

guideWELD® LIVE MIG Welding Procedure Specifications (WPS) Included:

WPS Number	Material Thickness	Welding Position	Joint Design	Specified Weld Size	Volt Range	Wire Feed Speed	Welding Work Angle	Welding Travel Angle	Welding Travel Speed
	(T1, T2)			(AWS A2.4)	(volts)	(WFS)	(Range of Degree)	(Range of Degrees)	(Minimum ipm)
					TARGET	TARGET	TARGET	TARGET	TARGET
GM2FT10216G	16-18ga	2F	Tee	0.09	17	180	45	10	14.7
GM2FL10216G	16-18ga	2F	Lap	0.06	17	180	45	10	16.2
GM1GG8216G	16-18ga	1G	V-Groove	0.06	17	145	90	10	13.7
GM2FT1401/8	0.125	2F	Tee	0.125	18	270	45	10	13.2
GM2FL1281/8	0.125	2F	Lap	0.125	17.5	265	45	5	14.7
GM1GG1271/8	0.125	1G	V-Groove	0.125	18	230	90	10	13.2
GM2FT1701/4	0.25	2F	Tee	0.25	23	360	45	5	8.5
GM2FL1701/4	0.25	2F	Lap	0.25	23	360	45	5	10.0
GM1GG1461/4	0.25	1G	V-Groove	0.125	22.5	340	90	10	7.7

Base Material (type): All WPS's are tested with STEEL

Welding Polarity: DC

Filler Metal Size (diam.): All WPS's are tested with 0.035

Mode of Wire Transfer: All WPS's for GMAW process

Filler Metal Type (AWS classification): All WPS's are ER70S wire

Measurement Units: All WPS's are available in Metric and Imperial.

NOTE: Customizable WPS available



guideWELD® LIVE STICK Welding Procedure Specifications (WPS) Included:

WPS Number	Material Thickness	Welding Position	Joint Design	Consumable Type	Electrode Size	Amp Range	Welding Travel Speed	Welding Work Angle	Welding Travel Angle
	(inch)			(AWS Wire Class)	(inch)	(amps)	(ipm)	(Range of Degree)	(Range of Degrees)
						TARGET	TARGET	TARGET	TARGET
SM2FT1351/8	1/8	2F	Tee	E7018	1/8	120	11	45	20
SM2FL1351/8	1/8	2F	Lap	E7018	1/8	120	11	45	20
SM1GG1351/8	1/8	1G	V-Groove	E7018	1/8	120	11	90	20
SM2FT1401/4	1/4	2F	Tee	E6013	1/8	95	7	45	20
SM2FL1401/4	1/4	2F	Lap	E6013	1/8	95	7	45	20
SM1GG1401/4	1/4	1G	V-Groove	E6013	1/8	95	7	90	20
SM2FT1303/8	3/8	2F	Tee	E6010	1/8	90	6	45	20
SM2FL1303/8	3/8	2F	Lap	E6010	1/8	90	6	45	20
SM1GG1303/8	3/8	1G	V-Groove	E6010	1/8	90	6	90	20

Base Material (type): All WPS's are tested with STEEL

Welding Polarity: DC

Mode of Wire Transfer: All WPS's for SMAW process

Measurement Units: All WPS's are available in Metric and Imperial.

NOTE: Customizable WPS available

