

AWS D1.1 - 2015 SUGGESTED FORMAT FOR WELDING PROCEDURE SPECIFICATION (JWPS)

(See Gen. Requirements, Section 1)

PREQUALIFIED JOINT WELDING PROCEDURE SPECIFICATION

(Ref. Sec. 3) & Annex H

SHOP AND FIELD PRODUCTION WELD PROCEDURE

Company Name:	Wa	By:	Welding Engineer
Welding Procedure Specification No.:	PQ-GMAW -1	Supporting PQR No(s):	N/A
Date:	2/19/2015	Revision No.:	None
Welding Process(es):	Gas Metal Arc Weld (GMAW) C-25 Mixed Welding Gas (Aron 75% - CO2-25%)	Type(s):	SEMI-AUTOMATIC WELDING (Automatic, Manual, Machine, of Semi-Auto)
Prequalification Allow By Code			

Joints [SEC 3 (3.12, Fig 3.3 & 3.13, Fig 3.4) Table - 3.6, 3.7]

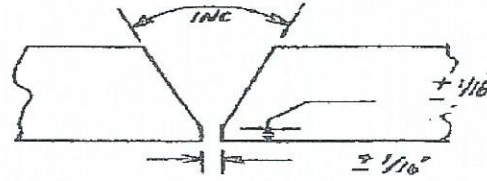
Joint Design Single V Groove Weld (Typ Joint Design Shown)

PP & CP Joint Common Requirements [Sec 3 (3.11, 3.12)]

Backing (Yes) When Applicable [Ref Sec 3, Table 3.1, 3.2 - Sec-5, 5.9, 5.10]

Backing Material (Type) Carbon Steel when Applicable

Sketches, Production Drawings, Weld Symbols or Written Description should show the general arrangements of the parts to be welded. Where applicable, the root spacing and the details of weld groove may be specified.



(At the option of the Mfg., sketches may be attached to illustrate joint design, weld layers and bead sequence, e.g. for notch toughness procedures, for multiple process procedures, etc.)

***BASE METALS (SEC 3, Table 3.1)**

A-No. (A36)	Group No. Inc's I & II	to A-No. (A36)	Group No. Inc's I & II
OR			
Specification type and grade		N/A	
to Specification type and grade		N/A	
OR			
Chem. Analysis and Mech. Prop.		N/A	
to Chem. Analysis and Mech. Prop.		N/A	
Thickness Range: Sec 3 (3.2 & Table 3.4)			
Base Metal:	Groove: <u>1/8" THUR 1"</u>	Filet:	<u>Ref Sec - 3 Fig 3.9 (Unlimited Sizes)</u>
Deposited Weld Metal:	Groove: <u>THUR 1-1/4" (3.12.2.1)</u>	<u>Min Sizes (Ref Sec -3 Table 5.8)</u>	
Pipe Dia. Range:	Groove: <u>N/A</u>	<u>Ref-Sec 2 2.4 Effective Throat</u>	
Other:	<u>Ref Sec 3.10.1-3 , 10.3 , 2.5. 2-2.5.4 For Plug Welds</u>		

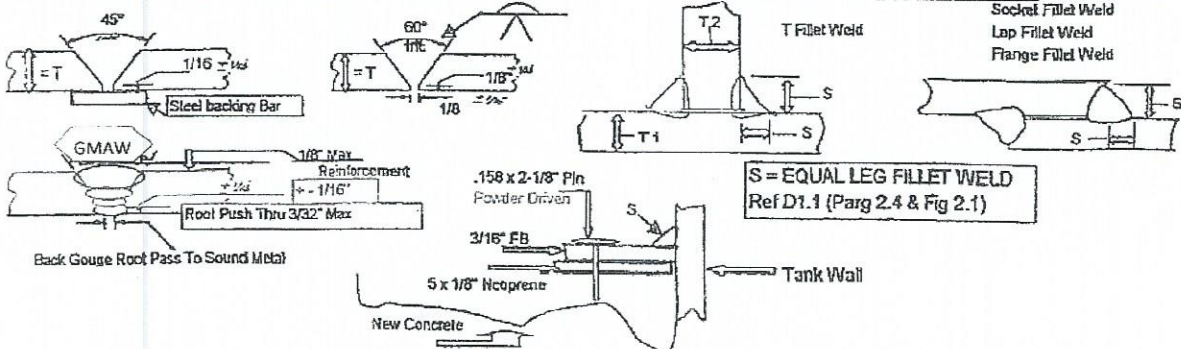
***FILLER METALS (Sec 3, Table 3.1)**

Other:	N/A	Other:	N/A
Other:	N/A	Other:	N/A
AWS No. & (Class)	<u>A5.18</u>		
AWS No. & (Class)	<u>ER70S-XX</u>		
Size of filler metals	<u>.035 , .045 Dia</u>		
(Electrode, Cold Wire, Hot Wire, etc.)			
Electrode-Flux (Class)	<u>N/A</u>		
Flux Trade Name	<u>N/A</u>		
Consumable Insert	<u>N/A</u>		

TYPICAL WELD JOINTS SHOWN BELOW FOR CARBON STEEL PIPE OR PLATE

Partial Penetration Groove Butt Weld

Fillet Weld Examples shown below



S = EQUAL LEG FILLET WELD
Ref D1.1 (Parg 2.4 & Fig 2.1)