

METALS INSPECTION SERVICES, INC.

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QW - 482 SUGGESTED FORMAT FOR WELDING PROCEDURE SPECIFICATION (WPS)

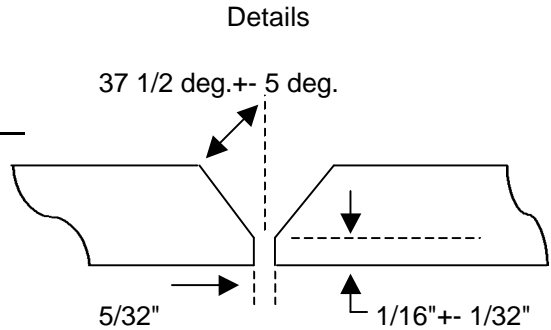
(See QW - 200.1(d), Section IX, ASME Boiler and Pressure Vessel Code)

Company Name: Dooley Tackaberry By _____
 Welding Procedure Specification No. GMAW - SMAW - P1 Date 2/16/2001
 Revision Number _____ Date _____ Supporting PQR No.(s) GMAW - SMAW - P1
 Welding Process (es) Gas Metal Arc Welding; Shielded Metal Arc Welding Type(s) Semi - Auto, Manual
 (Automatic, Manual, Machine, or Semi-Auto)

JOINTS (QW - 402)

Joint Design: Single - V - Groove
 Backing: Yes No Material _____
 Root Opening: 5/32" +- 1/32" Retainers: Yes _____ No

Sketches, Production Drawing, welding Symbols or Written Description should show the general arrangement of the part to be welded. Where applicable, the root spacing and details of the weld groove may be specified. (At the option of the Mfg., sketches may be attached to illustrate joint design, weld layers and bead sequence, e.g. for notch toughness procedures, for multiple process procedures, etc.)



BASE METALS (QW - 403)

Specification No. SA 106 Grade B P-No. 1 Group No. 1
 To Specification No. SA 106 Grade B P-No. 1 Group No. 1
 Or Other Materials of P- No. 1
 Chemical Analysis and Mechanical Properties _____
 To Chemical Analysis and Mechanical Properties _____
 Thickness Range: .438" Deposited weld Metal Range:
 Base Metal: Groove .187" - .864" Process: GMAW Maximum .250"
 Fillet All Sizes and Diameters Process: SMAW Maximum .614"
 Pipe Diameter Range Groove: Procedure Unlimited Process: _____ Maximum _____
 Other: Diameter Range & Thickness Range established by attached PQR's
No pass Greater than 1/2" in Thickness.

FILLER METALS (QW - 404)

Process (es)	<u>GMAW</u>	<u>SMAW</u>	_____
F - No.	<u>6</u>	<u>4</u>	_____
A - No.	<u>1</u>	<u>1</u>	_____
Spec. No.(SFA)	<u>5. 18</u>	<u>5.1</u>	_____
AWS No. (class)	<u>ER70S-6</u>	<u>E 7018</u>	_____
Dia. of filler metals	<u>.035"</u>	<u>3/32"- 1/8"</u>	_____
Tungsten Size: <u>N/A</u> Type: <u>N/A</u>	Class: _____	SFA No. _____	_____
Electrode - Flux (class)	Flux Trade Name: _____	_____	_____
Impact Specimens: Test Temperature _____	Average Ft /Lb. _____	Min. Ft/Lb. _____	_____
Consumable Insert _____	GTAW: Addition of Filler _____	Yes _____ No _____	_____
Other: _____	_____	_____	_____

Contractor's Specification

(Electrode, Code Wire, Hot Wire, etc.)

Each base metal-filler combination should be recorded individually. This form modified for information and typing purposes.(QW-200.1(d))

