



**ELECTRICAL CHARACTERISTICS (QW-409)**

Details may be shown on Table below

	FIRST PROCESS	SECOND PROCESS
Current/ Polarity	DCEN	DCEP
Amps (Range)	90 to120	100 to 130
Volts (Range)	18 to 25	20 to 28
Wire Feed Speed (Range) mm/min (in/min)	-	-
Travel Speed (Range) mm/min (in/min)	Manual control	Manual control
Mode of Metal Transfer for GMAW	N/A	N/A
Tungsten Electrode Size mm (in)	2.5 mm	-
Tungsten Type	SFA 5.12 EWTh-2	-

**TECHNIQUE (QW-410)**

String or Weave Bead	String Bead	String and Weave Bead
Multiple or Single Electrodes	Single	Single
Multiple or Single Pass (per side)	Multiple	Multiple
Orifice or Gas Cup Size	5/8 in. Nozzle Size	-
Contact Tube to Work Distance mm (in)	-	-
Initial and Interpass Cleaning	Brushing	Brushing and Grinding
Method of Back Gouging	n/a	n/a
Oscillation	-	-
Peening	Not Required	Not Required

Other information: Clean each layer before start welding new passes/layers

**JOINTS (QW-402)**

Joint Design: Single-Vee groove weld Backing Type: No Backing Backing Material (Refer to both backing and retainers.): n/a

Joint Details/ Sketch: Groove Details (or as per production drawing): Root Opening G: 2 to 3 mm Root Face RF: 1.5 mm Groove Angle: 75 ° Radius (J-U): n/a

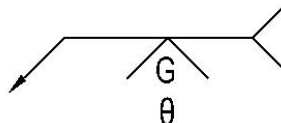
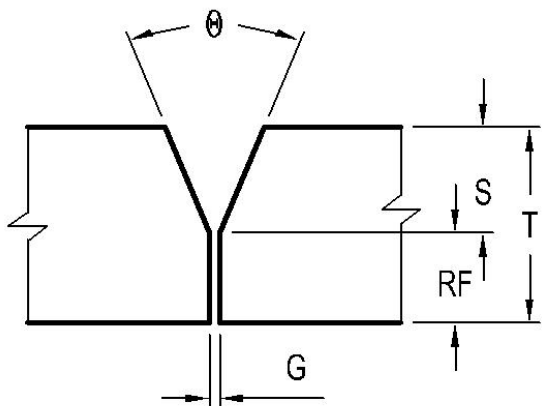


Table for recorded information; Refer to QW-409

Weld Layer(s)	Pass No. (s)	Process	Filler Metal Classification	Filler Size Diameter mm (in)	Current Amps Range	Current Type & Polarity	Wire Feed Speed Range mm/min (in/min)	Volts Range	Travel Speed Range mm/min (in/min)	Max. Heat Input kJ/mm (kJ/in) Or Remarks
1	1	GTAW	ER80S-G	2.0 mm	90-120	DCEN	n/a	18-25	-	Root Pass
2	2 to 3	GTAW	ER80S-G	2.0 mm	90-120	DCEN	n/a	18-25	-	
3 to n	4 to n	SMAW	E8016-B2	3.25 mm	100-130	DCEP	n/a	20-28	-	Fill and Cap Passes

Additional Notes: This is a Demo WPS from WPSAmerica.com

**Manufacturer or Contractor's Welding Engineer:**

Name: *Weld Guy*

Signature: *W.G.*

Title: *Welding Engineer*

Date: *12, 12, 2005*

**Authorized by:**

Name: *John Smith*

Signature: *J.S.*

Title: *QA Manager*

Date: *12,12, 2005*

