

## Welding Procedure Specification

Welding Process:	GMAW	Transfer Mode:			Pulsing		
Supporting PQR:	Prequalified	MA	--	SA	X	AU	-
This WPS is intended to be used for joining heat and corrosion resistant alloy steel base metal components. This procedure is machine specific for the Power Mig 350MP™							
<b>Base Metal</b>							
Base Type:	Austenitic Stainless Steel	P/M Number:	8				
		Group Letter:	A and B				
Specification:	Per Annex A-P8						
Thickness:	Grooves:	1/16 in. min. to Unlimited					
	Fillets:	Unlimited					
<b>Filler Metal</b>							
Specification:	AWS 5.9						
Classification:	E316Si/E316LSi						
F Number:	6						
A Number:	8						
Group:	A						
Diameter:	0.035 in.						
Notes:	Filler metal shall be protected from shop dust, mists, etc. once the spool is removed from the manufacturer's shipping carton.						
<b>Shielding Gas(es)</b>							
Shielding Gas:	SG-AO-2%						
Percent Mix:	Ar-98%, O <sub>2</sub> -2%						
Specification:	AWS A5.32						
Flow Rate:	35 to 45 cfh						
Cup Diameter:	1/2 to 5/8 inch						
Purge Gas:	Not required – Argon Optional						
Flow Rate:	5 to 30 cfh when root purge is required by the customer.						
Trailing Gas:	None required						
Notes:	Welding shall be performed in areas protected from wind or breezes to prevent porosity. Maximum velocity – 3 mph. A wind screen may be used to minimize the effects of breezes or gusts.						