

**Standard Welding  
Procedure Specification  
(SWPS) for 75% Ar/25%  
CO<sub>2</sub> Shielded Flux Cored  
Arc Welding of Carbon  
Steel (M-1/P-1, Group 1  
or 2), 1/8 inch [3 mm]  
through 1-1/2 inch [38  
mm] Thick, E70T-1M  
and E71T-1M, in the  
As-Welded or PWHT  
Condition, Primarily  
Plate and Structural  
Applications**

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**An American National Standard**

**Approved by the**  
**American National Standards Institute**  
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Prepared by the  
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the  
AWS Technical Activities Committee

Approved by the  
AWS Board of Directors

## **Abstract**

This standard contains the essential welding variables for carbon steel in the thickness range of 1/8 inch [3 mm] through 1-1/2 inch [38 mm], using semiautomatic Ar/CO<sub>2</sub> shielded flux cored arc welding. It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for fillet and groove welds. This SWPS was developed primarily for plate and structural applications.



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