

WELDING PROCEDURE SPECIFICATION

WELDING PROCEDURE NO. WPS-001

WELDING POSITION: ALL POSITIONS

WELDING PROCESS: SMAW

WELDING METAL: ER70S-3

WELDING SPEED: 10-15 IPM

WELDING CURRENT: 100-125 AMP

WELDING VOLTAGE: 18-22 V

WELDING PREHEAT: 150-200 F

WELDING INTERPASS TEMPERATURE: 150-200 F

WELDING POSTHEAT: 250-300 F

WELDING INSPECTION: 100% VISUAL

WELDING QUALITY CONTROL: ASME SECTION IX

WELDING QUALITY ASSURANCE: AWS D1.1

WELDING QUALITY CONTROL PLAN: WQCP-001

WELDING QUALITY CONTROL RECORD: WQCR-001

WELDING QUALITY CONTROL REPORT: WQCR-001

WELDING QUALITY CONTROL CERTIFICATE: WQCC-001

WELDING QUALITY CONTROL PLAN: WQCP-001

WELDING QUALITY CONTROL RECORD: WQCR-001

WELDING QUALITY CONTROL REPORT: WQCR-001

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