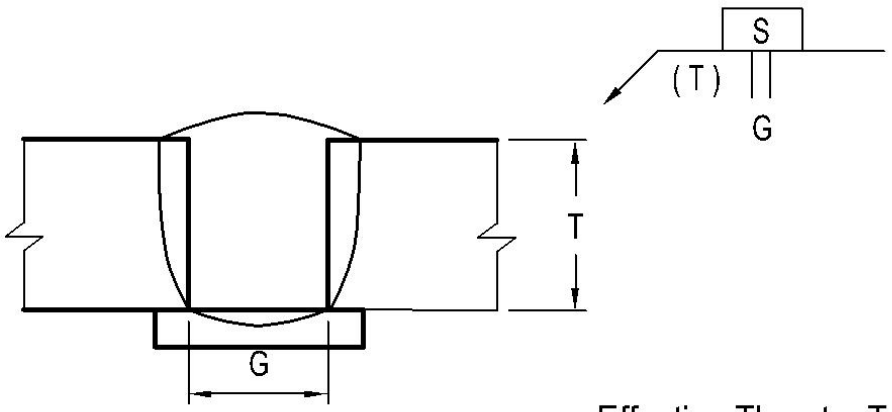
Prepared by: Your Company Name Shown Here	WELDING PROCEDURE SPECIFICATION (WPS)		Identification #	DEMO for Service Package (B)
			Ref. Code	AWS D1.1
Company Name: Your Client's Company Name Here Address: Your Client's Company Address Here			PQR No.	PREQUALIFIED

Process	SMAW	Process Type	Manual	Positions	F, H, V (up), OH
Base Metals		Steels in Groups I and II of Table 3.1 of AWS D1.1			
Filler Metals		AWS A5.1: E7018, E7018 H4R, E7018 H8 (Or) E7018-1, E7018-1 H4R, E7018-1 H8			
Preheat/ Interpass Temp., Min		Up to 20 mm (3/4): 0 C (32 F) ; Table 3.2 of AWS D1.1 on requirements for greater thicknesses			
Interpass Temp., Max			Current/ Polarity	DCEP or AC	
Interpass Cleaning		Chip, File, Brush and/ or Grind	Weld Type	Complete Joint Penetration Groove Weld	

Joint Details/ Joint Design Used/ Sketch:



B-L1a

Effective Throat = T
G = T
T ≤ 6 mm ($\frac{1}{4}$ in)

Welding Procedure:

Thickness (T) mm (in)	Weld Size ETT (E)	Side	Weld Layers	Pass No.	Filler Diameter mm (in)	Current Amps	Alternate Filler Diameters mm (in)	Current Amps
T<=6 mm (1/4)	T	1	Root, Fill, Cap	As Required, see notes	3.2 mm (1/8)	110-150	2.4 mm (3/32)	75-110

Notes, Technique or Code Guidance:
-Number of passes varies based on joint configuration, position, electrode size, travel speed, and weld technique.
-First pass should be large enough to minimize the possibility of cracking.
-F=Flat, H=Horizontal, V=Vertical, OH=Overhead
-Maximum thickness of layers is 6 mm (1/4) for root pass and 5 mm (3/16) for subsequent layers.
-The groove in a joint may be reversed where more practical or necessary.
-Larger size electrodes may be used for fill and/ or cap passes of the thicker material.
-Smaller size electrodes usually applicable for root passes and/ or for thinner material.

Originated by:

John Smith, Welding Engineer

Date: 03, 14, 2005 Revision (1)

Authorized by:

Jim Clark, QA Manager

Date: 03, 14, 2005