

**ASME SECTION IX**

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Company Name \_\_\_\_\_  
 Welding Process GTAW  
 Supporting WPS No(s). WS 17-4 GT

Identification # WS 17-4 GT  
 Date 10-20-2009

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 Authorized by: \_\_\_\_\_  
 Date: 10-9-2009

Written by: \_\_\_\_\_  
 Type Manual  Automatic \_\_\_\_\_  
 Machine  Semi-Automatic \_\_\_\_\_

**JOINT DESIGN USED (QW 402)**  
 Type: Single  U Partial Penetration with backing  
 Backing: Single  Double Weld   
 Yes  No   
 Backing Material: 718  
 Root Opening 0.010" Root Face Dim. 0.0"  
 Groove Angle 74 Deg Radius (J-U) 74 Degrees  
 Back Grinding: Yes  No   
 Method N/A

**POSITION (QW 405)**  
 Position of Groove: 1G Fillet: N/A  
 Vertical Progression: Up  Down

**BASE METALS (QW 403)**

Material Spec 17-4  
 Heat Number \_\_\_\_\_  
 Diameter (Pipe) 3"  
 Base thickness .395"

**ELECTRICAL CHARACTERISTICS (QW 409)**

GTAW Manual  
 DCSP GTAW \_\_\_\_\_  
 Current: AC  DCRP   
 DCSP  Pulsed   
 Other \_\_\_\_\_  
 Tungsten Electrode  
 Size: 1/8"  
 Type: EWTh-2 2% Thoria

**FILLER METALS (404)**

AWS Classification ER630  
 AWS Specification 5.9  
 Deposit .131"  
 F Number 6 A number. MnNiCrCu  
 Filler Size .045"

**TECHNIQUE (QW 410)**

Stringer or Weave Bead: Stringer  
 Multi-pass or Single Pass (per side) Multiple  
 Number of Electrodes 1  
 Electrode Spacing Longitudinal N/A  
 Lateral N/A  
 Angle N/A  
 Oscillation None  
 Contact Tube to Work Distance N/A  
 Peening None  
 Interpass Cleaning Stainless Steel Wire brush

**SHIELDING**

Flux N/A Gas Argon  
 Composition 100%  
 Electrode-Flux (Class) \_\_\_\_\_ Flow Rate 30  
 Nozzle Gas Cup Size 3/4"

**PREHEAT**

Preheat Temp., Min 65F  
 Interpass Temp., Min 65F Max 350F

**POSTWELD HEAT TREATMENT (QW 407)**

Temp. As Welded  
 Time N/A

**WELDING PROCEDURE**

		Classification	Filler Size	Polarity	Amps	
1	GTAW	ER360	.045	DCSP	150	
2	GTAW	ER360	.045	DCSP	130	
3	GTAW	ER360	.045	DCSP	130	
4	GTAW	ER360	.045	DCSP	130	