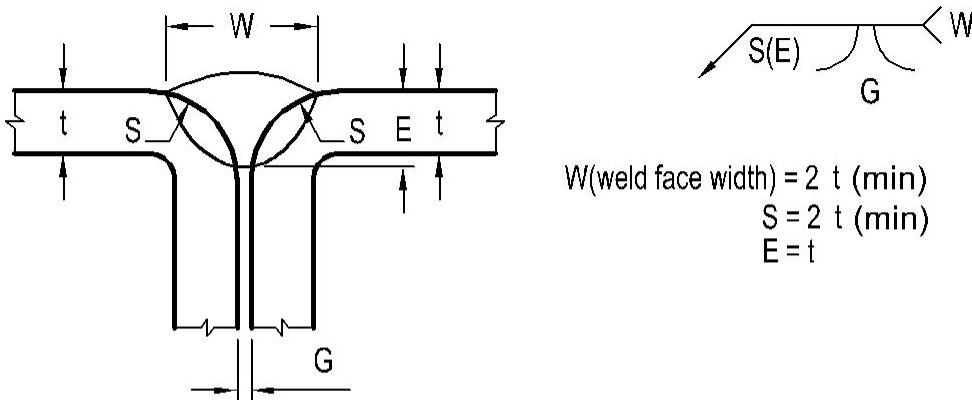


Prepared by: WPSAmerica.com		WELDING PROCEDURE SPECIFICATION (WPS)		Identification #	DEMO-FCAW
Company Name: <i>www.WPSAmerica.com</i>				Ref. Code	AWS D1.3
Address: <i>info@WPSAmerica.com, Toll Free: 1 (877) WPS-WELD</i>		PQR No.		PREQUALIFIED	
Process	FCAW	Process Type	Semi-Automatic	Positions	F, H, V (up), OH
Base Metals		Steels in Groups I and II of Table 1.2 of AWS D1.3			
Filler Metals		AWS A5.20: E71T-11, E71T-11 H16 (FCAW-S)			
Shielding Gas Flux (SAW)		Self-Shielded (FCAW-S)		Flow Rate	N/A
				Nozzle Dia.	5/8 in
Weld Type		Partial Joint Penetration Groove Weld		Current/ Polarity	DCEN
Electrical Stick Out ESO (in)		1/2 to 3/4	Preheat / Interpass Temp., Min	0 °C (32 °F), Clause 5.1-AWS D1.3 Surfaces free from moisture	

Joint Details/ Joint Design Used/ Sketch:



Thickness	Root Opening (G)
18 Ga. (min)	0 (min)
11 Ga. (max)	t / 2 (max)

Figure 3.3 C

Welding Procedure:

Thickness (T) mm (in)	Weld Size ETT (E)	Side	Weld Layers	Pass No.	Filler Metal Diameter mm (in)	Current Amps	Volts	Wire Feed Speed (IPM)	Travel Speed (IPM)
From 18 Ga. Min. to range shown in Sketch	As shown in Sketch	1	1 to 2	1 to 2	1.1/ 1.2 mm (0.045)	120	15	70	10 to 25
						140	16	90	
						160	17	110	
						170	18	130	

Notes, Technique or Code's rules:

- Depending upon welding position, weld type, surface condition or other factors, voltage and/or wire feed speed may need to be adjusted.
- Thicker sheets may need more than 1 layer and pass.

Originated by:

John Smith, Welding Engineer

Date: 04, 29, 2005 Revision (1)

Authorized by:

Jim Clark, Quality Manager

Date: 04, 29, 2005

Caution Note: Use of prequalified joint is not intended as a substitute for engineering judgment in the suitability of application to a welded assembly or connection.