pass or Single Pass (per side) Both						
Electrode) Flow Rate	IA			Number of Electrodes 1						
NA	Gas Cup Size	NA		Electrode S	Electrode Spacing: Longitudinal NA						
PREHEAT							Lateral NA				
Preheat T	emp., M in.	NONE			Contact Tub	o to Me	Angle <u>NA</u>				
Thickness Up to 3/4" Temperature NONE				Contact Tub Peening N		rk Distance <u>NA</u> _ LOWED					
Over 3/4" to 1-1/2"					-			IP GRIND			
Over 1-1/2" to 2-1/2"					•	Interpass Cleaning WIRE BRUSH, CHIP, GRIND					
	2"			POSTWELD	HEAT TI	REATMENT PWH	T Required ☐				
Interpass	Temp., Min.	Ma	nx		Temp.		Time				
		Nuncel see Graves	I	WELDIN	G PROCEDURE	Roman and					
Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps or WFS	Volts	Travel Speed	Other Notes			
ALL	SMAW	E308L, E3XX(L)	1/8"	DCEP	65-100	19-26	4-7 IPM				
OR											
ALL	SMAW	E308L, E3XX(L)	3/32"	DCEP	40-70	16-22	5-9 IPM				



If root opening is greater than 1/16", the leg of the fillet shall be increased by the amount of the root opening.

Welding Process	Joint Designation	Base Metal Thickness (U=unlimited)		Root Opening	Tolerances As Detailed		Permitted Welding Positions	Size) Notes
SMAW	<u> </u>	1/8 min to U		*MAX = 3/16"		See AWS D1.6	All	NA	7 140163

MEMO

This WPS applies to joints where the minimum angle between the joined pieces is 60 degs. and the maximum angle is 135 degs. The provisions of weld sizes and base metal thicknesses can be found in AWS D1.6 paragraph 3.14.1. Acceptable weld profiles are defined in Figure 5.2 of AWS D1.6.

Fillet Weld Assembly. The parts to be joined by fillet welds shall be brought into as close contact as practicable. If the separation is greater than 1/16 in. (1.6 mm), the leg of the fillet weld shall be increased by the amount of the root opening. Fit up separations greter than 3/16 in. (5 mm) are unacceptable without prior approval of the engineer and demonstration that the required effective throat has been attained.