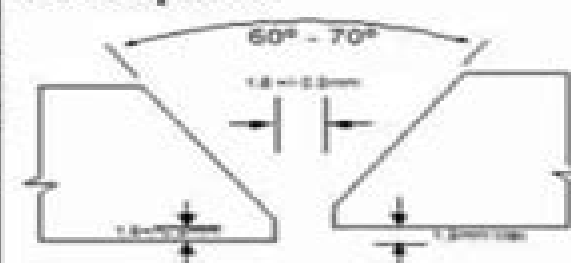


Welding Procedure Specification

Client:	Mobil	Project:	221010Goatee	REF No.	WPS 6 R1	
Procedure Description:		12" Heavy Wall Offshore Tie-in			0290/1/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):	300		
Welding Process		ROOT SMAW		HOT PASS SMAW		FILL & CAP SMAW
Welding Direction		Vertical Down		Vertical Down		Vertical Down
Filler		Lincoln SA70+		Lincoln SA70+		Böhler BVD90M
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/sec)	Heat Input (kJ/mm)
1	3.2mm	70-130	18-33	3.3-6.6	0.4-0.8
2	4.0mm	110-210	18-35	2.9-6.3	0.6-1.3
FILL	4.0mm	145-260	16-27	1.6-7.0	0.6-2.2
CAP	4.0mm	180-230	16-26	1.8-6.3	0.6-1.7

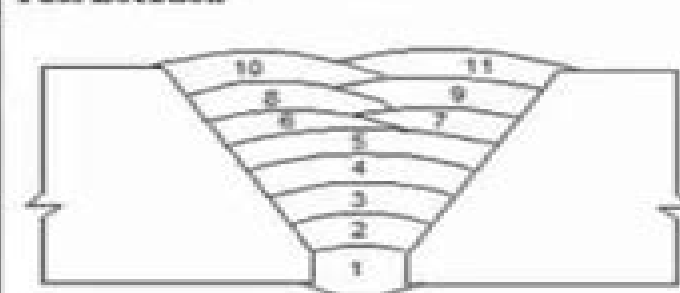
Weld Preparation



NOTES

- API Std 1104BP3094-SP-PL-3010R1
- Clamp removal stage: 100% completion of root (external clamp may be used in the event of a breakdown - removed after 50% minimum completion of the root.)
- Time lapse between root and second pass : 16 Minutes
- Time lapse between second pass and 1st fill : 12 Minutes
- Minimum number of passes before pipe movement : 2 passes
- Minimum number of passes before break in welding : 3 passes
- Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1
- Method of cleaning : Grinder / Wire brush
- Method of Preheat : Gas Torch
- Qualification reference number : 48250/PP/WP6 R1

Pass Location



**Company Welding
Engineer Approved**

Approved for Client

Welding Procedure Specification Guide

**J. A. Packer, J. E. Henderson, Canadian
Institute of Steel Construction**



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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 *Quality Assurance Representative's Guide* ,1992 **Construction Inspector's Guide: Architectural and structural features in building construction** ,1982 Quality Assurance Representative's Guide: Architectural and structural features in building construction ,1992 **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

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