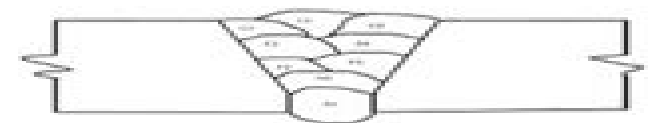


Company logo	<b>WELDING PROCEDURE SPECIFICATION (WPS)</b>		
<b>PROJECT NAME</b>			
<b>PJT Contract Number</b>			
<b>WPS No. :</b>		<b>Date :</b>	
<b>Supporting PQR No. :</b>			
<b>Procedure for :</b>	24" X 12.7MM		
<b>Welding Process</b>	SMAW / MANUAL		
<b>Applicable Code ;</b>	ASME B31.3, ASME IX		

### JOINT

<b>Joint Design :</b>	See Below	<b>Bevel Angle :</b>	30° ± 5°
<b>Backing :</b>	N/A	<b>Root Gap :</b>	2mm ± 0.4mm
<b>Backing Material :</b>	N/A	<b>Root Face :</b>	1.6mm ± 0.8mm



### BASE METAL

<b>Material Specification Type &amp; Grade :</b>	API 5L X60
<b>Material Items (Name)</b>	Pipe to Pipe or Pipe to fittings (CE shall not increase with more than 0.03)
<b>Pipe Diameter Qualified</b>	24"
<b>Pipe Diameter Range</b>	12" - 36"
<b>Pipe Thickness Qualified:</b>	12.7mm
<b>Pipe Thickness Range :</b>	9.5mm - 19.05mm

### FILLER METALS

Weld Run	Size	Electrode Brand	AWS Specification	AWS Classification
ROOT	1/8" (3.2mm)	Lincoln Fleet Weld	A 5.1	E 6010 SP+
HOT PASS	1/8" (3.2mm)	Lincoln Jet Weld	A 5.1	E 7018 H4R
FILLING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R
CAPPING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R

### ELECTRODE STORAGE

<b>Electrode Drying Conditions:</b>	E6010	As per manufacturer's recommendation for handling and storage. Re-drying not recommended
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# Welding Procedure Specification Guide

**M Mark**



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