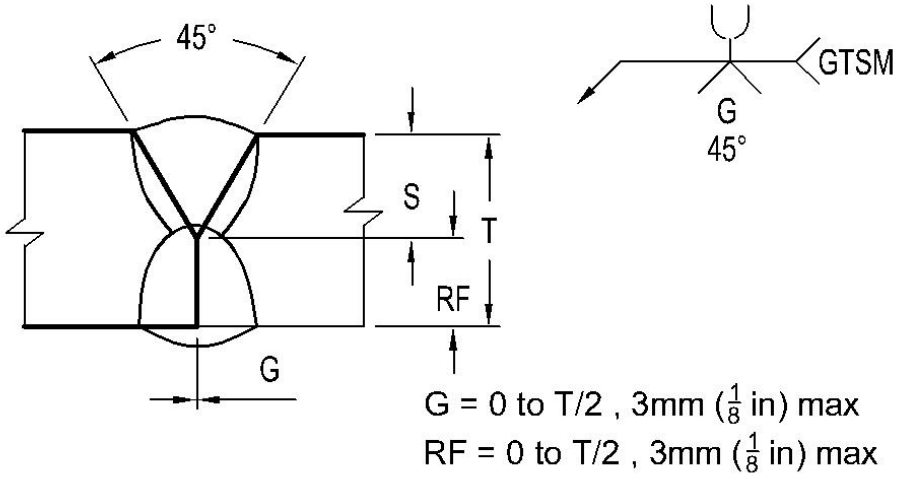
Prepared by: WPSAmerica.com	WELDING PROCEDURE SPECIFICATION (WPS)		Identification #	DEMO-GMAW
			Ref. Code	AWS D1.6
Company Name: *www.WPSAmerica.com* Address: *info@WPSAmerica.com, Toll Free: 1 (877) WPS-WELD*			PQR No.	PREQUALIFIED
Process GMAW	**Process Type**	Semi-Automatic	**Position**	Flat
Base Metals	Austenitic Stainless Steel Alloy Grades 304, 304L, 316 or 316L of Group A or B of Table 3.2-AWS D1.6			
Filler Metals	AWS A5.9: ER308L; ER308LSi; ER308; ER308Si; ER316L; ER316LSi; ER316; ER316Si			
Shielding Gas **Flux (SAW)**	Ar+ 2% CO2 (Or) Ar+ 2% O2		**Flow Rate**	30-45 CFH
			Nozzle Dia.	5/8 in
Weld Type	Complete Joint Penetration Groove Weld		Current/ Polarity	DCEP
Electrical Stick Out **ESO (in)**	5/8 to 3/4	**Preheat / Interpass Temp., Min**	To free surfaces from moisture, Max Interpass 175 °C (350 °F)	

Joint Details/ Joint Design Used/ Sketch:



B-U2-GF

GTSM : Gouging To Sound Metal before welding from the other side

Welding Procedure:

Thickness (T) mm (in)	Weld Size ETT (E)	Side	Weld Layers	Pass No.	Filler Metal Diameter mm (in)	Current Amps	Volts	Wire Feed Speed (IPM)	Travel Speed (IPM)
T<=6 mm (1/4) T>=6 mm (1/4) T>=6 mm (1/4) T>=10 mm (3/8)	T	1 and 2	Root, Fill, Cap	As Required, see notes	1.6 mm (0.062, 1/16)	260-310	25-28	175-200	10 to 20
						310-330	26-29	200-250	
						330-360	27-31	250-275	
						360-390	28-32	275-300	

Notes, Technique or Code's rules:
-Transfer Mode: Spray
-For low or high temp., corrosive or any critical applications always confirm wire choice with manufacturer.
-Shielding gases shall conform to AWS A5.32/A5.32M
-For similar metal joints, use filler metal of matching composition, (e.g.: weld 304L with 308L wire), (316 with 316, and 316L with 316L wire).
-Dissimilar joining, use the lower alloyed of the two base metals, (e.g. use 308 to join 304 to 316).
-If both metals are low carbon (3XXL), then use 3XXL filler metal as well.
-Maximum thickness of layer is 5 mm (3/16) for root pass and 6 mm (1/4) for subsequent layers.
-The minimum size of a root pass shall be sufficient to prevent cracking.

Originated by:

John Smith, Welding Engineer

Date: 04, 29, 2005 Revision (1)

Authorized by:

Jim Clark, Quality Manager

Date: 04, 29, 2005