Los Alamos NATIONAL LABORATORY

WELDING PROCEDURE SPECIFICATION

WPS: 2010-xxxx-8 **REV. NO.:** 1 **DATE:** 9/8/2005 ****APPLICABILITY****

WELDING PROCESS: GTAW **and** GTAW **CODE:** ASME IX **and** AWS **OTHER:**

SUPPORTING PQR: P-WS-4-2 Z-WS-6 Z-WS-1-A Z-WS-1B Z-WS-1C P-WS-197-2 P-WS-199-2

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: 0 - 1/8 **Backing:** Gas/ring/back welding

Backgrind Root: Double sided joints **Backing Mat.:** SS when used

Bkgrd Method: Grind when required **GTAW Flux:** N/A **Backing Retainer:** N/A

FILLER METALS: **Class:** ER2xx/3xx-x **and** ER2xx/3xx-x

A No: 8 **SFA Class:** 5.9 **and** 5.9 **F No:** 6 **and** 6 **Size:** 1/16 3/32 1/8 1/8

Insert: Y* **Insert Type:** EBR Type "A" **Weld Metal Thickness Ranges:**

Flux: **Type:** N/A **Size:** N/A **AWS Root Pass:** 0.03 **thru** 0.75

Filler Material Note: *Use of consumable insert (EBR) is optional **AWS Balance:** 0.03 **thru** 0.75

ASME Root Pass: 0.03 **thru** 0.075

ASME Balance: 0.03 **thru** 0.75

BASE MATERIAL:

	P No: 8	**Gr No.:** All	**to P No.:** 8	**Gr No.:** All
Spec.: A-240 SS- Plate, sheet & strip	**Grade:** All	**to Spec.:** A-240 SS- Plate, sheet & strip		**Grade:** All
Qualified Pipe Dia. Range: >=	**AWS:** 0.75	**ASME:** 0.125		
Qualified Thickness Range:	**AWS:** 0.03 **thru** 0.75	**ASME:** 0.03 **thru** 0.75		

QUALIFIED POSITIONS: **AWS:** All **ASME:** All **Vert. Prog.:** Up

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Preheat Min. Temp.:	50	**GAS: Shielding:** Argon	**or**
Interpass Max. Temp.:	350 **°F**	**Gas Composition:** 100 / / %	0 / 0 / 0 %
Preheat Maintenance:	50 **°F**	**Gas Flow Rate cfh:** 15 **to** 25	0 **to** 0
PWHT: Time @ °F Temp.:	N/A	**Backing Gas/Comp:** Argon	100 **%**
Temperature Range:	N/A **°F to** N/A **°F**	**Backing Gas Flow cfh:** 5 **to** 8	
		Trailing Gas/Comp: N/A	0 **%**

WELDING CHARACTERISTICS:

Current:	DCEN **and** DCEN	**Tungsten Type:** EWTh-2		**Transfer Mode:** N/A	
Ranges:	**Amps:** 50 **to** 180	**Tungsten Dia.:** .065 **to** 1/8		**Pulsing Cycle:** 0 **to** 0	
	Volts: 10			**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		
Single or Multi Pass:	M	**Stringer or Weave Bead (S/W):** S/W	**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):** N/A		
Maximum K/J Heat Input:	N/A **KJ/in**	**Travel Speed:** Varies	**Gas Cup Size:** Varies	

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	GTAW	ER2xx/3xx-x	1/16	50 **to** 70	10 **to** 14	4 **to** 8	0 **to** 0	
2	GTAW	ER2xx/3xx-x	3/32	90 **to** 150	12 **to** 16	6 **to** 10		
3	GTAW	ER2xx/3xx-x	1/8	130 **to** 180	16 **to** 18	10 **to** 12		
4	GTAW	ER2xx/3xx-x	1/8					

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:** 9/7/2005