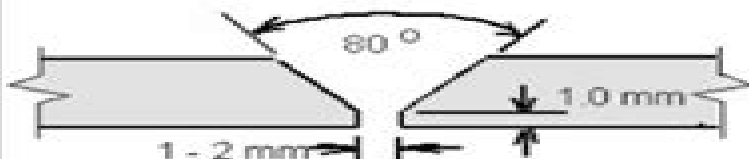



Welding Procedure Specification:- Example

Weld Procedure Number		30 P1 TIG 01 Issue A	
Qualifying Welding Procedure (WPAR)		WP T17/A	
Manufacturer:	National Fabs Ltd 25 Lane End Birkenshaw Leeds	Method Of Preparation and Cleaning:	Machine and Degrease
Location:	Workshop	Parent Metal Specification:	Grade 304L Stainless Steel
Welding Process:	Manual TIG	Parent Metal Thickness:	3 to 8mm Wall
Joint Type:	Single Sided Butt Weld	Pipe Outside Diameter:	25 to 100mm
		Welding Position:	All Positions
		Welding Progression:	Upwards

Joint Design	Welding Sequences
	

Run	Process	Size Of Filler Metal	Current A	Voltage V	Type Of Current/Polarity	Wire Feed Speed	Travel Speed	Heat Input
1 2 And Subs	TIG TIG	1.2mm 1.6mm	70 - 90 80 - 140	N/A	DC- DC-	N/A	N/A	N/A

Welding Consumables:- Type, Designation Trade Name: Any Special Baking or Drying:	BS 2901 Part 2 : 308S92 No	Production Sequence
Gas Flux:	Argon 99.99% Purity	1. Clean weld and 25mm borders to bright metal using approved solvent.
Gas Flow Rate - Shield:	8 - 12 LPM	2. Position items to be welded ensuring good fit up and apply
- Backing:	5 LPM	

Weld Design Manual

**Wire Reinforcement Institute.
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Weld Design Manual:

Manual of Design for Arc Welded Steel Structures ,1946 *Jig and Fixture Design Manual* Erik Karl Henriksen,1973 Written for the experienced engineer as well as the student this comprehensive and easy to understand reference presents the fundamental principles for combining the components into successful fixtures It includes metric conversion tables and appendices on transfer tolerances measuring of tolerances measuring of angles in radians and the dimensioning of fixtures by stress analysis *Pressure Vessel Design Manual* Dennis R. Moss,2004-01-24 A pressure vessel is a container that holds a liquid vapor or gas at a different pressure other than atmospheric pressure at the same elevation More specifically in this instance a pressure vessel is used to distill crack crude material taken from the ground petroleum etc and output a finer quality product that will eventually become gas plastics etc This book is an accumulation of design procedures methods techniques formulations and data for use in the design of pressure vessels their respective parts and equipment The book has broad applications to chemical civil and petroleum engineers who construct install or operate process facilities and would also be an invaluable tool for those who inspect the manufacturing of pressure vessels or review designs ASME standards and guidelines such as the method for determining the Minimum Design Metal Temperature are impenetrable and expensive avoid both problems with this expert guide Visual aids walk the designer through the multifaceted stages of analysis and design Includes the latest procedures to use as tools in solving design issues

Handbook for Welding Design Institute of Welding,C. Rowland Harman,1956 *Arc-welding Manual for the Design and Control of Welded Construction* United States. Bureau of Reclamation,1950 *Heat Exchanger Design Handbook* Kuppam Thulukkanam,2013-05-20 This comprehensive reference covers important aspects of heat exchangers HEs design and modes of operation and practical large scale applications in process power petroleum transport air conditioning refrigeration cryogenics heat recovery energy and other industries This second edition includes over 400 drawings diagrams tables and equations includes updated material throughout coverage of the latest advances in HE design techniques expanded and updated coverage of materials selection and a look at the newest fabrication techniques *General Design Standards* United States. Bureau of Reclamation,1992 *Procedure Handbook of Arc Welding, Design and Practice* Lincoln Electric Company,1940 **Welding Design Handbook for Engineers** ,1948 *Manual for Structural Welding Design and Practice* ,1971 *Building Design Handbook Wire Reinforcement* Institute. Technical Committee,1960 *Handbook of Structural Steel Connection Design and Details* Akbar R. Tamboli,1999 The most comprehensive guide to LRFD connection design available Gain access to the expertise of the top LRFD designers working today with this superlative book and CD ROM package It not only gives you the best and latest methods in connection design it supplies Fabricated examples on the CD ROM that you can use for instant application and configuration of your own designs Featuring a broad range of design methods and details the Handbook demonstrates the newest techniques and materials in welded joint design and production

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