

Company Name: Los Alamos National Laboratory By Kelly Bingham
 Welding Procedure Specification Number: 1000-20 Ga Spot2 Galv-1 Rev. 0 Date 1/15/08
 Supporting Procedure Qualification Test Record(s) No. 1000-1-20 Ga Spot2 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)

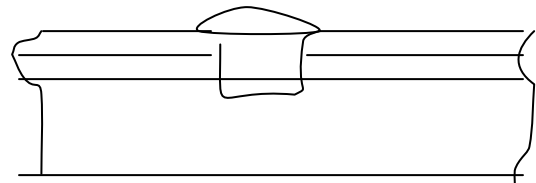
Type of Welding Joint(s) Arc Spot Weld
 - Sheet to supporting Member Figure 4.6
 Backing Yes () No (X)
 Backing Material Type N/A
 Groove Welded From:
 One side N/A both sides N/A

COATING(S)

Type Galvanized
 Thickness 0.005

BASE METAL (1.2)

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



FILLER METAL (Table 1.1)

Specification AWS 5.1
 Classification E6010

Sketch of Joint Details

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 Feed Speed
		Amperes	Volts			
1	E6010 1/8"	176 - 194	26 - 34	9 - 17 Sec	6.0 / 13sec.	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)

Welding Procedure Specification Number: 1000-20Ga Spot2 Galv-1 Rev. 0 Page 2 of 2

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