



WELDING PROCEDURE SPECIFICATION

WPS: 1000-xxxx-1/5A

REV. NO.: 1

DATE: 1/30/2006

APPLICABILITY

WELDING PROCESS: SMAW and SMAW

CODE: ASME IX

OTHER:

SUPPORTING PQR: 100-1/5

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: Butt/Fillet**Class:** Full & Partial Penetration & Fillets**See GWS 1-06 and WFP's for joint details.****Preparation:** Thermal/Mechanical**Root Opening:** 1/8 - 3/16**Backing:** With/without single sided**Backgrind Root:** On double sided joints**Backing Mat.:** CS strap/ring when used**Bkgrd Method:** Grind/chip**GTAW Flux:** N/A**Backing Retainer:** N/A**FILLER METALS:****Class:** E9018 and E10018**A No:** 4**SFA Class:** 5.5 and 5.5**F No:** 4 and N/A**Size:** 3/32 1/8 5/32**Insert:** N**Insert Type:** N/A**Weld Metal Thickness Ranges:****Flux:** Type: N/A**Size:** N/A**AWS Root Pass:****AWS Balance:** 0 thru 0**ASME Root Pass:****ASME Balance:** 0.187 thru 8**Filler Material Note:** E-8018M electrodes may also be used.**BASE MATERIAL:****P No:** 1**Gr No.:** N/A**to P No.:** 5A**Gr No.:** N/A**Spec.:** A-516 CS- Plate**Grade:** All**to Spec.:** A-387 AS- Plate**Grade:** 65**Qualified Pipe Dia. Range:** >=**AWS:** 24**ASME:** 0**Qualified Thickness Range:****AWS:** 0 thru 0**ASME:** 0.187 thru 8**QUALIFIED POSITIONS:****AWS:** All**ASME:** N/A**Vert. Prog.:** V/Up**Preheat Min. Temp.:** 300**GAS: Shielding:** N/A or N/A**Interpass Max. Temp.:** 500 °F**Gas Composition:** 0 / 0 / 0 % 0 / 0 / 0 %**Preheat Maintenance:** 300 °F**Gas Flow Rate cfh:** 0 to 0 0 to 0**PWHT: Time @ °F Temp.:** 0**Backing Gas/Comp:** N/A 0 %**Temperature Range:** N/A °F to N/A °F**Backing Gas Flow cfh:** 0 to 0**Trailing Gas/Comp:** N/A 0 %**WELDING CHARACTERISTICS:****Current:** DCEP and N/A**Tungsten Type:** N/A**Transfer Mode:** N/A**Ranges:** Amps: 70 to 205**Tungsten Dia.:****Pulsing Cycle:** 0 to 0

Volts: 18 to 23

Background Current: 0**Fuel Gas:** N/A**Flame:** N/A**Braze Temp °F:** N/A to N/A

WELDING TECHNIQUE: For fabrication specific requirements such as fitup, cleaning, grinding, PWHT and inspection criteria, refer to Volume 2, Welding Fabrication Procedures.

Technique: Manual**Cleaning Method:** Wire Brush, File, Grind, Chip**Single or Multi Pass:** M**Stringer or Weave Bead (S/W):** S**Oscillation:** N/A**GMAW Gun Angle:** 0 ° to 0 °**Forehand or Backhand for GMAW:** N/A**No Pass > 1/2":** True**GMAW/FCAW Tube to Work Distance (in):** N/A**Maximum K/J Heat Input:** N/A KJ/in**Travel Speed:** Variable**Gas Cup Size:** N/A**PROCEDURE QUALIFIED FOR:****Charpy "V" Notch:** N/A**Nil-Ductile Transition Temperature:** N/A**Dynamic Tear:** N/A

Comments: No comments.

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel/ipm	Nozzle Angle	Other
1	SMAW	E9018	3/32	70 to 95	18 to 23	5 to 8	0 to 0	
2	SMAW	E10018	1/8	125 to 160	18 to 23	5 to 8		
3	SMAW	E10018	5/32	140 to 205	18 to 23	5 to 8		
4	SMAW	E10018		140 to 205	18 to 23	5 to 8		

REM. * Weld layers are representative only - actual number pf passes and layer sequence may vary.

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

Use of LANL Welding Procedures and Welder Qualifications for non-LANL work shall be at the sole risk and responsibility of the Subcontractor, and the Subcontractor shall indemnify and save LANL and the Government harmless from any and all claims, demands, actions or causes of action, and for any expense or loss by the reason of Subcontractor's and their employees posession and use of LANL procedures and qualifications.

APPROVAL: Signatures on file at ES-FE

DATE: 1/30/2006