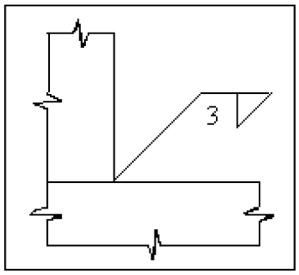
Welding Procedure Specification

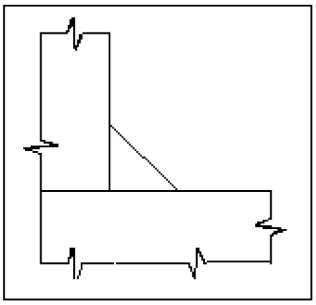
WELDING PROCESS	MMAW	**WELDING CODE(S)**	AS/NZS 1554.1 category SP
JOINT TYPE	Fillet (F1)	**WPS NO./Rev.**	MAXI-TUBE ZM275 MMAW Fillet
JOINT POSITION	Horizontal (2F)	**PQR NO.**	TBA
POSITIONS QUALIFIED	Flat and horizontal	**CLIENT**	TBA
WELD DIRECTION	N/a	**JOB NO.**	N/a

JOINT TOLERANCES		MATERIALS WELDED & QUALIFIED		CONSUMABLE DETAILS	
Root gap (G) mm	0 to 1	Spec./Class - 1	AS 1163 C350L0	Brand Name	BOC SmoothArc 12
Root face (F)	N/a	Thickness/dia. - 1	2mm	Classification - 1.	AS/NZS 4855 B-E 43 13 A
Root Radius (R)	N/a	Spec./Class. - 2	N/a	Classification - 2.	AS/NZS 1553.1 E4112-0
Included angle (A)°	N/a	Thickness/dia. - 2	N/a	Alternative Brand	BOC SmoothArc 13
Backing type	N/a	Thickness Range	1.6 to 6mm	Baking temperature	N/a
Backing size	N/a	Diameters Range	N/a	Hold temperature	N/a

WELD PREPARATION



PASS SEQUENCE



MATERIAL PREPARATION		THERMAL TREATMENT			
		Parent Material Preheat (°C)		POST WELD HEAT TREATMENT	
Method	Saw	Preheat method	N/a	PWHT method	N/a
Pre-weld clean	Degrease	Preheat temperature	N/a	Heating rate	N/a
Interpass clean	N/a	Max. inter-pass temp.	N/a	Soak temp.	N/a
Gouge method	N/a	Temp. check method	Pyrometer	Cooling rate	N/a
Dressing	Flapper disc	Temp. check location	75mm from joint	Withdrawal temp	N/a
Weld finish	N/a				

PASS DETAILS			CONSUMABLE DETAILS			GAS	WELDING PARAMETERS					HEAT INPUT
No.	Side	Position	Classification	Size ∅ (mm)	Flux Class	Flow l/min	Amps	Volts	Travel mm/min	W.F.S m/min	Polarity	kJ/mm
1	1	Horizontal	E 43 13 A	3.2	N/a	N/a	105 to 125	20 to 24	200 to 250	4 to 5	Neg.	0.5 to 0.9

OTHER PASS DETAILS		SHIELDING GASE(S) DETAILS			
			Brand name	Composition	Flowrate (l/min)
Max bead width	N/a	Shielding gas:	N/a	N/a	N/a
Electrical stick-out	N/a	Trailing / secondary:	N/a		
Mode of arc transfer	N/a	Purging gas:	N/a		
Leading/Trailing arc	N/a	Max. 02 at weld root			
Weave/Stringer runs	Stringer				

Notes	GTAW DETAILS		APPROVALS		DATE
This procedure is an indication of good welding practice only, and should not be considered as qualified.	Nozzle size	N/a	Contractor Signature		
	Tungsten diameter	N/a			
	Tungsten type	N/a	Clients Rep. Signature		
	High frequency start	N/a			
All dimensions are in millimeters, temperature in Celsius UOS.	Gas lense size	N/a	Cert. Authority Signature		
	Other	N/a			

		REFERENCE TO WORK INSTRUCTION			
WPS STATUS	TBQ				
PREPARED BY	Peter Kuebler IWE	**Number/Rev.**		**Title**	
DATE	17.12.2013	**Number/Rev.**		**Title**	