



# Evans Metal Products Co Inc

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[www.EvansMetal.com](http://www.EvansMetal.com)

*“Building Beyond Tomorrow”*  
*Established 1945*



## **EMP's Quality Policy**

1. Provide products and services of the highest possible standards, to satisfy our customer's need, expectations of quality, safety, reliability and service.
2. We accomplish these objectives by establishing, implementing and maintaining a documented effective Quality Management System.
3. We strive to become a world-class organization.

## **Welders Habits @ Evans Metal**

May 9, 2018

1. We weld ONLY after our parts are QC's.
2. On our controlled projects, we never used uncontrolled material. All controlled material will have an Evans Metal sticker on it.
3. We can use uncontrolled material on miscellaneous steel and on our smaller projects. Management will let us know when controlled material is to be used.
4. We set our Welders to both the voltage and our amperage withing the range of our printed welding procedure.
5. Our welding gas is set to our welding procedure's pressure and the correct gas.
6. Regularly we make sure out welders are calibrated so our welding is withing voltage and amperage tolerance found in our procedures.
7. We weld in the flat position. No vertical or overhead welds.
8. We use wire that is named in our welding procedure.
9. We make sure that when the temperature is colder than 50 degrees, we preheat the material we weld. We bring material inside the day before we weld to make sure in cold weather that the material we weld falls within our procedures' temperature tolerances.
10. We make sure that our welds are not contaminated by rust or mill scale. We use wire brushes to do this. (Our QC personnel looks for wire brush marks near welds.)

David Evans

President, Evans Metal Products Co., Inc.

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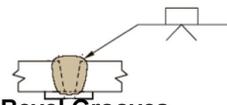
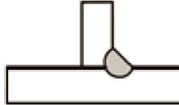
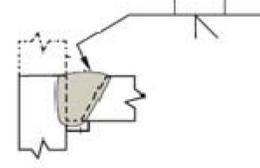
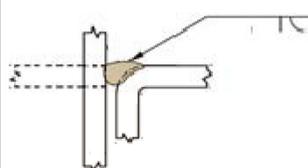
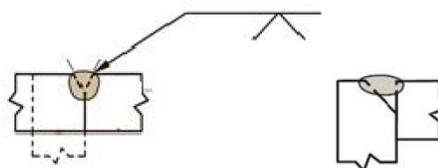


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<b>WPS Welding          Procedure          Specification          Prequalified AWS D1.1</b>	WPS	<b>PR-WPS-GMAW</b>
	<b>GMAW</b>	
	Date	<b>October 5, 2016</b>
	Authorized	<b>David Evans</b>
Revision		<b>Original</b>

Process **GMAW**

Process type **Semi automatic**

Weld Type and Joint Design	<b>Single V-Grooves          In Butt Joints Full Penetration          With backing</b> 	<b>Flare Grooves</b> 	<b>Fillet Welds</b> 	
	<b>Single Bevel Grooves          In Butt, Corner, T- Joints Full          Penetration With backing</b> 	<b>Flare Bevels</b> 	<b>V-Grooves and Bevel Grooves          In Butt or Corner Joints          Partial Penetration</b> 	
	<b>Also Double grooves without          backing and back gouged</b>			

Root opening	<b>3/16"</b>	<b>3/8"</b>	<b>1/4"</b>	Root opening	<b>0</b>
Root face	<b>0</b>	<b>0</b>	<b>0</b>	Root face	<b>3/16" min</b>
groove angle	<b>30°</b>	<b>30°</b>	<b>45°</b>	Bend radius	<b>3 T/2 min</b>

Root opening	<b>0</b>
Root face	<b>1/8" min</b>
groove angle	<b>60°</b>

Base Material (and Backing for Grooves)	<b>Group I, II including A36, A572, A992 Group I A53 Grade B, A500 Grade B</b>	
Thickness	<b>1/8" to unlimited</b>	
Filler Metal Specification	<b>AWS A5.18</b>	
Filler Metal Classification	<b>ER 70S-6</b>	
Shielding	<b>95/5% AR/O<sub>2</sub> 30-40 CFH</b>	
Positions	<b>1G, 2G (flat, horizontal) 1F, 2F (flat, horizontal)</b>	
Electrical Characteristics	<b>DCEP (DC+)</b>	
Technique	<b>Stringers and weave</b>	
Contact tube to work distance	<b>1/2" - 3/4"</b>	
Interpass cleaning	<b>Chipping and wire brush</b>	
Preheat/ Interpass Temperature	<b>≤3/4" 32°F</b>	
<b>Note: Any material temp below 32°F must be preheated and maintained to a min. temp of 70°F</b>	<b>&gt;3/4" to 1 1/2"</b>	<b>50°F</b>
	<b>&gt;1 1/2" to 2 1/2"</b>	<b>150°F</b>
	<b>&gt;2 1/2"</b>	<b>225°F</b>

Process	Position	Filler metal		Current		Volts	Travel speed (inches/min.)
		Class	Diameter	Type/polarity	Amps		
<b>GMAW</b>	<b>1G, 1F, 2G, 2F</b>	<b>ER70S-6</b>	<b>0.045"</b>	<b>DC+</b>	<b>257 (285) 313</b>	<b>25 (27) 29</b>	<b>6-10</b>