WELDING PROCEDURE SPECIFICATION

WPS- 6000-1 **REV. NO.:** 0 **DATE:** 9/1/2004 ****APPLICABILITY****

WELDING PROCESS/ES OFW **and** OFW **ASME:** **AWS:**

SUPPORTING PQ 600-1 **OTHER:**

JOINT **This WPS shall be used in conjunction with the General Welding Standards (GWS) and Welding Fabrication Procedure (WFP) sections and criteria for joint details, repairs, NDE, inspection etc.**

Weld Joint Type **Class:**

See GWS 1-06 for details **Preparation:**

Root Opening: **Backing:**

Backgrind root: **Backing Mat.:**

Bkgrd Method: **GTAW Flux:** **Backing Retainer:**

FILLER METALS: **Class:** **and**

A No: **SFA Class:** **and** **F No:** **and** **Size:**

Insert: **Insert Desc.:** **Weld Metal Thickness Range:**

Flux: Type: **Size:** **AWS:** **thru**

Filler Metal Note: **ASME:** **thru**

BASE MATERIAL **P No.** 1 **Gr No.** All **to: P No.** 1 **Gr No.** All

Spec. ASTM A-53 **Grade:** B **to: Spec.** ASTM A-53 **Grade:** B

Pipe Dia Range: **Groove >**

Thickness Range: **Groove :** **AWS:** **thru** **ASME:** 0.000 **thru** 0.188

QUALIFIED POSITIONS **Vertical Progression:**

Preheat Min. Temp.: **F** **GAS: Shielding:** **or**

Interpass Max. Temp. **F** **Gas Composition:** **%** **%** **%**

Preheat Maintinance: **F** **Gas Flow Rate cfh** **to**

Backing Gas/Comp: 0 **%**

PWHT: Time @ F Temp. **Backing Gas Flow cfh** **to**

Temp. Range: **F** **to** **F** **Trailing Gas/Comp:** **%**

PREPARED BY Kelly Bingham **DATE:** 9/1/2004

Signature on file at FWO-DECS

APPROVED BY Tobin Oruch **DATE:** 9/1/2004

Signature on file at FWO-DECS

Note:For SC/SS/ML-1/ML-2 work, this WPS requires independent review.

WPS NO: 6000-1

WELDING CHARACTERISTICS:

Current:	**and**	**Tungsten type:**		**Transfer Mode:**	N/A
Ranges: Amps	**to**			**Pulsing Cycle:**	**to**
Volts	**to**			**Background Current:**	
Fuel Gas:		**Flame:**		**Braze temp. F**	**to**

WELDING TECHNIQUE: **For cleaning, grinding, and inspection criteria refer to Volume 2, Welding Fabrication Procedures**

Technique:		**Cleaning Method:**	
Single Pass of Multi Pass:		**Stringer or Weave bead (S/W):**	**Oscillation:**
GMAW Gun Angle °:	**to**	**Forehand or Backhand for GMAW (F/B):**	
Maximum K/J Heat Input		**Travel speed/ipm:** **-**	**Gas Cup Size:**

PROCEDURE QUALIFIED FOR:

Charpy "V" Notch:	**Nil-Ductil Transition Temperature:**	**Dynamic Tear:**

Comments:

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel ipm	Nozzel Angle	Other
1	OFW							
2	OFW							
3								
4								
5								
6								
7								
8								

REM. *** Weld layers are representative only - actual number of passes and layer sequence may vary due to variations in joint design, thickness and fitup.**