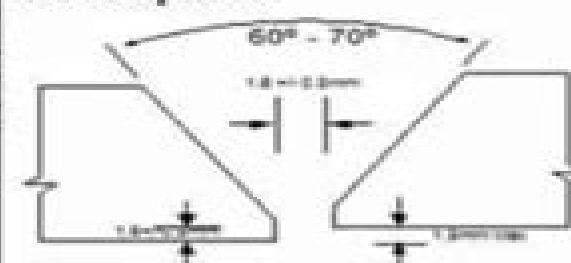


Welding Procedure Specification

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	130-230	16-26	1.8-6.3	0.6-1.7

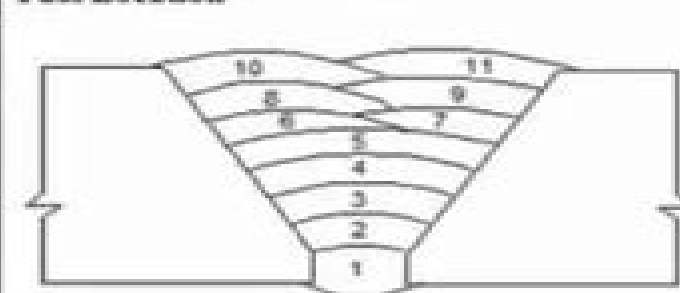
Weld Preparation



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

American Welding Society

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Pullarcot, 2002-01-22 Explores vessel fabrication and the corresponding procedures of quality and control Details the necessary methods for code specification compliance Clarifies the inspection testing and documentation of the ASME code

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Welding Handbook American Welding Society, 2001

Quality Management in Welded Fabrication Serhii Fomichov, Yevgenia Chvertko, Serhii Minakov, Igor Skachkov, Anna Banin, 2023-08-23 This book focuses on topics in the field of welding science technologies and equipment with a particular emphasis on quality management The textbook consists of four modules covering quality management basics measurement imperfections and non destructive testing The material is presented in an illustrated and uncomplicated manner The textbook is based on the experience of professors of the National Technical University of Ukraine and the Approved Training Body for International Welding Engineers and Technologists of the International Institute of Welding making it an ideal resource for graduate and postgraduate students university professors and welding specialists

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