

Welding Procedure Specification

Client:	Mobil		Project:	221010Geates		REF No.	WPS 6 R1	
Procedure Description:	12" Heavy Wall Offshore Tie-in					02981/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"> 1. API Std 1104/SP3094-SP-PL-3010R1 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.) 3. Time lapse between root and second pass: 16 Minutes 4. Time lapse between second pass and 1st fill: 12 Minutes 5. Minimum number of passes before pipe movement: 2 passes 6. Minimum number of passes before break in welding: 3 passes 7. Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1 8. Method of cleaning: Grinder / Wire brush 9. Method of Preheat: Gas Torch 10. Qualification reference number: 48280/PP/WP6 R1 								
Pass Location								
Company Welding Engineer Approved					Approved for Client			

Welding Procedure Specification Guide

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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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R. Rao,2006 This is Volume 1 of the fully revised second edition Organized to provide the technical professional with ready access to practical solutions this revised three volume 2 100 page second edition brings to life essential ASME Codes with authoritative commentary examples explanatory text tables graphics references and annotated bibliographic notes This new edition has been fully updated to the current 2004 Code except where specifically noted in the text Gaining insights from the 78 contributors with professional expertise in the full range of pressure vessel and piping technologies you find answers to your questions concerning the twelve sections of the ASME Boiler and Pressure Vessel Code as well as the B31 1 and B31 3 Piping Codes In addition you find useful examinations of special topics including rules for accreditation and certification perspective on cyclic impact and dynamic loads functionality and operability criteria fluids pipe vibration stress intensification factors stress indices and flexibility factors code design and evaluation for cyclic loading and bolted flange joints and connections

Welding Handbook American Welding Society,2001 Scientific and Technical Aerospace Reports ,1987 Practical Reference Guide for the Qualification of Welding Procedure Specifications ,2008-01-01

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Henderson,Canadian Institute of Steel Construction,1992 **Handbook of Valves and Actuators** Brian Nesbitt,2007-08-02 Industries which use pumps seals and pipes will almost certainly also use valves in their systems Someone in each industry needs to be able to design purchase or maintain the right valve for the job in hand and that can amount to a lot of valves world wide Here is a single resource which is aimed at those designers and end users plus their

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