

WELDING PROCEDURE SPECIFICATION (WPS)

WPS No:
2.2
Revision No:
1

General information pWPS

Manufacturer: **INTERBROD D.O.O.**
 Manufacturer address: **BAJMOK, MOŠE PIJADE 2, SRBIJA**
 Welding procedure qualification test records: **WPQR 2.2**

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 Fillet weld	Stringer/weave, max. bead width:	mm
Welding layer:	Single-layer One side	Backing:		Method of preparation:	
Min. preheating tempertaure:	°C	Gas flow rate:	l/min	PWHT details:	
		Max. interpass temperature:	°C		

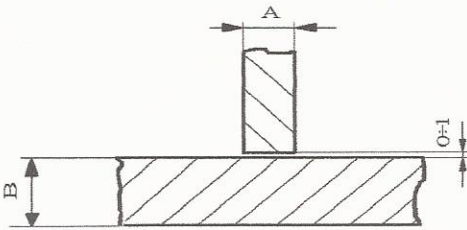
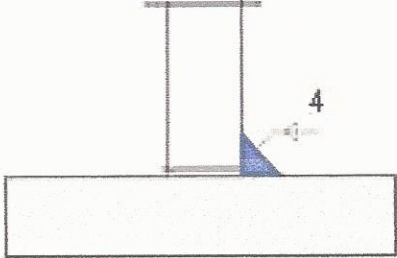
Material specification

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:	mm	Outside diameter range:	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				
 <table border="1" data-bbox="292 1870 673 1933"> <tr> <td>A(mm)</td> <td>8</td> </tr> <tr> <td>B(mm)</td> <td>8</td> </tr> </table> <p>Throat thickness range:</p>	A(mm)	8	B(mm)	8	
A(mm)	8				
B(mm)	8				

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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)
Fill	136-FCAW	1	1.2	14	180 - 200	22 - 24	DC+	-	70		-
					-	-		-			-
					-	-		-			-
					-	-		-			-
					-	-		-			-

(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	Brand name:	Max. dry film thickness:	µm
Manufacturer:			

Other:

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

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for **DNV GL**



BRANKO BAJIC
 Surveyor