

**Ref. WPS: MCAW-SS**

COMPANY NAME: \_\_\_\_\_.

COMPANY ADDRESS: \_\_\_\_\_.

**WELDING PROCEDURE SPECIFICATION (WPS)  
FOR METAL CORED ARC WELDING (MCAW)  
OF STAINLESS STEEL****About WPS:**

Welding Procedure Specification (WPS) is a general document that outlines shop and field welding practice and limitations for a welding process. Welding parameters and ranges are specified and used to prepare associated WPDS.

**About WPDS:**

Welding Procedure Data Sheet (WPDS) is a document, used in conjunction with a WPS, detailing the welding parameters and ranges for welding a specific joint, over a range of thicknesses and weld sizes, as illustrated on the data sheet.

**Scope**

This WPS covers welding and related operations of stainless steel which are fabricated in accordance with the terms specified in the latest editions of following Standards:

- **CSA W47.1-Certification of Companies for Fusion Welding of Steel**
- **AWS D1.6/D1.6M-Structural Welding Code, Stainless Steel**

Note: CSA W59-18-Welded Steel Construction (Metal Arc Welding) may be referenced when joining stainless steel to carbon steel.

This WPS will be presented to the Canadian Welding Bureau (CWB) along with the related WPDS for approval.

**Welding Procedure**

The welding shall be done Semi-automatically using the Metal Cored Arc Welding (MCAW) process. Joints shall be made by single or multiple pass welding, from one or both sides as per accepted WPDS that referring to this specification. (Note: Fully Automatic application can also be used).

Please note that as per AWS D1.6 code, GMAW process is named for both solid wire and also metal cored wires.

MCAW process designed primarily for welding of thin gauge materials. It has higher deposition rate and less penetration than a solid wire and so this wire are best for small butt, fillet and lap type welds on gauge material at increased travel speeds compare to solid wire. Some of the applications for this process are catalytic converters, manifolds, mufflers, exhaust system and cladding.

Semi-automatic welding: Welding with equipment that supplies continuous wire feed with or without means for mechanical travel. Manual manipulation by the welder of one or more of the variables of speed of travel, guidance, and direction of wire is involved during the welding operation.

**Fact on Stainless Steels**

Stainless steels are commonly divided into the following general groups:

- (1) Martensitic (4XX Series)
- (2) Ferritic (4XX Series)
- (3) Austenitic (include 2XX Series, Cr-Ni-Mn and 3XX Series, Cr-Ni)
- (4) Precipitation-hardening (which grades are assigned designations based on their Cr and Ni contents; including austenitic, semi-austenitic and martensitic)
- (5) Duplex

Austenitic stainless steels have excellent weldability; have better ductility and toughness than carbon steels or low alloy steels because of the Face-Centered cubic Crystal (FCC) structure.

**Base Metals**

The base metals used shall conform to ASTM austenitic stainless steel specifications as noted on the WPDS, welded to each other or to carbon steels conforming to the specifications of steel groups 1, 2 and 3 of Table 11.1 and Table 12.1 of the CSA W59-18 Standard.

Other grades of stainless steel and carbon steel may be welded provided accepted WPDS are available.

Note: For the purpose of this WPS, Table 5.2 of Prequalified Austenitic Stainless Steels, base metal Groups A, B, C, D and E of the AWS D1.6 code can be used. However Alloy Designation like 304L, 304, 316L and 316 of group A or B are the most popular ones used in industry.

**Base Metal Thicknesses**

Base metal from 1.5 mm (1/16 in) or 16 gauge to unlimited thickness may be welded under this specification provided that WPDS has been supplied and accepted by the CWB. Thicknesses less than 1.5 mm (1/16 in) may be welded providing data sheets have been accepted by the CWB.

**Filler Metals**

Filler metal shall be certified by the Canadian Welding Bureau as conforming to specifications for Stainless Steel Electrodes for Metal Cored Arc Welding under AWS A5.22 for metal cored wires.

The filler metal shall be certified by the Canadian Welding Bureau as conforming to the CSA Standard W48 latest edition.

Following are guides for choosing filler metal match for austenitic stainless steels:

-Joining of similar metal joints; use filler metal of matching composition (e.g.: weld 304L material with 308L electrode).

-Dissimilar joining; use the lower alloyed of the two base metals (e.g. use 308 electrode to weld 304 to 316 materials).

-If both metals are low carbon (3XXL), then use low carbon (3XXL) filler metal as well.

**Note 1:** For low or high temperature, corrosive or any critical applications always confirm wire choice with wire manufacturer.

**Note 2:** For the purpose of this WPS, Table 5.3 of Prequalified Filler Metal Classifications, lists filler metal groups, based upon strength, which are prequalified for the corresponding prequalified Base Metal Group of Table 5.2 of the AWS D1.6 code. For welding of two different base metal groups in Table 5.2, use filler metal of Table 5.3, corresponding to the lower strength of the two base metal groups.

### **Storage and Conditioning of Wires**

Wires shall be dry and free from surface rust and foreign material. Wires shall be delivered in sealed containers that do not show evidence of damage.

All Wires shall be stored in warm and dry conditions and kept free from oil, grease and other deleterious matter once they have been removed from their containers.

### **Shielding Gas**

The shielding gas shall be a welding grade having a dew point of -40 °C (-40 °F) or lower. Shielding gas shall not be done in a draught or wind unless the weld is protected by a shelter.

The shielding gas/ wire combination shall be as shown on the accepted WPDS.

Shielding gases like Ar+1-2% O<sub>2</sub> and Ar+1-2% CO<sub>2</sub> are good choices for spray transfer mode.

### **Position(s) of Welding**

The welding shall be done preferably in the flat position, but other positions such as horizontal, vertical and overhead are permissible providing the proper WPDSs are prepared and approved.

### **Electrical Characteristics**

The welding current shall be direct current (reverse polarity) using a constant voltage type power supply. The range of parameters, as per wire manufacturer's instructions, will show in WPDS.

### **Preheat and Interpass Temperature**

Preheat does not normally apply to the welding of austenitic stainless steel, but if required, details will be shown on the specific WPDS. The minimum preheat shall be sufficient to remove moisture from the work. The maximum interpass temperature shall not exceed 350 °F (175 °C) according to the AWS D1.6 code.

### **Heat Treatment and Stress Relieving**

This will not be applicable to structures welded under this specification, unless a specific WPDS showing all the parameters is submitted to the CWB and acceptance is obtained.

### **Types of WPDS:**

There are two types of WPDS, Prequalified or non Prequalified. Prequalified WPDS uses prequalified joint as specified in a governing code or standard that does not require validation of welding parameters through the performance of a procedure qualification test.

Prequalified joints and requirements for Prequalified WPDS are outlined in Section 5 of the AWS D1.6 code.

**Note 1:** All prequalified WPDS to be used shall be prepared, approved, and controlled by the manufacturer or Contractor as written prequalified WPDS, and shall be available to those who need to use or review them.

**Note 2:** The use of a Prequalified joint shall not exempt the Engineer from using engineering judgment in determining the suitability of application of these joints to a welded assembly or connection.

### **General Requirements for Prequalified WPDS:**

Definition: Groove welds without steel backing, welded from one side, and groove welds welded from both sides, but without back gouging, are considered Partial Joint Penetration (PJP) groove welds for purposes of prequalification. In other hand Complete Joint Penetration (CJP) groove welds made without the use of backing shall have the root back gouged to sound metal before welding is started from the second side.

-Prequalification covers weldments in thickness of 2 mm (1/16 in) or 16 gage and greater, designed for supporting mechanical loads under normal atmospheric corrosion conditions. It applies only to nominally austenitic stainless steel base metals and filler metals whose as-welded fusion zones normally contain a small amount of delta ferrite.

**-In addition to the requirement of Table 5.1 and Table 5.4, the following requirements shall apply to all prequalified WPDS's (See Clause 5.7 of AWS D1.6 for more detail):**

-The classification and size of electrode, voltage, amperage, travel speed, and gas flow rate shall be suited to thickness of material, type of groove and welding position.

-Base Metal Prequalification: Austenitic stainless steels whose filler metals normally produce a small amount of ferrite (as per Table 5.2 of AWS D1.6 for prequalified limits) shall be considered prequalified, provided they are welded with filler metals in accordance with Table 5.3 and the WPDS used conform to all the applicable requirements of this code. All other stainless steels or combinations, and WPDS which are not prequalified, shall be qualified in conformance to this Code.

-Steel for backing shall be of the same base metal group (Table 5.2 of AWS D1.6) as the base metal, unless otherwise approved.

-Neither the depth nor the maximum width in the cross-section of weld metal deposited in each weld pass shall exceed the width at the surface of the weld pass; see Figure 5.6 of AWS D1.6 Code.

-For corner joints, the outside groove preparation may be in either or both members, provided the basic groove configuration is not changed and adequate edge distance is maintained..

-Prequalification for spray mode of transfer is limited to welds in flat position and fillet welds in the flat/ horizontal positions.

**Essential Variables**

**Essential variables should be, as per Table 6.1 of the AWS D1.6 Code.** Changes to any of the essential variables require requalification of WPDS. **(Note: For Supplementary Essential variables for CVN Testing, See Table 6.2 of AWS D1.6)**

**Essential Variables when reference code in WPDS is combination of CSA W47.1/ AWS D1.6:**

**AWS D1.6:****Highlights for Essential Variables of Table 6.1:**

Following are general changes requiring a requalification for MCAW process based on Table 6.1 of AWS D1.6, however for full detail list of essential variables, Table 6.1 of AWS D1.6 applies:

- (a) a change in base metal thickness qualified per Table 6.3 of AWS D1.6
- (b) a change in F-Number (Table 6.5) and/ or A-Number (Table 6.6) of filler metal qualified
- (c) a change in the type of welding current (AC or DC) or polarity
- (d) a change in base metal M-Number or Clause 6.5 or in base metal type if unlisted
- (e) a change in deposited weld metal thickness, exceeding the maximum per Table 6.3
- (f) a change from a single gas to any other single shielding gases, or to a mixture of shielding gases, or a change in specified percentage composition of shielding gas mixture, or omission of shielding gas

**CSA W47.1:**

**CSA W47.1: Clause 11.4.2:** Essential variables for soundness and mechanical testing shall be as specified in Table 11, Table 12 and Clause 11.4.3

**CSA W47.1: Clause 11.4.3:** The PQR mechanical test essential variable changes requiring a requalification for the MCAW process shall be as follows:

- (a) a change in the base metal steel group (number) as defined in Table 17
- (b) a change in welding process
- (c) an increase in filler metal classification strength level
- (d) a change of thickness outside the range allowed by Table 13

**Note:** When required by the CSA W47.1 Standard or when there is a conflict that make the CSA W47.1 take precedence over the AWS D1.6 code (for example, when welding stainless steel of AWS D1.6 code to carbon steel of the CSA W59-18 Standard), essential variables of the CSA W47.1 Clause 11, may apply (this should be decided by an authorized company's engineer with approval of the CWB):

### **Preparation of Base Material**

The edges or surfaces of parts to be joined by welding shall be prepared by machining, grinding, chipping, plasma or air carbon arc gauging (provided that oxidized surfaces are removed). The process(es) used for removal shall be controlled in such a matter that the adjacent weld metal or base metal is not nicked or gouged and without substantial removal of the base metal. Oxyfuel gas gouging is not permitted. Where hand cutting is involved the edge will be ground to a smooth surface. All surfaces and edges shall be free from fins, tears, cracks or any other defects which would adversely affect the quality of the weld.

All moisture, grease or other foreign material that would prevent proper welding or produce objectionable fumes, shall be removed. Contact with lead, zinc, or lead or zinc compound shall be avoided due to the potential for hot cracking. Chemical cleaning only allowed under supervision of the Engineer for safety, corrosion and weldability effects (**Clause 7.21**).

All surfaces to be welded shall be wire brushed prior to welding. In multi-pass welds the weld bead shall be wire brushed between passes. The brushes shall be of stainless steel and be kept exclusively for use on stainless steel and be kept clean and free of contaminants.

All other equipment such as grinding discs shall be kept exclusively for use on stainless steels.

Back gouging of welds shall produce a groove having a profile and a depth adequate to ensure fusion with the adjacent base metal and penetration into the root of the previously deposited weld metals.

### **Welds Quality**

Cracks or blowholes that appear on the surface of any pass shall be removed before depositing the next covering pass. All welds shall be free of cracks and overlap.

The procedure and technique shall be such that undercutting of base metal or adjacent passes is minimized.

Fillet and groove welds shall meet the desirable or acceptable weld profiles specified in Clause 7.15.2, Figure 7.2, Clause 8.9, and Table 8.1 of AWS D1.6 Code.

The reinforcement in groove welds shall not exceed 3 mm (1/8 in) and shall have a gradual transition to the plane of the base metal surface. Undercut shall be limited to that described in Clauses 6.9 and 7.15.2 of AWS D1.6 Code.

In general, the weld quality will be such as to meet the requirements of Clause 8.7 of AWS D1.6 Code for both statically loaded structures and cyclically loaded structure.

### **Weld Metal Cleaning**

Slag remaining after a pass, if any, shall be removed before applying the next covering pass. After the final pass all slag and weld spatter shall be removed. Arc strikes shall be removed by grinding or other suitable means (by using only stainless steel chipping tool, brush). Cracks or blemishes caused by arc strike shall be ground to a smooth contour and examined visually to assure complete removal.

**Welding Technique**

Refer to the WPDS for the precise variables to be used in welding a particular thickness and joint configuration, position and parameters, i.e. stick-out, gas flow rate, travel speed, passes and layers, etc.

The selection of the torch angle depends on joint type, material thickness, edge preparation, in addition to the degree of skill and experience of the operator.

Generally, the forehand technique provides better visibility of the weld joint and a flatter weld puddle. The backhand technique yields better penetration. Forehand (pushing) technique usually used for butt welds while backhand (drag) technique is usually easier on fillet welds and will result in a neater weld. Torch angle is usually maintained with 10 to 20 degrees on either side of vertical.

The size of any single-pass weld or the size of the first pass of a multiple-pass weld size shall be such as to minimize the possibility of cracking.

Prior to depositing weld metal on the underside of a welding groove, the root shall be gouged, or chipped to sound metal, unless otherwise specified on the applicable WPDS.

Keep stainless steel materials clean and dry and keep them in separate place in warehouse.

Special ventilation and/or exhaust are required when welding high chromium alloys such as stainless steels.

**Engineer or Supervisor Signature**

**CWB Acceptance**