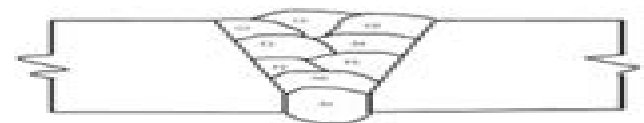


Company logo	WELDING PROCEDURE SPECIFICATION (WPS)		
PROJECT NAME			
PJT Contract Number			
WPS No. :		Date :	
Supporting PQR No. :			
Procedure for :	24" X 12.7MM		
Welding Process	SMAW / MANUAL		
Applicable Code :	ASME B31.3, ASME IX		

JOINT

Joint Design :	See Below	Bevel Angle :	30° ± 5°
Backing :	N/A	Root Gap :	2mm ± 0.4mm
Backing Material :	N/A	Root Face :	1.6mm ± 0.8mm



BASE METAL

Material Specification Type & Grade :	API 5L X60
Material Items (Name)	Pipe to Pipe or Pipe to fittings (CE shall not increase with more than 0.03)
Pipe Diameter Qualified	24"
Pipe Diameter Range	12" - 36"
Pipe Thickness Qualified:	12.7mm
Pipe Thickness Range :	9.5mm - 19.05mm

FILLER METALS

Weld Run	Size	Electrode Brand	AWS Specification	AWS Classification
ROOT	1/8" (3.2mm)	Lincoln Fleet Weld	A 5.1	E 6010 SP+
HOT PASS	1/8" (3.2mm)	Lincoln Jet Weld	A 5.1	E 7018 H4R
FILLING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R
CAPPING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R

ELECTRODE STORAGE

Electrode Drying Conditions:	E6010	As per manufacturer's recommendation for handling and storage. Re-drying not recommended
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Welding Procedure Specification Guide

Brian Nesbitt



Welding Procedure Specification Guide:

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 *Construction Inspector's Guide: Architectural and structural features in building construction* ,1982 **Quality Assurance Representative's Guide** ,1992 Quality Assurance Representative's Guide: Architectural and structural features in building construction ,1992 **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 intensification factors stress indices and flexibility factors code design and evaluation for cyclic loading and bolted flange joints and connections **Welding Handbook** American Welding Society, 2001 Scientific and Technical Aerospace Reports ,1987 Welding Handbook: Welding processes American Welding Society, 1987 *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

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The book delves into Welding Procedure Specification Guide. Welding Procedure Specification Guide is an essential topic that must be grasped by everyone, ranging from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into Welding Procedure Specification Guide, encompassing both the fundamentals and more intricate discussions.

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 - Chapter 3: Welding Procedure Specification Guide in Everyday Life
 - Chapter 4: Welding Procedure Specification Guide in Specific Contexts
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6. In chapter 5, this book will draw a conclusion about Welding Procedure Specification Guide. This chapter will summarize the key points that have been discussed throughout the book.

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