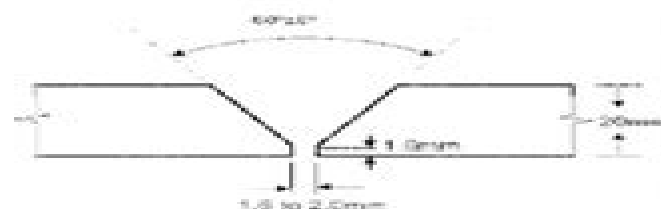


WELDING PROCEDURE SPECIFICATION (WPS)

Company Name	Stars Line Metallic Ind. LLC		Prepared by	Mr. N.C Sekar
Welding Procedure Specification #	SLM WPS 002/09	Date	25-01-2009	Supporting PQR #
Revision #	0	Date	-	Cognizant Code
Welding Process (es)	GMAW	Type (s)	MANUAL	

Joint Design	Single V Butt Joint
Backing/Back weld	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
Backing Material (type)	N/A
Reininer	N/A
Root Gap	1.6mm ± 2.0mm
Groove Angle	60° ± 5°
Root Face	1.6mm
Edge preparation	Bevel
Plate Thickness	20mm



Base Metals

P.No.	1	Group No.	I	Tec.	P.No.	1	Group No.	I
Specification	Type	EN 10025	Tec.	Specification	Type	EN 10025		
	Grade	S 275 JH			Grade	S 275 JH		

Qualification Range

Thickness	Groove	Base metal	5 mm to 32 mm	Filler	Plate	All
		Weld metal	6 mm - 36 mm		Pipe	-
Pipe Dia	Groove			Filler	All	

Other

Filler Metals	Weld Run: 1	Weld Run: 2 - 4	Others
Spec No	5-15	5-15	
AWS No. Classification	ER 70 S - 3	ER 70 S - 3	
F-No	5	5	
A-No	I	I	
Size of Filler Metals	1.2mm	1.2mm	
Electrode Trade Name	N/A	N/A	
Flux Trade Name	N/A	N/A	
Consumable Insert	N/A	N/A	
Process	GMAW	GMAW	



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