Los Alamos NATIONAL LABORATORY

WELDING PROCEDURE SPECIFICATION

WPS: 7000-xxxx-PVDF-Hot Gas **REV. NO.:** 0 **DATE:** 10/18/2012 ****APPLICABILITY****
WELDING PROCESS: TF **CODE:** ANSI B31.3 **OTHER:**
SUPPORTING PQR: 7000-xxxx-PVDF-HG

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 **Class:** Full thermal fusion
See GWS 1-06 and WFP's for joint details. **Preparation:** Machined Bevel 37.5° Feather Edge to =1/32"
Root Opening: N/A **Backing:** N/A
Backgrind Root: N/A **Backing Mat.:** None
Bkgrd Method: N/A **GTAW Flux:** N/A **Backing Retainer:** N/A

FILLER METALS:
A No: N/A **SFA Class:** N/A **and** N/A **Class:** N/A **and** N/A
Insert: No **Insert Type:** N/A **F No:** N/A **and** N/A **Size:** 1/8
Flux: **Type:** N/A **Size:** N/A **Weld Metal Thickness Ranges:**
Filler Material Note: Filler material is PVDF in 18" dia. rod form **AWS Root Pass:**
AWS Balance:
ASME Root Pass:
ASME Balance: .115 **thru** .462

BASE MATERIAL:

	P No: N/A	**Gr No.:**	**to P No.:** N/A	**Gr No.:**
Spec.: PVDF- pipe	**Grade:**	**to Spec.:** PVDF- pipe		**Grade:**
Qualified Pipe Dia. Range: >=	**AWS:**	**ASME:** 2		
Qualified Thickness Range:	**AWS:**	**ASME:**		

QUALIFIED POSITIONS: **AWS:** N/A **ASME:** All **Vert. Prog.:** Down/Up

Preheat Min. Temp.:	300	**GAS: Shielding:** N/A	**or**	N/A
Interpass Max. Temp.:	400 **°F**	**Gas Composition:** N/A / N/A / N/A %		N/A / N/A / N/A %
Preheat Maintenance:	350 **°F**	**Gas Flow Rate cfh:**		
PWHT: Time @ °F Temp.:		**Backing Gas/Comp:** N/A		N/A **%**
Temperature Range:	N/A **°F to** N/A **°F**	**Backing Gas Flow cfh:**		
		Trailing Gas/Comp: N/A		N/A **%**

WELDING CHARACTERISTICS:
Current: N/A **and** N/A **Tungsten Type:** N/A **Transfer Mode:** N/A
Ranges: **Amps:** **Tungsten Dia.:** N/A **to** N/A **Pulsing Cycle:**
Volts: **Background Current:**
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: Thermal fusion **Cleaning Method:** Abrasive cloth, file, alcohol
Single or Multi Pass: S or M **Stringer or Weave Bead (S/W):** N/A **or** N/A **Oscillation:** N/A
GMAW Gun Angle: **Forehand or Backhand for GMAW:** N/A
No Pass > 1/2": N/A **GMAW/FCAW Tube to Work Distance (in):** N/A
Maximum K/J Heat Input: **Travel Speed:** **Gas Cup Size:** N/A

PROCEDURE QUALIFIED FOR:
Charpy "V" Notch: No **Nil-Ductile Transition Temperature:** No **Dynamic Tear:** No

Comments: WPS is with hot air. Air is at 350 degrees F to 400 degrees F. Weld is completed with a hot air welding torch

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel/ipm	Nozzle Angle	Other
1	TF	N/A	1/8					
2		N/A						
3		N/A						
4		N/A						

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:**