

Welding Procedure Specification (WPS)

Sheet 1 of 3

Code: AWS D14.1

Company Name: Precision Cut Industries

Identification #:

1401 Rev.1

Address: 115 Ram Dr, Hanover, Pennsylvania, 17331, USA

WPS Prequalified:

Yes

Welding Process:

GMAW

Process Type:

Semi-Automatic

Position (s):

Flat, Horizontal

Supporting PQR No.(s):

N/A

Base Metal Part I (Material Spec., type or grade):

ASTM A 572 Grade 50

Base Metal Part II (Material Spec., type or grade):

ASTM A 572 Grade 50

Qualified Thickness and Diameter (Pipe) Range:

Groove (Fillet): mm (in)

.125- Unlimited

Filler Metals:

AWS Classification/AWS Specification:

ER70S-6

A5.18

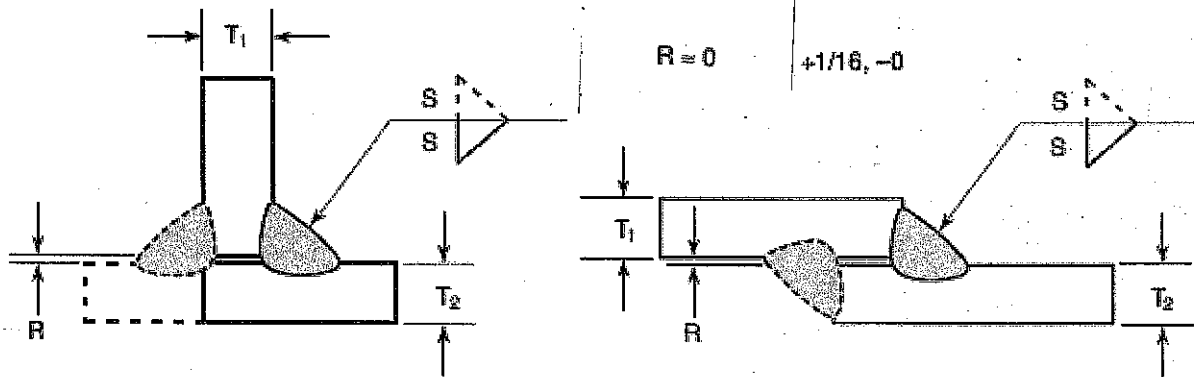
Joint Details/Sketch:

Fillet weld (12)

T-joint (T)

Corner joint (C)

Lap joint (L)



Joint Design Used: mm (in)

Root Opening G: N/A

Root Face RF: N/A

Groove Angle: N/A

Radius (J-U):

Weld Type:

Fillet Weld

Joint Type:

Lap Joint

Corner Joint

Tee Joint

Backing Option:

N/A

Backing Material:

N/A

Back Gouging Method:

N/A