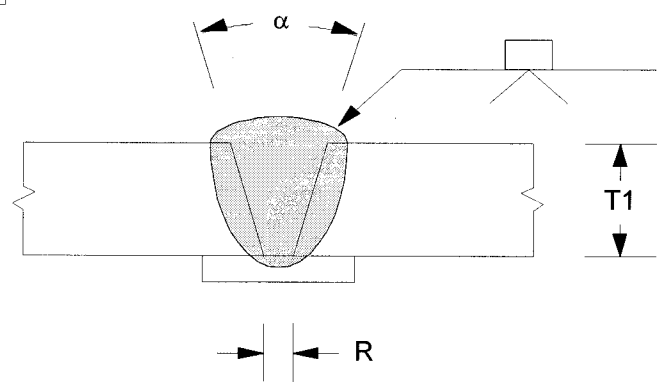


Welding Procedure Specification

GE-AWS D1.6 NO.1

Single-V-groove weld (2)
Butt joint (B)



Welding Process	Joint Designation	Base Metal Thickness (U=unlimited)	Groove Preparation				Permitted Welding Positions	Notes
			Root Opening	Groove Angle	Tolerances			
					As Detailed (see 3.13.1)	As Fit Up (see 3.13.1)		
SMAW	B-U2a	U	R=1/4	$\alpha = 45^\circ$	R = +1/16, -0 $\alpha = +10^\circ, -0^\circ$	+1/4, -1/16 +10°, -5°	All	X, N

MEMO

FOR WELDER QUALIFICATION TO THIS WPS, THE ROOT OPENING SHALL BE 1/4" AND THE GROOVE ANGLE SHALL BE 45 DEGS. TO QUALIFY FOR ALL POSITIONS, THE WELDER MUST WELD A 3G (VERTICAL) AND A 4G (OVERHEAD) TEST PLATE. NOTE FOR UNLIMITED THICKNESS QUALIFICATION THE TEST PLATE THICKNESS SHALL BE 1.0".