

# Welding Procedure Specification

Client:	Mobil		Project:	221010Geates		REF No.	WPS 6 R1	
Procedure Description:	12" Heavy Wall Offshore Tie-in					02901/WPS5		
Material:	AS3679.1 Grade 250 API 5L X65			Diameter:	168.3		Thickness:	18.3
Position:	6G			Clamp Type:	Internal			
Preheat °C (Min):	100			Interpass °C (Max):	200			
Welding Process		ROOT		HOT PASS			FILL & CAP	
		SMAW		SMAW			SMAW	
Welding Direction		Vertical Down			Vertical Down			Vertical Down
Filler		Lincoln SATO+			Lincoln SATO+			Bolder BVD90GM
Polarity		DC +ve			DC +ve			DC +ve
Shielding Gas		N/A			N/A			N/A
Purge Gas		N/A			N/A			N/A
Pass No	Filler Size (mm)	Amps	Volts	Speed (mm/min)	Heat Input (kJ/mm)	Weld Preparation		
1	3.2 mm	70-130	18-33	3.3-6.6	0.4-0.8			
2	4.0 mm	110-210	18-35	2.9-6.2	0.6-1.3			
FILL	4.0 mm	145-260	16-27	1.6-7.0	0.6-1.2			
CAP	4.0 mm	130-230	16-26	1.8-6.2	0.6-1.7			
NOTES								
<ol style="list-style-type: none"> <li>1. API Std 1104/SP3094-SP-PL-3010R1</li> <li>2. Clamp removal gage: 100% completion of root (external clamp may be used in the event of a breakdown – removed after 50% minimum completion of the root.)</li> <li>3. Time lapse between root and second pass: 16 Minutes</li> <li>4. Time lapse between second pass and 1<sup>st</sup> fill: 12 Minutes</li> <li>5. Minimum number of passes before pipe movement: 2 passes</li> <li>6. Minimum number of passes before break in welding: 3 passes</li> <li>7. Minimum Number of welders- Root &amp; second pass: 2 , Fill &amp; Cap : 1</li> <li>8. Method of cleaning: Grinder / Wire brush</li> <li>9. Method of Preheat: Gas Torch</li> <li>10. Qualification reference number: 48280/PP/WP6 R1</li> </ol>								
Pass Location								
Company Welding Engineer Approved					Approved for Client			

# Welding Procedure Specification Guide

**American Welding Society**

## **Welding Procedure Specification Guide:**

*A Quick Guide to Welding and Weld Inspection* S E Hughes, 2009-10-20 A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector. In covering both European and US based codes the book gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter. A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector. Covers both European and US based codes. Gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter.

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**Practical Reference Guide for the Qualification of Welding Procedure Specifications**, 2008-01-01    **ASME Section IX Simplified: Fundamentals, Variables, Welder Qualification, Compliance and Audits**

Sumitra Kumari, Master the complexities of ASME Section IX with this comprehensive easy to understand guide designed for welding inspectors engineers and quality control professionals. ASME Section IX Simplified breaks down the fundamentals of welding procedure and performance qualification making it accessible for both beginners and experienced professionals. Whether you're preparing for welder qualification ensuring compliance or navigating audits this ASME Section IX welder qualification book provides clear explanations real world applications and expert insights to help you succeed. What You'll Learn Fundamentals of ASME Section IX Key concepts explained in simple language Welding Variables Essential non essential and supplementary variables demystified Welder Qualification Step by step guides for GMAW GTAW SMAW FCAW and SAW in all positions Compliance Audits How to avoid common failures and maintain certification Material Filler Metal Selection Understanding P Numbers F Numbers and A Numbers This welder qualification book is an essential resource for anyone working with welding qualification and compliance under ASME Section IX. Whether you're a welding inspector engineer or quality control professional this guide will boost your expertise and confidence in handling welder and procedure qualification with ease.

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