

WELDING PROCEDURE SPECIFICATION (WPS) Yes ☐
 PREQUALIFIED ☒ QUALIFIED BY TESTING _____
 or PROCEDURE QUALIFICATION RECORDS (PQR) Yes ☐

Company Name UNITED IRON INC
 Welding Process(es) SMAW
 Supporting PQR No.(s) PREQUALIFIED

Identification # _____
 Revision _____ Date _____ By TED VALLEY, PE
 Authorized by _____ Date _____
 Type—Manual ☒ Semiautomatic ☐
 Mechanized ☐ Automatic ☐

JOINT DESIGN USED

Type: FLUET WELD
 Single ☐ Double Weld ☒
 Backing: Yes ☐ No ☒
 Backing Material: _____

Root Opening _____ Root Face Dimension _____
 Groove Angle: N/A Radius (J-U) _____
 Back Gouging: Yes ☐ No ☐ Method _____

BASE METALS

Material Spec. A5TM
 Type or Grade A36, A572 GR 50
 Thickness: Groove _____ Fillet 1/4"
 Diameter (Pipe) _____

FILLER METALS

AWS Specification AWS A5.1
 AWS Classification E70XX

E7018 OR BETTER

SHIELDING

Flux ☒ Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

PREHEAT

Preheat Temp., Min. 50°F
 Interpass Temp., Min. 65°F Max. 350°F

POSITION

Position of Groove: _____ Fillet: ALL
 Vertical Progression: Up ☐ Down ☐

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW) _____ Short-Circuiting ☐
 Globular ☐ Spray ☐
 Current: AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐
 Power Source: CC ☐ CV ☐
 Other _____
 Tungsten Electrode (GTAW)
 Size: _____
 Type: _____

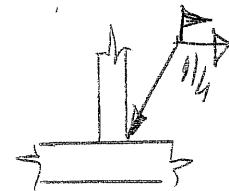
TECHNIQUE

Stringer or Weave Bead: STRINGER OR WEAVER
 Multi-pass or Single Pass (per side) SINGLE
 Number of Electrodes _____
 Electrode Spacing _____ Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening NOT ALLOWED
 Interpass Cleaning: METAL WIRE BRUSH

POSTWELD HEAT TREATMENT

Temp. _____
 Time _____

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			
<u>SINGLE</u>	<u>SMAW</u>	<u>E7018</u>	<u>1/8"</u>	<u>DCEP</u>	<u>140-180 A</u>	<u>20-22V</u>	<u>5-10</u>	

Form N-1 (Front)

JOB Barr Middle School
Roof reinforcements

LOCATION: 50 Blauvelt Rd #1 Nanuet, NY
10954