Pullman Power Products	150-I-1-KI-A1 DOCUMENT NO.
PREPARED BY: G. L. MARTIN APPROVED BY: K. J. FREED KJF	ISSUE DATE: 2/13/81
WELDING PROCEDURE SPECIFICATION TO BE USED ONLY ON JOB # 7035	PAGE NO. 1 OF 3
	LATEST REV. DATE 2/13/81

AUTOMATIC GTAW WELDING

HEADQUARTERS AT

WILLIAMSPORT, PENNSYLVANIA

UE&C CODE
00

REVISION	PREPARED BY	APPROVED BY	INITIALS	DESCRIPTION
00 2/13/81	G.L. Martin	K.J. Freed	KJF	Initial Issue

Pullman Power Products

150-I-1-KI-A1
DOCUMENT NO.

81-01-14

PREPARED BY: G. L. MARTIN | APPROVED BY: K. J. FREED KJF | DATE: 2/13/81

WELDING PROCEDURE SPECIFICATION | TO BE USED ONLY ON JOB # 7035 | PAGE NO. 2 OF 3

THIS WPS MUST BE USED IN CONJUNCTION WITH THE GENERAL WELDING STANDARD (S). GWS-I | SUPPORTING PQR NO. 047A, 047B

BASE METALS (QW-403)

P NO. 1 GR.NO. N/A TO P NO. 1 GR.NO. N/A

OR

SPECIFICATION TYPE & GRADE N/A

TO SPECIFICATION TYPE & GRADE N/A

WELDING SEQUENCE			
	ROOT WELD	INTERMEDIATE WELD	BALANCE
PROCESS	GTAW	N/A	GTAW
SFA/AWS SPEC. NO.	5.18	N/A	5.18
F-NO./A-NO.	F6/A1	N/A	F6/A1
SHIELDING FLUX/GAS	Argon	N/A	Argon

GAS (QW-408)

SHIELDING GAS(ES) Argon

PERCENT COMPOSITION (MIXTURES) N/A

FLOW RATE 25 CFH Min.

GAS BACKING Argon (Flow Rate ?

NEV 408.5

POSITION QUALIFIED All positions

THICKNESS RANGE QUALIFIED .187" - 8"

CONSUMABLE INSERT MATERIAL SFA 5.18/1/16" X 3/16" E70S-3

TUNGSTEN ELECTRODE SIZE & TYPE 3/32, 1/8 EWTh-2

TECHNIQUE (QW-410)

ORIFICE OR GAS CUP SIZE 4-10

CONTACT TUBE TO WORK DISTANCE N/A

OTHER See * Below

STRINGER OR WEAVE BEAD Both

WEAVE BEAD TECH See * Below

SINGLE OR MULTIPLE ARC Single

SINGLE OR MULTIPA S Multiple

PREHEAT & INTERPASS TEMPERATURE REQUIREMENTS:

See paragraph 5.0 of GWS-I for preheat; interpass 600°F Max.

POST WELD HEAT TREATMENT REQUIREMENTS:

See paragraph 6.0 of GWS-I
Maximum time qualified in temp. range 1100-1200°, 10 hr.

FOR GAS BACKING SEE," BACKING GAS PURGE CHART," PAGE 9 of GWS-I

ADDITIONAL INSTRUCTIONS: *

Out Dwell .1 -.7 sec.

Excursion Time .1 - .6 sec.

In Dwell .1 - .7 sec.

Oscillation Amplitude 0 - .30"

Pullman Power Products	150-I-1-KI-A1 DOCUMENT NO.
PREPARED BY: G. L. MARTIN	APPROVED BY: K. J. EREED DATE: 2/13/81
WELDING PROCEDURE SPECIFICATION	TO BE USED ONLY ON JOB # 7035
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81-81-14A

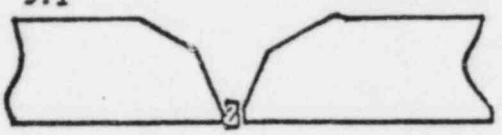
WELDING MATERIAL / BASE METAL CONTROL			
BASE METAL	ELECTRODE	BARE WIRE	FLUX
All P1 Materials	N/A	E70S-3	N/A

(QW-402) JOINT DESIGN(S) SHOWN HERE IS A TYPICAL ILLUSTRATION ONLY

See paragraph 9.0 of GWS-I for details and subparagraph.

The joint configurations of the following specific subparagraphs of GWS-I are acceptable.

9.1



9.4

WELD LAYER OR PASS	PROCESS	FILLER METAL CLASS.	FILLER METAL DIA.	CURRENT TYPE POLA.	CURRENT AMP RANGE	VOLT RANGE	TRAVEL SPEED RANGE	
Root	GTAW	E70S-3	K-Insert	DCSP	100-150 50-90	7.5-10.0 6.0-8.5	2.0 IPM (Min.)	Primary or 1st Level Background
Fill	GTAW	E70S-3	.035" ✓	DCSP	140-299 50-210	7.5-10.5 6.0-8.5	2.0 IPM (Min.)	Primary or 1st Level Background
Fill	GTAW	E70S-3	.045" ✓	DCSP	200-299 160-230	8.5-11.0 7.0-9.5	2.0 IPM (Min.)	Primary or 1st Level Background

JOB NO.	PURCHASE ORDER COMM.	PURCHASE ORDER SEQ. (SUBT. NO.)	FOREIGN PRINT NO.	INSP. CIRCUIT	DISC. ACTION	STATUS	VENDOR DRAWING OR DOCUMENT NO.	REV. NO.	SIZE	ORIG. DISC.	ACTION	CODE
1 7	8 10	11 14	15 19	20 21	22 23	24 25	26 42	43 44	45	46 47	79	80
9763011248005	146	1002	11	PR			PQR-047B	01	Z	19		1

DESCRIPTION LINE 1	LINE 2	VENDOR'S NAME	ACTION	CODE
24 43	44 63	64 72	79	80
AUTOMATIC GTAW WPS		P-H		2

LETTER TO UE&C	UE&C LOG-IN DATE	CLIENT'S REVIEW TO CLIENT	CLIENT'S REVIEW FROM CLIENT	UE&C REVIEW TO VENDOR	UE&C REVIEW STATUS	FINAL DISTRIBUTION DATE	ACTION	CODE
24 29	30 35	36 41	42 47	48 53	54 55	56 61	79	80
35-30	1050181	PP5091	TF12335	F4267	Ø			3

UNITED ENGINEERS & CONSTRUCTORS INC.

Reviewed only for general arrangement and overall dimensions as set forth in purchase order or contract. This review does not constitute acceptance of any design, material, component or equipment not fulfilling all contract specification and drawing requirements.

- [X] PROCEED AS PER P.O. OR CONTRACT
- [ ] SUBMIT REVISED DRAWINGS FOR REVIEW
- [ ] SEND CORRECTED DRAWINGS FOR RECORD

BY M. G. Eidgen DATE 5-5-91

CHECK			*
FILE		Q/A	
SQUAD #		ELEC.	
CLIENT		MECH. S.	
MFR		MECH.	
FIELD		STRUCT.	
RMW		INST.	
PE		NUCLEAR	

FORM 5041 REV 7/74

QW 356.1 Perf.

QW 402.4

403.16

403.19

404.16

404.22

404.28

405.1

405.3

408.8

409.4

E Proc (NTE

403.7

403.8

403.9

403.11