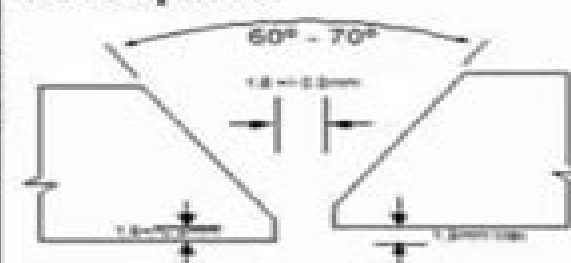


Welding Procedure Specification

Client:	Mobil	Project:	221010Goatee	REF No.	WPS 6 R1	
Procedure Description:		12" Heavy Wall Offshore Tie-in			0290/1/WPS5	
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		HOT PASS SMAW		FILL & CAP SMAW
Welding Direction		Vertical Down		Vertical Down		Vertical Down
Filler		Lincoln SA70+		Lincoln SA70+		Böhler BVD90M
Polarity		DC +ve		DC +ve		DC +ve
Shielding Gas		N/A		N/A		N/A
Purge Gas		N/A		N/A		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	0.4-0.8
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	180-230	16-26	1.8-6.3	0.6-1.7

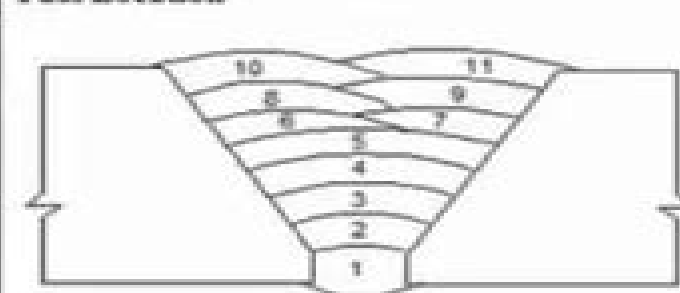
Weld Preparation



NOTES

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

Pass Location



Company Welding
Engineer Approved

Approved for Client

Welding Procedure Specification Wps Sheet 1 Of 3

Terry C. Jones



Welding Procedure Specification Wps Sheet 1 Of 3:

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.

Welding Code - Steel , A Practical Guide to Construction of Hydropower Facilities Suchintya Kumar Sur, 2019-03-18 This book deals with the narratives of water to watt which includes elementary conceptual design, modern planning, scheduling and monitoring systems and extensive pre and post investigations pertaining to hydropower facilities. It also includes explorations to ensure aspects of dam safety, evaluation, effective contract management, specialized construction management techniques and preferred material and equipment handling systems. Special emphasis is placed upon health, safety, environmental and risk management concepts. The book discusses a standard QA/QC system to measure and assure quality and an environmental impact assessment to reach the set target in the stipulated timeline within the approved budget. **Key Features:** Offers comprehensive coverage of hydro structures and practical coverage from an industry perspective. Helps readers understand complexity involved in large scale interdisciplinary projects. Provides good insights on building procedures, precautions and project management. Includes project planning, construction management and hydropower technology, QA/QC, HSE and statutory requirements. Illustrates how to integrate good constructability/buildability into good design for the best monetary value. **Welding Code - Aluminum , FCS Welding L2** Penny Swift, 2008 **Handbook of Engineering Practice of Materials and Corrosion** Jung-Chul (Thomas) Eun, 2020-09-04 This handbook is an in-depth guide to the practical aspects of materials and corrosion engineering in the energy and chemical industries. The book covers materials, corrosion, welding, heat treatment, coating, test and inspection and mechanical design and integrity. A central focus is placed on industrial requirements including codes, standards, regulations and specifications that practicing material and corrosion engineers and technicians face in all roles and in all areas of responsibility. The comprehensive resource provides expert guidance on general corrosion mechanisms and recommends materials for the control and prevention of corrosion damage and offers readers industry tested best practices, rationales and case studies. **Catalog of American National Standards** American National Standards Institute, 1995 **FCS Welding L3** Swift, 2009 **Oil and Gas Pipelines** R. Winston Revie, 2015-04-01 A comprehensive and detailed reference guide on the integrity and safety of oil and gas pipelines both onshore and offshore. Covers a wide variety of topics including design, pipe manufacture, pipeline welding, human factors, residual stresses, mechanical damage, fracture and corrosion protection, inspection and monitoring, pipeline cleaning, direct assessment, repair, risk management and abandonment. Links modern and vintage practices to help integrity engineers better

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Practical Guide to Pressure Vessel Manufacturing Sunil Kumar Pullarcot,2002-01-22 Explores vessel fabrication and the corresponding procedures of quality and control Details the necessary methods for code specification compliance Clarifies the inspection testing and documentation of the ASME code **Heat Exchanger Design Handbook, Second Edition** Kuppam Thulukkanam,2013-05-20 Completely revised and updated to reflect current advances in heat exchanger technology Heat Exchanger Design Handbook Second Edition includes enhanced figures and thermal effectiveness charts tables new chapter and additional topics all while keeping the qualities that made the first edition a centerpiece of information for practicing engineers research engineers academicians designers and manufacturers involved in heat exchange between two or more fluids See What s New in the Second Edition Updated information on pressure vessel codes manufacturer s association standards A new chapter on heat exchanger installation operation and maintenance practices Classification chapter now includes coverage of scrapped surface graphite coil wound microscale and printed circuit heat

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Recommended Postearthquake Evaluation and Repair Criteria for Welded Steel Moment-frame Buildings SAC Joint Venture. Guidelines Development Committee,2000 **Laboratory Manual of Test Procedures, 2001 as Revised** Colorado. Department of Transportation. Materials and Geotechnical Branch,2001 Installing Seismic Restraints For Mechanical Equipment Vibration Isolation and Seismic Control Manufacturers Association,2004 **Critical Infrastructure Protection: Advanced Technologies for Crisis Prevention and Response** Tünde Anna Kovács,Igor Fürstner,2025-06-13

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