WELDING PROCEDURE SPECIFICATION (WPS)

ACCORDING TO API 1104

COMPANY NAME	: GASCO
PROJECT NAME	: Dahshor~Bany Swief 36" pipeline
WELDING PROCEDURE SPECIFICATION No.	: P01 Main Pipeline
REVISION NO.	: 0
SUPPORTING PQR NO.	: PQR (PL-62/2016)
TYPES (Manual, Automatic, Semi Auto.)	: MANUAL (SMAW)

JOINTS DESIGN
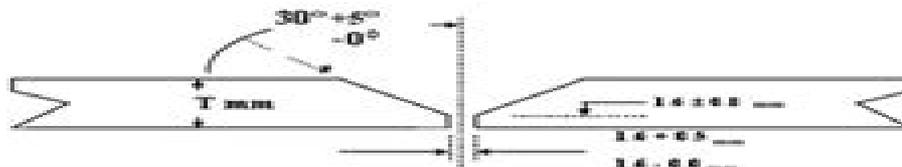
BASE METAL

Material Spec.	: API-5L
Type or Grade	: X-65
P No.	: 01
A No.	: 01
Thickness	: 4.8 ≤ T ≤ 19.05 mm
Diameter	: 36"
Other	:

FILLER METALS

Weld Metal Analysis A No.	: A1
Size of Electrode	: 3.25, 4.0 & 5.0 mm
Filler Metal No.	: F3
S F A Specification	: A 5.1 & A 5.5
AWS Classification	: E 6010 & E 8010G

POSITION

Position of Groove	: 5G
Direction of welding	: All Down-Hill
Other	:

PREHEAT

Preheat Temp . (°C) (Min)	: 30°C(if needed)
Interpass Temp . (°C) (Max.)	: 250 °C Max
Other	: N.A.

POSTWELD HEAT TREATMENT

Temperature Range	: N.A.
Time Range	: N.A.
Other	: N.A.

GAS

Type of Gas or Gases	: N.A.
Composition of Gas Mixture	: N.A.
Other	: N.A.

ELECTRICAL CHARACTERISTICS

Current	: DC
Polarity	: -ve & +ve

WELD LAYERS	FILLER METAL Class	FILLER METAL Diam. (mm.)	CURRENT Polar.	CURRENT Amp. range	VOLTAGE RANGE
1st	E6010	3.25	-ve	90- 110	20-22
2nd	E8010G	4.00	+ve	120-180	20-27
3rd	E8010G	4.00	+ve	120-180	20-27
4th	E8010G	5.00	+ve	120-180	20-27
CAP	E8010G	5.00	+ve	120-180	20-27

TECHNIQE

Interpass Cleaning	: Root Grinding & Wire Brush
String or Weave Bead	: Both
Orifice or Gas Cup Size	: N.A.
Multipass or Single Pass	: Multi-passes
Single or Multiple Electrodes	: Single
LINE UP CLAMP	: Remove Internal Clamp after 100% of the Root Pass

Maximum time between 1st and 2nd pass (5 minutes)

Maximum time between 2nd pass and others Shortly

JOB TITLE	PETROJET QA / QC	Client QA / QC
NAME	AHMED SHAWKY	ABD-ELFATTAH ABU ALI
DATE	16/10/2016	16/10/2016
SIGN		

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