Los Alamos NATIONAL LABORATORY

WELDING PROCEDURE SPECIFICATION

WPS: 1000-xxxx-4140 **REV. NO.:** 1 **DATE:** 4/20/2005 ****APPLICABILITY****
WELDING PROCESS: SMAW **and** SMAW **CODE:** ASME IX **OTHER:**
SUPPORTING PQR: 100-4140

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: 3/32 - 1/4 **Backing:** With/without single sided
Backgrind Root: On double sided joints **Backing Mat.:** Mild steel strap/ring
Bkgrd Method: Grind or Carbon arc **GTAW Flux:** N/A **Backing Retainer:** N/A

FILLER METALS: **Class:** E9018 **and** E9018
A No: 4 **SFA Class:** 5.5 **and** 5.5 **F No:** 4 **and** 4 **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:**
Filler Material Note: No bead or pass shall be greater than 1/2"in thickness. **AWS Balance:**
ASME Root Pass:
ASME Balance: 0.062 **thru** 0.75

BASE MATERIAL:

	P No: N/A	**Gr No.:** 0	**to P No.:** N/A	**Gr No.:** 0
Spec.: AISI 4140 AS- Pipe, plate, bar & sheet	**Grade:** 0	**to Spec.:** AISI 4140 AS- Pipe, plate, bar & sheet		**Grade:** 0
Qualified Pipe Dia. Range: >=	**AWS:** 0	**ASME:** 2.5		
Qualified Thickness Range:	**AWS:**	**ASME:** 0.062 **thru** 0.75		

QUALIFIED POSITIONS: **AWS:** 1G, 1F, 2F **ASME:** All **Vert. Prog.:** V/Up

Preheat Min. Temp.:	350	**GAS: Shielding:** N/A	**or**	N/A
Interpass Max. Temp.:	500 **°F**	**Gas Composition:** 0 / 0 / 0 %		0 / 0 / 0 %
Preheat Maintenance:	350 **°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** DCEP	**Tungsten Type:** N/A	**Transfer Mode:** N/A	
Ranges: **Amps:** 70	**Tungsten Dia.:**	**Pulsing Cycle:** 0 **to** 0	
Volts:		**Background Current:** 0	
Fuel Gas: N/A	**Flame:** N/A	**Braze Temp °F:**	

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":	**GMAW/FCAW Tube to Work Distance (in):** 0		
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			0 **to** 0	
2	SMAW	E9018	1/8	125 **to** 160				
3	SMAW	E9018	5/32	140 **to** 205				
4	SMAW	E9018						

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:** 4/20/2005