

APPENDIX A

PROPOSED WELD PROCEDURE SPECIFICATIONS

Introduction

The Weld Procedure Specifications (WPS's) in this appendix have been drafted as guides for use in the Phase 2 Steel Project. The fabricator and investigator should use these in conjunction with the information provided in Appendix B to develop specific WPS's for each experimental project. Where ranges are listed in these WPS's, an attempt should be made to work with values near the middle of each range as appropriate for the actual plate thickness and other conditions present in the joint in order to achieve a heat input at the target level. Differences between root pass parameters and subsequent passes shall be documented. In all cases, the parameters used at the time the specimen is fabricated must be documented. Examples of items which must be documented include preheat and interpass temperature, amperage, voltage, travel speed, electrical stickout, layer thickness and layer width, etc. A comprehensive fabrication checklist is provided in Appendix G.