

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"> 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

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.

Companion Guide to the ASME Boiler & Pressure Vessel Code K. 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 **Welding Handbook: Welding processes** American Welding Society,1987 *Light Rail Transit Car Specification Guide* ,1981 **Minnesota Rules** ,2007 Process Pipe and Tube Welding W Lucas,1991-05-31 The welding of tubes is an essential requirement in the fabrication of components in many industries The original idea for this book came from a seminar organized by The Welding Institute which attracted over 100 specialists concerned with design fabrication production and quality assurance and yielded a number of valuable papers Process Pipe and Tube Welding contains some of these papers together with additional chapters to provide comprehensive coverage of all aspects of tube welding from initial design considerations through production to final inspection In the first three chapters the authors outline the process and equipment options available for both manual and mechanized welding This is essential for design and production planning when faced with the choice of competing processes such as MMA MIG TIG or plasma helping engineers make the right choice for particular applications and ensuring the most cost effective welding techniques are employed Five further chapters are devoted to the application of tube welding in the aero engine ship building power generation petrochemical and chemical plant industries with numerous details on processes materials techniques and equipment The welding parameters and production data provided by the authors are a valuable source of information and will help engineers to overcome problems in production This title includes Process options and manual techniques for welding pipework fabrications Mechanised arc welding process options for pipework fabrications Process techniques and equipment for mechanised TIG welding of tubes Welding pipes for aero engines TIG welding pipework for ships Automatic tube welding in boiler fabrication TIG and MIG welding developments for fabrication of plant for the chemical petrochemical and offshore oil and gas industries Fabrication of aluminium process pipework A fabrication system for site mechanical construction Qualification of welding procedures for the chemical process industry Non destructive examination of welds in small diameter pipes

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