Company Name: Los Alamos National Laboratory By Kelly Bingham

Welding Procedure Specification Number: 1000-20 Ga spot-1 Galv.-1 Rev. 0
Date 1/15/2008

Supporting Procedure Qualification Test Record(s) No. 1000-1-20 Ga Spot1 Galv.

Welding Process(es) SMAW Type Manual
(Automatic, Manual, etc.)

Mode of Transfer for GMAW N/A
(Short Circuiting, Spray, etc.)

JOINTS (Table 4.1)

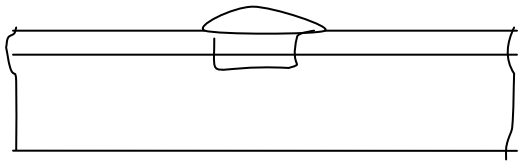
Type of Welding Joint(s) Arc Spot Weld
- Sheet to supporting Member Figure 4.6
Backing Yes ( ) No (X)
Backing Material Type N/A
Groove Welded From:
One side N/A both sides N/A

COATING(S)

Type Galvanized
Thickness 0.005

BASE METAL (1.2)

Material specification type and grade:
Sheet steel A1008 or A653.
Support Steel AWS D1.1 Table 3.1 Group 1&2
Thickness Range:
Sheet Steel 20 Gauge
Support Steel All
Thickness All
Base Metal Preparation Clean & dry



Sketch of Joint Details

FILLER METAL (Table 1.1)

Specification AWS 5.1
Classification E6010

POSITIONS (Table 1.2)

Position of Groove Flat
Position of Fillet F
Progression N/A

PREHEAT (1.1.1 AND 5.1)

Preheat Temperature Min N/A
Preheat Temperature Max N/A

GAS (1.4.6.2)

Shielding Gas N/A Flow Rate N/A
Percent Mixture N/A

FLUX (1.4.5.2) N/A

TECHNIQUE

Pass No.	Electrode Size	Welding Current		Travel Speed (or Weld Time for Arc Spot Welds)	Melting Rate	Wire Freed Speed
		Amperes	Volts			
1	E6010 1/8”	59.8 – 111.3	24 - 30	1.5 – 3.0 Sec.	6.0 / 10sec.	N/A

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in ANSI/AWS D1.3 (____98 & 08_____), Structural Welding Code-Sheet Steel.
(year)

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ML-1/2 projects or jobs must determine if the supporting documentation for this WPS complies with quality requirements of the project/job

Authorized by Signatures on file at ENG Date 3/23/2011

Form A-2