Welding Procedure Specification (WPS)

Sheet 1 of 3

N/A

N/A

ASME Boiler and Pressure Vessel Code , Section IX

Company Name: www.WPSAmerica.com

Company Address: info@WPSAmerica.com, 1 (877) WPS-WELD

Welding Procedure Specification WPS No.: DEMO-WPS Revision No.: (0) Supporting PQR No. (s): DEMO-PQR Date: 12,12, 2005

BASE METALS (QW-403) Group No.: 1 Material Specification: SA-335 Type or Grade: P11

P-No.: 4 Welded to

Group No.: 1 Material Specification: SA-234 Type or Grade: WP11, Class 1 P-No.: 4

Chem. Analysis and Mech. Prop. N/A Welded to Chem. Analysis and Mech. Prop.

Qualified Thickness Range mm (in) Groove: 5 mm (3/16 in.) to 60 mm (2.36 in.) Fillet: Unlimited

Qualified Diameter Range mm (in) Groove: All Sizes Other information: This is a DEMO WPS from www.WPSAmerica.com Fillet: Unlimited

Welding Process (es): FILLER METALS (QW-404) WS Classification Slectrode-Flux Class (SAW) SFA Specification Siller Metal F-No.	Gas Tungsten Arc Welding (GTAW) Manual ER80S-G (see sheet 3) SFA 5.28	Shielded Metal Arc Welding (SMAW) Manual E8016-B2 (see sheet 3)
FILLER METALS (QW-404) WS Classification Electrode-Flux Class (SAW) FFA Specification	ER80S-G (see sheet 3)	
AWS Classification Electrode-Flux Class (SAW) SFA Specification		E8016-B2 (see sheet 3)
AWS Classification Electrode-Flux Class (SAW) SFA Specification		E8016-B2 (see sheet 3)
Electrode-Flux Class (SAW) SFA Specification		E8016-B2 (see sheet 3)
	SEA 5 28	(See Silver b)
Filler Metal F-No.	SFA 5.20	SFA 5.5
	6	4
Weld Metal Analysis A-No.	_	3
Size of Filler Metals mm (in)	2.0 mm (see sheet 3)	3.25 mm (see sheet 3)
Filler Metal Product Form	Solid copper coated wire	Iron powder low hydrogen
Max. Weld Pass Thickness mm (in)	1/8 in.	3/16 in.
Qualified Weld Metal Range: Groove mm (in)	10 mm (3/8 in.)	60 mm (2.36 in.)
Qualified Weld Metal Range: Fillet mm (in)	Unlimited	Unlimited
Weld Deposit Chemistry	_	_
Flux Trade Name and Flux Type (SAW)	N/A	N/A
Consumable Insert, Class and Size	_	_
Other information: This is a DEMO WPS from www.WPSAmer	rica.com	
POSITIONS (QW-405)		
Position (s) of Groove	ALL Position	ALL Position
Welding Progression	Up	Up
Position (s) of Fillet	ALL Position	ALL Position
PREHEAT (QW-406)		
Preheat Temp. °C (°F)	150 °C	150 °C
interpass Temp. Max. °C (°F)	280 °C	280 °C
Preheat Maintenance °C (°F)	New Joint	New Joint

100% Ar 7 to 9 lt/min. N/A

N/A

Flow Rate It/min. (CFH)
Gas Backing (Mixture)
Flow Rate It/min. (CFH)

Shielding Gas Type (Mixture)
Flow Rate lt/min. (CFH)
Trailing Gas Type (Mixture)

POSTWELD HEAT TREATMENT (QW-407) Holding Temperature Range °C (°F): 680 °C + or - 10 °C Heating Rate °C/hr (°F/hr): 120 °C/hr Holding Time Range: 1 hr/ in. (15 minutes Min.)

Method: Furnace

Cooling Rate °C/hr (°F/hr): 120 °C/hr Method: Open Air