### Welding Procedure Specification

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<table>
<thead>
<tr>
<th>Layer/Pass</th>
<th>Process</th>
<th>Filler Metal Class</th>
<th>Diameter</th>
<th>Cur. Type</th>
<th>Amps</th>
<th>Volts</th>
<th>Travel Speed</th>
<th>Other Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>All</td>
<td>GMAW</td>
<td>ER70S-6</td>
<td>0.035&quot;</td>
<td></td>
<td>90-150</td>
<td>16-20</td>
<td>6-8 ipm</td>
<td>WFS 140-350 ipm</td>
</tr>
</tbody>
</table>

**WELDING PROCEDURE**

**PREHEAT**
- Preheat Temp., Min.: 60 Deg.F
- Thickness: Up to 3/4" Temperature N/A
- Over 3/4" to 1-1/2" N/A
- Over 1-1/2" to 2-1/2" N/A
- Over 2-1/2" N/A
- Interpass Temp., Min. N/A Max. N/A

**POSTWELD HEAT TREATMENT**
- PWHT Required
- Temp: N/A
- Time: N/A

**FILLER METALS**
- AWS Specification: E71T-1
- AWS Classification: ER70S-6

**SHIELDING**
- Flux: Gas
- Electrode-Flux (Class): 75%Argon/25%CO2
- Gas Cup Size: 1/2" - 3/4"

**ELECTRICAL CHARACTERISTICS**
- Transfer Mode (GMAW): Short-Circuiting
- Current: AC DCEP DCEN Pulsed
- Electrode Spacing: Longitudinal N/A
- Angle: N/A
- Contact Tube to Work Distance: 1/4" to 3/8"

**TUNGSTEN ELECTRODE (GTAW):**
- No other electrode types specified.

**Interpass Cleaning**
- Chip slag and wire brush

**Technique**
- Stringer or weave bead
- Both

**RECOMMENDED SETTINGS:**
- FCAW-G E71T-1M 0.045 DCEP 290-360 21-30 18-22 ipm WFS 340-500pm