

PROPOSED WELDING PROCEDURE SPECIFICATION (pWPS)

Organization Name PT. INOFAB By Eka Yulikal Putra
WPS No. 001/WPS/RF/ASME/2015 Date 10-Mar-16 Page No. 1 of 3
Revision No. 1
Supporting PQR No.(s) 001/PQR/RF/ASME/2015
Welding Process(es) GTAW + SMAW Type(s) Manual
Automatic, Manual, Machine or Semi-Automatic

JOINTS (QW-402)

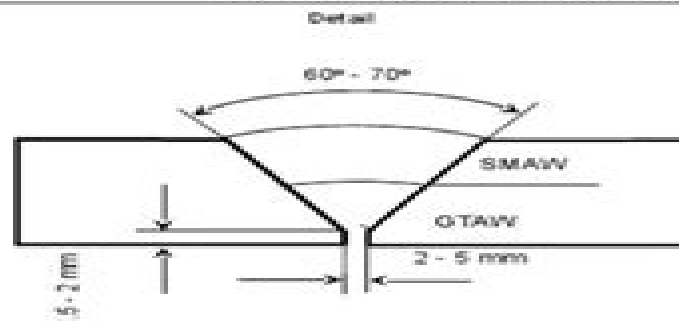
Joint Design *see below
Root Spacing 2 - 5 mm
Backing: No for GTAW, Yes for SMAW
Backing Material (Type) Weld Metal

☐ Metal ☐ Non fusing Metal
☐ Non Metallic ☐ Other (Weld Metal)

Refer to both backing & retainers.

Sketches, Production Drawing, Weld Symbol or Written Description should show the general arrangement of the parts to be welded. Where applicable, the detail of weld groove may be specified.

*Refer to Page 3 of 3 for other joint configurations qualified


BASE METAL (QW-403)

P No. 1 Group No. 1 to P No. 1 Group No. 1

OR

Specification and type/grade or UNS No. N/A

to Specification and type/grade or UNS No. N/A

OR

Chem. Analysis and Mech. Prop. N/A

to Chem. Analysis and Mech. Prop. N/A

Thickness Range

Base Metal: Groove 5 - 28.54 mm (without impact) (6" Sch. 120) Fillet

Maximum Pass Thickness ≤ 1/4 in. (13 mm) (Yes) ☐ (No) ☐

Other -

FILLER METAL (QW-404)

	GTAW	SMAW
Spec. No. (SFA)	SFA-5.18	SFA-5.1
AWS No. (Class)	ER70S-6	E7018
F No.	6	4
A No.	1	1
Size of Filler Metal	22.4 mm	23.2 mm
Filler Metal Product Form	Bare (Solid)	N/A
Supplemental Filler Metal	None	None
Weld Metal		
Deposited Thickness		
Groove		
Fillet	A3	A3
Addition of Flux	None	None
Electrode-Flux (Class)	N/A	N/A
Flux Type	N/A	N/A
Electrode/Wire Trade Name	TG-551T	LB-52-18
Consumable Insert	None	N/A

Pwp Welding Procedures

Lingjun Ying



Pwp Welding Procedures:

The Enigmatic Realm of **Pwp Welding Procedures**: Unleashing the Language is Inner Magic

In a fast-paced digital era where connections and knowledge intertwine, the enigmatic realm of language reveals its inherent magic. Its capacity to stir emotions, ignite contemplation, and catalyze profound transformations is nothing in short supply of extraordinary. Within the captivating pages of **Pwp Welding Procedures** a literary masterpiece penned by way of a renowned author, readers attempt a transformative journey, unlocking the secrets and untapped potential embedded within each word. In this evaluation, we shall explore the book's core themes, assess its distinct writing style, and delve into its lasting effect on the hearts and minds of those that partake in its reading experience.

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