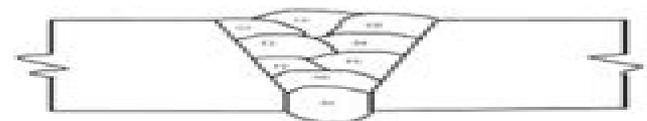


Company logo	WELDING PROCEDURE SPECIFICATION (WPS)		
PROJECT NAME			
PJT Contract Number			
WPS No. :		Date :	
Supporting PQR No. :			
Procedure for :	24" X 12.7MM		
Welding Process	SMAW / MANUAL		
Applicable Code ;	ASME B31.3, ASME IX		

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 Condition:	E6010	As per manufacturer's recommendation for handling and storage. Re-drying not recommended
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Xiaolong Qi



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Modern Welding Technology Howard B. Cary, 1989 This well respected introductory welding book contains coverage of the latest codes materials and processes necessary to become proficient in an ever more complex industry The technology of welding is growing and the book s focus on arc welding processes and the use of steel in construction reflect those changes while continuing to provide a comprehensive coverage of basic principles and theory Contains content on hybrid welding and stir friction welding background concepts and basic welding techniques the latest standards codes and specifications provided by the AWS the most recent information on the use of high strength metals laser welding and arc and oxyacetylene welding specifications for filler materials electrodes brazing fluxes etc computer aided welding processes the latest information on the training of welding personnel and welding power sources For any welding related occupations especially welding inspectors technicians or engineers *Metals Abstracts* ,1993 **How to Prepare Welding**

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