



Pyramid Co.
 123 Any Street
 KC, MO 64015

Welding Procedure Specification (WPS)

WPS No.: Example 1b Date: 3/11/2016 Rev. No.: 0

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Supporting PQR(s): Example 1a

Weld Type: Groove and fillet welds

BASE METALS						
P-No. <u>1</u> Thickness Range: <u>0.1875 in. to 2.0000 in.</u> to P-No. <u>1</u> Base Metal notes would appear here.						
PREHEAT		POSTWELD HEAT TREATMENT				
Minimum Preheat Temperature: <u>300</u> °F		PWHT Type: <u>PWHT below lower transformation temperature</u>				
Maximum Interpass Temperature: <u>600</u> °F		PWHT Temperature : <u>1275</u> °F				
Preheat Maintenance: <u>None</u>		PWHT Holding Time: <u>1.0 hr./in., 0.25 hr. min.</u>				
Preheat notes would appear here.		PWHT notes would appear here.				
Weld Process / Method Weld Deposit Limit POSITION Position of Joint Weld Progression Notes GAS Shielding Gas / CFH Trailing Gas / CFH Backing Gas / CFH FILLER METAL AWS Classification SFA Spec. / F-No. A-No. or Chemical Composition Filler Metal Product Form Supplemental Filler Metal Other: Consumable Insert GTAW Flux Pass Greater Than 1/2": Filler Metal Size (in.) Strip Thickness or Width (in.): ELECTRICAL Welding Amperage Range Welding Voltage Range Travel Speed (in/min) Max. Heat Input (J/in) Current Type and Polarity Tungsten Type / Size Pulsed Current Transfer Mode TECHNIQUE Thermal Processes Peening Stringer or Weave Bead Multiple / Single Pass (per side) Nozzle / Gas Cup Size Contact Tube to Work Distance Oscillation Multiple or Single Electrode(s) Electrode Spacing	1st Process			2nd Process		
	GTAW / Manual			GMAW / Machine		
	0.2500 in. maximum			1.0000 in. maximum		
	All Positions			All Positions		
	Any			Any		
	Process1 position notes would appear here.			Process2 position notes would appear here.		
	100% Argon / 14-18			100% Argon / 11-14		
	None / -			None / -		
	None / -			None / -		
	ER70S-2			E70C-3C		
	5.18 / 6			5.18 / 6		
	1			1		
	Bare (Solid)			Metal cored		
	NA			n/a		
	NA			No		
	1/16 3/32 1/8			0.035 0.045 1/16		
	70-150 80-180 130-275			80-145 110-145 165-300		
	n/r n/r n/r			17-22 18-23 20-25		
	Var. Var. Var.			Var. Var. Var.		
	None			None		
DCEN (straight)			DCEP (reverse)			
EWTh-2 / 3/32			Short-circuiting arc			
NA			No			
No			None			
None			None			
Stringer and weave bead			Stringer and weave bead			
Single and multipass			Single and multipass			
#5 to #10			3/8" to 5/8"			
			.5			
			n/a			
			Single electrode			
			2			
(1) Process1 electrical notes would appear here.						
(2) Process2 electrical notes would appear here.						

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Weld Process / Method Weld Deposit Limit POSITION Position of Joint Weld Progression Notes FILLER METAL AWS Classification SFA Spec. / F-No. A-No. or Chemical Composition Other: Pass Greater Than 1/2": Filler Metal Size (in.) Strip Thickness or Width (in.): ELECTRICAL Welding Amperage Range Welding Voltage Range Travel Speed (in/min) Max. Heat Input (J/in) Current Type and Polarity TECHNIQUE Thermal Processes Peening Stringer or Weave Bead Multiple / Single Pass (per side)	3rd Process SMAW / Manual 0.7500 in. maximum <hr/> All Positions Any Process3 position notes would appear here. <hr/> E7018 5.1 / 4 1 <hr/> No 3/32 1/8 5/32 <hr/> 70-110 90-160 130-220 n/r n/r n/r Var. Var. Var. None DCEN (straight) <hr/> No None Stringer bead Single and multipass	
(3) Process3 electrical notes would appear here.		

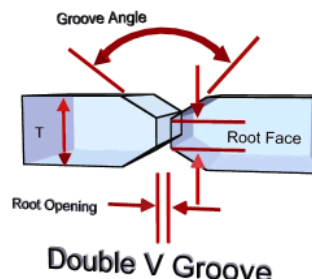
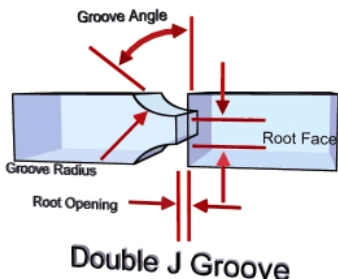
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JOINT DESIGN

Weld Type: Groove and fillet welds



Backing: With or without backing Backing Material: variable

Fillet Welds: All fillet sizes on all base metal thicknesses and all diameters.

Retainers: None

Joint notes would appear here.

WELD JOINT DESCRIPTIONS SHOWN ARE NOT INCLUSIVE OF ALL THOSE FOUND ON A JOB. WELD JOINT DESIGN REFERENCE IN AN ENGINEERING SPECIFICATION OR A DESIGN DRAWING SHALL TAKE PRECEDENCE OVER WELD JOINTS SHOWN IN THIS WPS.

Initial and Interpass Cleaning: With wire brush clean 1 inch (25 mm) on both sides of weld joint

Method of Back Gouging: When required, grind until all defects are removed.

Overall WPS Notes would appear here.

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Code.

Header 1 John Smith 3/11/2016 QA Manager
John Smith Date

Header 2 John Smith 3/11/2016 QA Manager
John Smith Date

Notes

Additional Optional Notes would appear here.