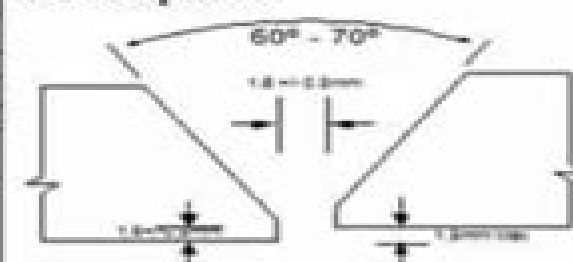


Welding Procedure Specification

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

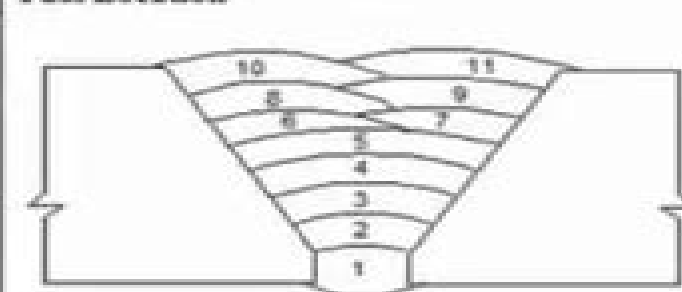
Weld Preparation



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

Sumitra Kumari



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Furthermore this piping handbook provides an important indication of the important project related factors hard factors and organizational related factors soft factors to achieve the desired project performance dimensions such as timely completion cost control acceptable quality safe execution and financial performance Lastly the role of ISO management systems such as ISO 9001 ISO 14001 and OHSAS 18001 in construction projects is widely known across the industry however oil and gas specific ISO quality management systems such as ISO 29001 and project specific management systems such as ISO 21500 are not widely known in the industry which are explained in detail in this handbook for the benefit of the oil and gas construction organizations Features Covering the stages from the raw material to project completion to handover and beyond Providing practical guidelines to oil and gas piping contractors for training purposes and best practices in the oil and gas industry Emphasizing project related factors hard factors and organizational related factors soft factors with a view to achieve the desired project performance Highlighting the roles of ISO management systems in oil and gas projects

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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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