

AWS B2.1-1-233:2006
An American National Standard

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

**Argon Plus 25% Carbon
Dioxide Shielded Gas Metal
Arc Welding (Short Circuiting
Transfer Mode) followed by
Argon Plus 2% Oxygen
Shielded Gas Metal Arc
Welding (Spray Transfer
Mode) of Carbon Steel
(M-1/P-1/S-1, Groups 1 and 2),
1/8 through 1-1/2 inch Thick,
ER70S-3, As-Welded or
PWHT Condition, Primarily
Pipe Applications**

Site License



American Welding Society



Site License to Make Copies for Intra-Company Use

This License is issued by the American Welding Society (hereinafter referred to as "AWS") to you (hereinafter referred to as "Licensee") based upon your application and conditions:

1. By becoming a Licensee, Licensee agrees to all the terms contained in this License.
2. Licensee is authorized to reproduce this AWS B2 Standard Welding Procedure for intra-company use only. Copies may not be made available to any individual not employed by Licensee or for any purpose unrelated to the business being conducted by Licensee.
3. Any reproduction must include the following copyright notice: "Copyright by the American Welding Society. Reproduced with the express written permission of the American Welding Society."
4. Licensee may not enter into any sublicense agreement.
5. Reproduction of this Standard Welding Procedure signifies that you agree with the terms of the License. If you do not agree with the terms of this License please return this document, and a new document without the copyright notice will be issued.
6. The AWS B2 Standard Welding Procedures are not the subject of any warranty. AWS disclaims any liability arising from the use of any Standard Welding Procedure. AWS is not liable for any actual or consequential damages that may arise from the use of any Standard Welding Procedure.
7. Licensee will notify AWS in writing if it becomes aware that any employee or other party has made copies or otherwise made use of any Standard Welding Procedure contrary to the terms of the License.
8. This License contains the entire understanding as between Licensee and AWS, and any changes must be contained in a writing signed by both parties.
9. The terms of this License are governed under the laws of the State of Florida, and both parties agree to submit to the jurisdiction of the cognizant court of law within Dade County, Florida to resolve any disputes.

AWS B2.1-1-233:2006
An American National Standard

Approved by the
American National Standards Institute
May 3, 2006

**Standard Welding Procedure Specification (SWPS) for
Argon Plus 25% Carbon Dioxide Shielded Gas Metal Arc
Welding (Short Circuiting Transfer Mode) followed by
Argon Plus 2% Oxygen Shielded Gas Metal Arc Welding
(Spray Transfer Mode) of Carbon Steel (M-1/P-1/S-1,
Groups 1 and 2), 1/8 through 1-1/2 inch Thick,
ER70S-3, As-Welded or PWHT Condition,
Primarily Pipe Applications**

Prepared by the
American Welding Society (AWS) B2 Committee on Welding 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 through 1-1/2 inch, using Argon plus 25% Carbon Dioxide shielded gas metal arc welding (short circuiting transfer mode) for the root followed by Argon plus 2% Oxygen shielded gas metal arc welding (spray transfer mode) for the balance. It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for groove welds. This WPS was developed primarily for pipe applications.



American Welding Society

550 N.W. LeJeune Road, Miami, FL 33126

Standard Welding Procedure Specification (SWPS)

Argon Plus 25% Carbon Dioxide Shielded Gas Metal Arc Welding (Short Circuiting Transfer Mode) followed by Argon Plus 2% Oxygen Shielded Gas Metal Arc Welding (Spray Transfer Mode) of Carbon Steel (M-1/P-1/S-1, Groups 1 and 2), 1/8 through 1-1/2 inch Thick, ER70S-3, As-Welded or PWHT Condition, Primarily Pipe Applications

Welding Research Council¹—Supporting PQR Numbers:
200707, 200853, 200854, 200855,
200856, 200858, 200864, 200865

Requirements for Application of Standard SWPSs

Scope. The data to support this Standard Welding Procedure Specification (SWPS) have been derived from the above listed Procedure Qualification Records (PQRs) which were reviewed and validated under the auspices of the Welding Research Council. This SWPS is not valid using conditions and variables outside the ranges listed. The American Welding Society considers that this SWPS presents information for producing an acceptable weld using the conditions and variables listed. The user needs a significant knowledge of welding and accepts full responsibility for the performance of the weld and for providing the engineering capability, qualified personnel, and proper equipment to implement this SWPS.

Application. This SWPS is to be used only as permitted by AWS B2.1, *Specification for Procedure and Performance Qualification*, and the applicable fabrication document(s) [such as code, specification, or contract document(s)]. The fabrication document(s) should specify the engineering requirements such as design, need for heat treatment, fabricating tolerances, quality control, and examination and tests applicable to the end product.

User's Responsibility. An SWPS does not replace or substitute fabrication codes, specifications, con-

tract requirements, or capability and judgment on the part of the user. An SWPS is to be used only as permitted by the applicable fabrication code, specification, or contract document.

The ability to produce production welds having properties suitable for the application depends upon supplementing the SWPS with appropriate performance qualification tests and sound engineering judgment. The user is responsible for the quality and performance of the final product in accordance with the provisions of the fabrication document(s).

Supplementary Instructions. To adapt this SWPS to a specific application, a user may issue supplementary instructions. Such instructions may consist of tighter fit-up tolerances, higher minimum preheat temperature, or any other instructions necessary to produce a weldment that meets the requirements of the fabrication document(s). These instructions shall not be less restrictive than provided in the SWPS.

Safety. Safety precautions shall conform to the latest edition of ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society.

This specification may involve hazardous materials, operations, and equipment. The specification does not purport to address all of the safety problems associated with its use. It is the responsibility of the user to establish appropriate safety and health practices. The user should determine the applicability of any regulatory limitations prior to use.

¹Welding Research Council, P.O. Box 201547, Shaker Heights, OH 44120.