



**PROCEDURE QUALIFIED FOR:**

Charpy "V" Notch: \*Y

Nil-Ductile Transition Temperature: N/A

Dynamic Tear: N/A

**Comments:** 1) Peening is not allowed. 2) \*Contact ENG DECS Welding Program Manager or Welding Engineer/SME if procedure is used on impact tested materials. 3) Use of RG 65 wire is limited to sheet steel, 10 gage and thinner.

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel/ipm	Nozzle Angle	Other
1	GTAW	ER70S-X	.045	35 to 80			0 to 0	
2	GTAW	ER70S-X	.062	65 to 100				
3	GTAW	ER70S-X	.093	80 to 120				
4	GTAW	ER70S-X	1/8	95 to 140				

**REM. \* Weld layers are representative only - actual number of 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 possession and use of LANL procedures and qualifications.

**APPROVAL:** Signatures on file at ES-DE

**DATE:** 7/22/2005