



WELDING PROCEDURE SPECIFICATION

WPS: 3012-xxxx-8-SC

REV. NO.: 1

DATE: 8/16/2006

APPLICABILITY

WELDING PROCESS: GMAW and GMAW

CODE: ASME IX

OTHER:

SUPPORTING PQR: 3011-8

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/Groove/Fillet**Class:** Full & Partial Penetration & Fillets**See GWS 1-06 and WFP's for joint details.****Preparation:** Thermal or Mechanical**Root Opening:** 0 - 1/16**Backing:** Gas**Backgrind Root:** N/A**Backing Mat.:** Argon**Bkgd Method:** N/A**GTAW Flux:** N/A**Backing Retainer:** N/A**FILLER METALS:****Class:** ER308L and ER308L**A No:** 8**SFA Class:** 5.9 and 5.9**F No:** 6 and 6**Size:** .035 .035 .035 .035**Insert:** N/A**Insert Type:** N/A**Weld Metal Thickness Ranges:****Flux:** Type: N/A**Size:** N/A**AWS Root Pass:****AWS Balance:****ASME Root Pass:** 0.060 thru 0.187**ASME Balance:** 0.060 thru 0.205**BASE MATERIAL:****Spec.:** A-240 SS- Plate, sheet & strip**P No:** 8**Gr No.:** all**to P No.:** 8**Gr No.:** all**Qualified Pipe Dia. Range:** >=**Grade:** 304**to Spec.:** A-240 SS- Plate, sheet & strip**Grade:** 304**Qualified Thickness Range:****AWS:** 0**ASME:** 0.25**AWS:****ASME:** 0.06 thru 0.205**QUALIFIED POSITIONS:****AWS:** All**ASME:** All**Vert. Prog.:** Up**Preheat Min. Temp.:** 50**GAS: Shielding:** Ar/CO2/O2**or** Ar/CO2/O2**Interpass Max. Temp.:** 350 °F**Gas Composition:** 75 / 20 / 5 %

75 / 20 / 5 %

Preheat Maintenance: 50 °F**Gas Flow Rate cfh:** 20 to 30

20 to 25

PWHT: Time @ °F Temp.: N/A**Backing Gas/Comp:** Argon

100 %

Temperature Range: N/A °F to N/A °F**Backing Gas Flow cfh:** 1 to 10**Trailing Gas/Comp:** N/A

0 %

WELDING CHARACTERISTICS:**Current:** DCEP and DCEP**Tungsten Type:** N/A**Transfer Mode:** Short Circuit**Ranges:** Amps: 85 to 130**Tungsten Dia.:** N/A to N/A**Pulsing Cycle:** 0 to 0

Volts: 15 to 18

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: Semi-Automatic**Cleaning Method:** Wire Brush or grinder**Single or Multi Pass:** S or M**Stringer or Weave Bead (S/W):** S or W**Oscillation:** N/A**GMAW Gun Angle:** 0 ° to 15 °**Forehand or Backhand for GMAW:** Backhand**No Pass > 1/2":** True**GMAW/FCAW Tube to Work Distance (in):** 1/2"-3/4'**Maximum K/J Heat Input:** N/A KJ/in**Travel Speed:** As required**Gas Cup Size:** 1/2 - 3/4**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	GMAW	ER308L	.035	85 to 110	15 to 17	9 to 12	0 to 15	
2	GMAW	ER308L	.035	85 to 110	15 to 17	9 to 12		
3	GMAW	ER308L	.035	85 to 110	15 to 17	9 to 12		
4	GMAW	ER308L	.035	85 to 130	15 to 18	9 to 12		

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: 8/16/2006