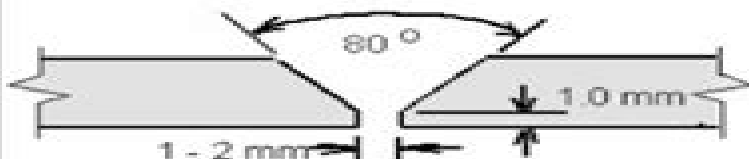



Welding Procedure Specification:- Example

Weld Procedure Number		30 P1 TIG 01 Issue A	
Qualifying Welding Procedure (WPAR)		WP T17/A	
Manufacturer:	National Fabs Ltd 25 Lane End Birkenshaw Leeds	Method Of Preparation and Cleaning:	Machine and Degrease
Location:	Workshop	Parent Metal Specification:	Grade 304L Stainless Steel
Welding Process:	Manual TIG	Parent Metal Thickness:	3 to 8mm Wall
Joint Type:	Single Sided Butt Weld	Pipe Outside Diameter:	25 to 100mm
		Welding Position:	All Positions
		Welding Progression:	Upwards

Joint Design	Welding Sequences
	

Run	Process	Size Of Filler Metal	Current A	Voltage V	Type Of Current/Polarity	Wire Feed Speed	Travel Speed	Heat Input
1 2 And Subs	TIG TIG	1.2mm 1.6mm	70 - 90 80 - 140	N/A	DC- DC-	N/A	N/A	N/A

Welding Consumables:- Type, Designation Trade Name: Any Special Baking or Drying:	BS 2901 Part 2 : 308S92 No	Production Sequence
Gas Flux: Gas Flow Rate - Shield: - Backing:	Argon 99.99% Purity 8 - 12 LPM 5 LPM	1. Clean weld and 25mm borders to bright metal using approved solvent. 2. Position items to be welded ensuring good fit up and apply

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Table of Contents Welding Types And Specification Manual

1. Understanding the eBook Welding Types And Specification Manual
 - The Rise of Digital Reading Welding Types And Specification Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Welding Types And Specification Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Welding Types And Specification Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Welding Types And Specification Manual
 - Personalized Recommendations
 - Welding Types And Specification Manual User Reviews and Ratings
 - Welding Types And Specification Manual and Bestseller Lists

5. Accessing Welding Types And Specification Manual Free and Paid eBooks
 - Welding Types And Specification Manual Public Domain eBooks
 - Welding Types And Specification Manual eBook Subscription Services
 - Welding Types And Specification Manual Budget-Friendly Options
6. Navigating Welding Types And Specification Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Welding Types And Specification Manual Compatibility with Devices
 - Welding Types And Specification Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Welding Types And Specification Manual
 - Highlighting and Note-Taking Welding Types And Specification Manual
 - Interactive Elements Welding Types And Specification Manual
8. Staying Engaged with Welding Types And Specification Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Welding Types And Specification Manual
9. Balancing eBooks and Physical Books Welding Types And Specification Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Welding Types And Specification Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Welding Types And Specification Manual
 - Setting Reading Goals Welding Types And Specification Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Welding Types And Specification Manual
 - Fact-Checking eBook Content of Welding Types And Specification Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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