

**Standard Welding Procedure
Specification (WPS) for**

**75% Ar/25% CO₂
Shielded Flux Cored
Arc Welding of Carbon
Steel (M-1/P-1/S-1,
Group 1 or 2),
1/8 through 1-1/2 inch
Thick, E70T-1 and
E71T-1, As-Welded
or PWHT Condition**

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Key Words—Welding Procedure Specification,
base metal, allowable joint designs,
filler metal, carbon steel, semi-
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cored arc welding

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**Approved by
American National Standards Institute
April 15, 1993**

**Standard Welding Procedure
Specification (WPS)
75% Ar/25% CO₂ Shielded Flux Cored Arc Welding
of Carbon Steel (M-1/P-1/S-1, Group 1 or 2)
1/8 through 1-1/2 inch Thick, E70T-1 and E71T-1
As-Welded or PWHT Condition**


Prepared by
AWS Committee on Welding Qualification

Under the Direction of
AWS Technical Activities Committee

Approved by
AWS Board of Directors

Abstract

This standard contains the essential welding variables for carbon steel in the thickness range of 1/8 through 1-1/2 inch, using semiautomatic Ar/CO₂ 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 WPS was developed primarily for plate and structural applications.

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