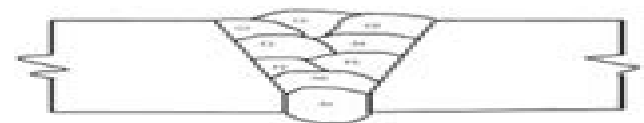


Company logo	WELDING PROCEDURE SPECIFICATION (WPS)		
PROJECT NAME			
PJT Contract Number			
WPS No. :		Date :	
Supporting PQR No. :			
Procedure for :	24" X 12.7MM		
Welding Process	SMAW / MANUAL		
Applicable Code :	ASME B31.3, ASME IX		

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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Brian Nesbitt



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Welding Handbook: Welding processes R. L. O'Brien, American Welding Society, 1987

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Welding Handbook American Welding Society, 2001

Scientific and Technical Aerospace Reports ,1987

The Manager's Guide to ISO 9000 Kenneth L. Arnold, 1994 This step by step guide to ISO 9000 presents an in depth study of the 5 phases of certification lists requirements for certification and provides examples of implementation

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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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Steel Detailers' Manual Alan Hayward, Frank Weare, A. C. Oakhill, 2011-05-06 This highly illustrated manual provides practical guidance on structural steelwork detailing It describes the common structural shapes in use and how they are joined to form members and complete structures explains detailing practice and conventions provides detailing data for standard sections bolts and welds emphasises the importance of tolerances in order to achieve proper site fit up discusses the important link between good detailing and construction costs Examples of structures include single and multi storey buildings towers and bridges

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