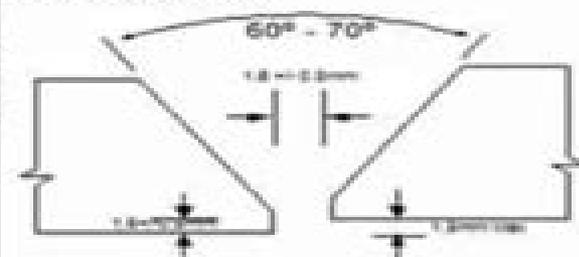


Welding Procedure Specification

Client:	Mobil	Project:	221010Goatee	REF No.	WPS 6 R1
Procedure Description:	12" Heavy Wall Offshore Tie-in			02901/WPSS	
Material:	AS3679.1 Grade 250 API 5L X65	Diameter:	168.3	Thickness:	18.3
Position:	6G	Clamp Type:	Internal		
Preheat °C (Min):	100	Interpass °C (Max):	300		
Welding Process	ROOT SMAW	Welding Process	HOT PASS SMAW	Welding Process	FILL & CAP SMAW
Welding Direction	Vertical Down	Welding Direction	Vertical Down	Welding Direction	Vertical Down
Filler	Lincoln SA70+	Filler	Lincoln SA70+	Filler	Bohler BVD90M
Polarity	DC +ve	Polarity	DC +ve	Polarity	DC +ve
Shielding Gas	N/A	Shielding Gas	N/A	Shielding Gas	N/A
Purge Gas	N/A	Purge Gas	N/A	Purge Gas	N/A

Pass No	Filler Size (mm)	Amps	Volts	Speed (mm/sec)	Heat Input (kJ/mm)
1	3.2mm	70-130	18-33	3.3-6.6	0.4-0.5
2	4.0mm	110-210	18-35	2.9-6.3	0.6-1.3
FILL	4.0mm	145-260	16-27	1.6-7.0	0.6-2.2
CAP	4.0mm	130-230	16-26	1.8-6.3	0.6-1.7

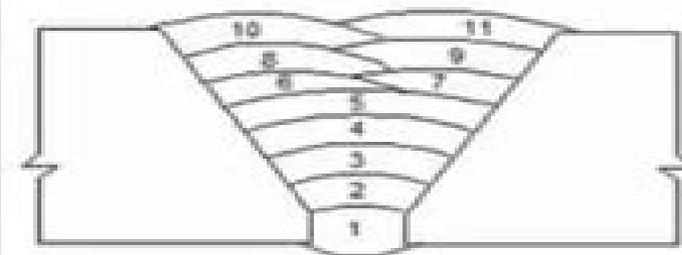
Weld Preparation



NOTES

1. API Std 1104BP3094-SP-PL-3010R1
2. Clamp removal gage: 100% completion of root (external clamp may be used in the event of a breakdown - removed after 50% minimum completion of the root.)
3. Time lapse between root and second pass : 16 Minutes
4. Time lapse between second pass and 1st fill : 12 Minutes
5. Minimum number of passes before pipe movement : 2 passes
6. Minimum number of passes before break in welding : 3 passes
7. Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1
8. Method of cleaning : Grinder / Wire brush
9. Method of Preheat : Gas Torch
10. Qualification reference number : 48250/PP/WP6 R1

Pass Location



**Company Welding
Engineer Approved**

.....
Approved for Client
.....

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Rosina Ehmann



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Welding Processes Handbook Klas Weman, 2003 Welding processes handbook is an introductory guide to all of the main welding processes. It is specifically designed for students on EWF courses and newcomers to welding and is suitable as a textbook for European welding courses in accordance with guidelines from the European Welding Federation. Welding processes and equipment necessary for each process are described so that they can be applied to all instruction levels required by the EWF and the important areas of welded joint design, quality assurance and costing are also covered in detail.

Modern Welding Technology Howard B. Cary, 1998 Principles and practices of welding. Provides more conceptual background than most texts. [Catalog of American National Standards](#) American National Standards Institute, 1995

Heat Exchangers Kuppam Thulukkanam, 2024-02-29 Heat Exchangers Mechanical Design Materials Selection Nondestructive Testing and Manufacturing Methods Third Edition covers mechanical design of pressure vessels and shell and tube heat exchangers including bolted flange joint design as well as selection of a wide spectrum of materials for heat exchanger construction, their physical properties, corrosion behavior and fabrication methods like welding. Discussing the basics of quality control, the book includes ISO Standards for QMS and references modern quality concepts such as Kaizen, TPM and TQM. It presents Six Sigma and Lean tools for heat exchangers manufacturing industries. The book explores heat exchanger manufacturing methods such as fabrication of shell and tube heat exchangers and brazing and soldering of compact heat exchangers. The book serves as a useful reference for researchers, graduate students and engineers in the field of heat exchanger design including pressure vessel manufacturers. **Steel Moment Frame Advisory No. 3**, 1995

Critical Infrastructure Protection: Advanced Technologies for Crisis Prevention and Response Tünde Anna Kovács, Igor Fürstner, 2025-06-13 This book presents the latest research findings from experts in critical infrastructure protection and management. It explores various aspects of both cyber and physical attack scenarios, focusing on crisis management and response strategies. A significant portion of the work addresses how different critical infrastructure sectors can withstand and recover from attacks, with an emphasis on practical solutions and real-world applications. Several chapters also delve into the human element of crisis management, highlighting the psychological and organizational challenges faced during emergencies. The book demonstrates how human decision-making behaviour and coordination play pivotal roles in the effectiveness of response efforts. One of the emerging topics in critical infrastructure protection discussed in the book is using Unmanned Aerial Vehicles (UAVs) in firefighting and other accident-related crisis situations. This innovative technology is shown to enhance emergency response capabilities, offering new ways to monitor, assess and manage crises from a distance. Additionally, the research includes detailed analyses of ballistic and blast effects, offering insights into how these physical threats can impact infrastructure and how to mitigate their effects. The book combines cutting-edge research with practical insights, providing a comprehensive overview of the current trends and challenges in protecting critical infrastructures from

a wide range of threats This book also addresses the evolving role of humans in modern warfare particularly in the context of increasing reliance on artificial intelligence As AI technologies reshape military strategies they emphasize the need to balance automation with human oversight ensuring that human security remains central to decision making processes in complex and high stakes environments

Modern Construction Envelopes Andrew Watts,2019-05-20 Modern Construction Envelopes deals with the facade and roof as an integral part of the building allowing a holistic approach to the design of the building envelope and providing greater design freedom The book is aimed at readers who want to extend their knowledge of wall and roof construction beyond the information given in the Modern Construction Handbook using state of the art construction principles of modern facade and roof systems The third edition of this classic has been fully brought up to date it contains new examples in all chapters and presents the projects in revised new 3D drawings and in 27 AR applications that can be accessed free of charge via smartphone and tablet

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Handbook of Steel Connection Design and Details Akbar R. Tamboli,2010 Surveys the leading methods for connecting structural steel components covering state of the art techniques and materials and includes new information on welding and connections Hundreds of detailed examples photographs and illustrations are found throughout this handbook from publisher description

Welding Handbook: Welding technology American Welding Society,1987

Energy Research Abstracts ,1985

Sheet Metal Industries ,1994

Handbook of Structural Steel Connection Design and Details, Third Edition Akbar R. Tamboli,2016-12-21 The definitive guide to steel connection design fully revised to cover the latest advances Featuring contributions from a team of industry recognized experts this up to date resource offers comprehensive coverage of every type of steel connection The book explains leading methods for connecting structural steel components including state of the art techniques and materials and contains new information on fastener and welded joints Thoroughly updated to align with the latest AISC and ICC codes Handbook of Structural Steel Connection Design and Details Third Edition features brand new material on important structural engineering topics that are hard to find covered elsewhere You will get complete details on fastener installation space truss connections composite member connections seismic codes and inspection and quality control requirements The book also includes LRFD load guidelines and requirements from the American Welding Society Distills ICC and AISC 2016 standards and explains how they relate to steel connections Features hundreds of detailed examples photographs and illustrations Each chapter is written by a leading expert from industry or academia

Standard Specifications for Transportation Materials and Methods of Sampling and Testing American Association of State Highway and Transportation Officials,2001

Structural Welding Code-- Steel American Welding Society. Structural Welding Committee,2004

Companion Guide to the ASME Boiler & Pressure Vessel Code K. R. Rao,2002 This comprehensive new guide available in two volumes addresses Sections I through XI of the ASME Boiler and Pressure Vessel Code and Codes B31 1 and B31 3 for Pressure Piping Contributors also provide examples and

explanatory text graphics references and annotated bibliographic notes As a result engineers can immediately refer to the material requirements to find acceptance criteria Its indepth treatment of each of the Code sections makes this the definitive companion book to the ASME Boiler and Pressure Vessel Code Volume 1 covers Code Sections I II III IV VI and VII as well as Codes B31 1 and B31 3 for Piping Volume 2 includes Sections V VII IX X and XI as well as special topics relating to the Code Each volume contains full introductory material table of contents author information and indexes for both volumes

Annual Book of ASTM Standards ASTM International, American Society for Testing and Materials, 2003 Cyclic Testing of Steel Moment Connections for the CalTrans District 4 Office Building Seismic Rehabilitation James D. Newell, Chia-Ming Uang, 2006 *ASM Handbook* ASM International. Handbook Committee, 1990 These volumes cover the properties processing and applications of metals and nonmetallic engineering materials They are designed to provide the authoritative information and data necessary for the appropriate selection of materials to meet critical design and performance criteria

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