YOUR LOGO HERE

Welding Procedure Specification

Asset Reliability Inspections Pty Ltd

WPS No:	140 R 0	WPQR No:	240 R0	Date:	19/02/2014
Fabricator:	Your company name	Project:	ALL	Job No:	ALL

Essentials

Standard: AS1554.1:2011 /AWS D1.1:2010

Process: GMAW
Position: 1G, 2G
Progression: Not Applicable
Joint Type: Butt Welded Single Side Only

Material Details

Material Group: AS1554.1 Table 4.6.1 B) Steel Type 1

Thickness Range: 3-12mm

Diameter Range: ALL

Consumable Details

Consumable Class: AWS SFA5.15:ERXXS-X
Consumable Class: -
Shielding Gas Type: 81.5% Argon, 16% CO_2, 2.5% O_2
AWS SG-ACO-8/2

Joint Parameters

Root Gap(g): 0-3mm
Root Face (f): 0-1.5mm
Groove Angle (α) 7≤

Welding Technique & Preparation

Preparation Method: Grind/Machine
Interpass Cleaning: Grind/Wire Brush
Max Bead Width: 14mm
Stringer/Weave: Stringer
Arc Transfer: Not applicable
Electrical Stickout: 12.75-17.25mm
Gas Lens/Nozzle Size: 19mm
Tungsten: Not applicable

Joint Preparation

Thermal Treatment

Preheat Minimum: 6° Celsius
Preheat Method: Flame
Temperature Check: Crayon/Laser
Interpass Maximum: 230°C
Post Weld Treatment: Not applicable

Welding Sequence

Pass No	Side	Position	Process	Polarity	Electrode/Wire Class	Electrode/Wire Size mm	Gas/Flux Type	Gas/Flux L/min	Amperage Range	Voltage Range	Travel Speed mm/min	Heat Input Kj/mm
1	1	1G/2G	GMAW	DC+	ERXXS-X	0.9	Argoshield U	18-25			132-178	
2	1	1G/2G	GMAW	DC+	ERXXS-X	0.9	Argoshield U	18-25		22.5-25.5		0.45-0.85
3	1	1G/2G	GMAW	DC+	ERXXS-X	0.9	Argoshield U	18-25				0.47-0.88

Notes:
1. This procedure was produced by Asset Reliability Inspections. The fabricator named above has approval for full usage of this procedure

Written/Approved By:	Fabricator:	Client/Third Party:
CSWIP NEIL K YOUNG 621150 WI 3.1	Accepted By: Signature: Date:	Approved By: Signature: Date:

EXAMPLE ONLY