

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

JG Myers

Welding Procedure Specification Guide:

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