DNV·GL

WELDING PROCEDURE SPECIFICATION (WPS)

WPS No:
1.1
Revision No:
1

General information ☐ pWPS

Manufacturer: **INTERBROD D.O.O.**

Manufacturer address: **BAJMOK, MOŠE PIJADE 2, SRBIJA**

Welding procedure qualification test records: **WPQR 1.1.**

Welding process (ISO 4063):	**136-FCAW Manual**	Number of electrodes:		Tungsten electrode designation and Ø:	**mm**
Welding position(s) (ISO/ASME): **PF**		Joint type:	**Plate Butt weld**	Stringer/weave, max. bead width:	**mm**
Welding layer:	**Multi-layer One side**	Backing: Gas flow rate:	**Ceramic l/min**	Method of preparation:	**Gouging - grinding**
Min. preheating tempertaure:	**°C**	Max. interpass temperature:	**°C**	PWHT details:	

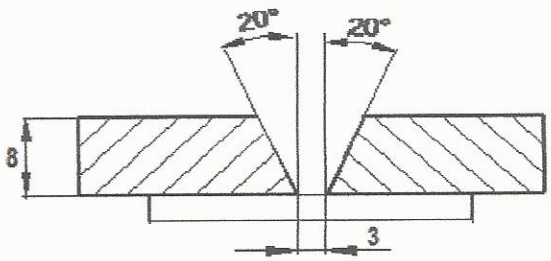
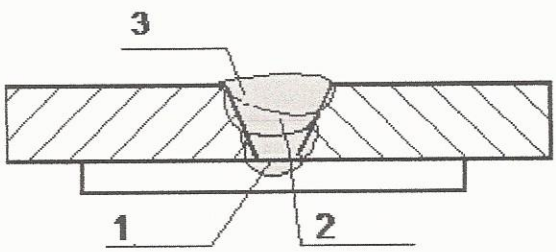
Material specification

Base material 1 group:	**1.1/VLA**	Base material 2 group:	**1.1/VLA**
Delivery condition(s):	**AR**	Delivery condition(s):	**AR**
Max. C_{eq}:		Max. C_{eq}:	
Thickness range:	**3-16 mm**	Thickness range:	**3-16 mm**
Outside diameter range:	**>500 mm**	Outside diameter range:	**>500 mm**

Welding consumables

No.	Filler metal and flux				Shielding gas		Nozzle diameter (mm)	DNV GL grade(s)
	Type	Manufacturer	Brand Name/ Designation	ISO or AWS classification	Type	Purity		
1	**Wire**	**METALWELD**	**COREFIL100R**	**ISO 17632-A**	**M21**			**III YMS(H10)**
2								

Joint preparation (sketch) and welding details

Joint design	Welding sequences
	
Throat thickness range:	

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Run[1]	Process[2]	C[3]	Ø[4] (mm)	Gas flow (l/min)	Current (A)	Voltage (V)	C&P[5]	v[6] (cm/min)	s[7] (mm/s)	F/B[8]	HI[9] (kJ/cm)
Root	**136-FCAW**	**1**	**1.2**	**14**	**180 - 200**	**22 - 24**	**DC+**	-	**80**		-
Fill	**136-FCAW**	**1**	**1.2**	**14**	**180 - 200**	**22 - 24**	**DC+**	-	**80**		-
Cap	**136-FCAW**	**1**	**1.2**	**14**	**180 - 200**	**22 - 24**	**DC+**	-	**80**		-
					-	-		-			-
					-	-		-			-

(1) Root, fill or cap. (2) Ref. ISO4063. (3) Welding consumable, see previous table. (4) Filler metal diameter. (5) Current and polarity, /P for pulse welding. Details to be specified below. (6) Travel speed. (7) Wire feed speed. (8) Forehand "F" or backhand "B" progression. (9) Heat input not compensated for process efficiency (arc energy).

Further information

Shop primer for fillet weld					
Manufacturer:		Brand name:		Max. dry film thickness:	**µm**

Other:

Place: **APATIN**
Date : **2018-10-07**

MIHAJLO MANDIĆ IWE/EWE ENGINEER
Manufacturer

Place: **APATIN**
Date : **2018-10-07**

for **DNV GL**

BRANKO BAJIĆ
Surveyor