

WELDING PROCEDURE SPECIFICATION
ASME SEC IX Ed. 2004

Date:
Page: 1 of 2

Welding Procedure Specs No.: WPS-01-WQT, W-P-SS-001

Welding Process : SMAW

Type : Manual

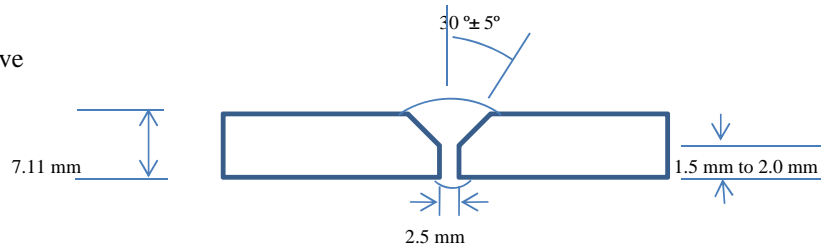
JOINTS (QW-402)

Joint Design : Single "V" Groove

Backing (Yes/No.) : No

Welding Position : 6G

Welding Progression: Uphill



BASE METAL (QW-403)

P No.: 1 Group No.: 1 TO P No.: 1 Group No.: 1

Specs. Type & Grade : ASTM A53 GR. B

Thickness of Test Plate: 7.11 mm , Dia. : 6 "

Thickness Range : Groove- 1.5 mm to 14.22 mm max.

Diameter range : 2 7/8 to unlimited

GAS (QW-408)

Shielding Gas : N/A

Percent Composition (Mixture) : N/A

FILLER METAL (QW-404)

F No.: 3/4 A No.: 1

Spec. No. (SFA) : 5.1

AWS No. (Class No.): E6010/E7018

Size of Electrode : 2.5 mm/2.5-3.2 mm

ELECTRICAL CHARACTERISTICS (QW-409)

Current AC or DC : DC

Polarity : DCEN (Root); DCEP (Fill, Cap)

Amps. Range : 60 - 140

Volts Range : 17 - 34

Tungsten Electrode Size and Type: N/A

Electrode Wire Speed & Range : N/A

POSITIONS (QW-405)

Position of Groove: 6G

Welding Progression: Uphill

Position of Fillet : N/A

TECHNIC (QW-410)

String or Weave Bead : String or Weave
(Max. 3 X Electrode Dia.)

Initial & Interpass Cleaning: Chipping, Grinding &
Wire brushing

Method of Back Gouging: N/A

Oscillation : N/A

Multiple or Single Pass (per side): Multiple

Multiple or Single Electrode : Single

Travel Speed Range : 1.33 mm/ sec.- 1.83 mm/sec.

PREHEAT (QW-406)

Preheat Temperature Min.: 27 deg. C (Remove Moisture)

Preheat Temperature Max.: 250 Deg. C

Preheat Maintenance : N/A

POST WELD HEAT TREATMENT (QW-407)

Temperature Range: N/A

Time Range : N/A