



Southern
BRANCH

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DEPARTMENT

WELDING PROCEDURE SPECIFICATION (WPS) ACCORDING TO API 1104

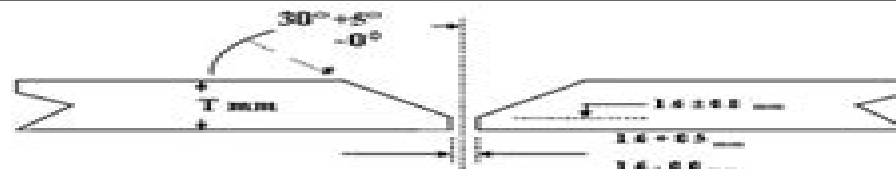
Date : 16/10/2016

WPS No. : P01

Sheet : 1 of 1

COMPANY NAME	: GASCO
PROJECT NAME	: Dahshor-Bany Swief 36" pipeline
WELDING PROCEDURE SPECIFICATION No.	: P01 Main Pipeline
REVISION NO.	: 0
SUPPORTING PQR NO.	: PQR (PL-62/2010)
TYPES (Manual, Automatic, Semi Auto.)	: MANUAL (SMAW)

JOINTS DESIGN



BASE METAL

Material Spec.	: API-5L
Type or Grade	: X-65
P No.	: 01
A No.	: 01
Thickness	: 4.8 ≤ T ≤ 19.05 mm
Diameter	: 36"
Other	:

FILLER METALS

Weld Metal Analysis A No.	: A1
Size of Electrode	: 3.25, 4.0 & 5.0 mm
Filler Metal No.	: F3
SFA Specification	: A 5.1 & A 5.5
AWS Classification	: E 6010 & E 8010G

POSITION

Position of Groove	: 5G
Direction of welding	: All Down-Hill
Other	:

PREHEAT

Preheat Temp. (°C) (Min)	: 30°C (if needed)
Interpass Temp. (°C) (Max.)	: 250 °C Max
Other	: N.A.

POSTWELD HEAT TREATMENT

Temperature Range	: N.A.
Time Range	: N.A.
Other	: N.A.

GAS

Type of Gas or Gases	: N.A.
Composition of Gas Mixture	: N.A.
Other	: N.A.

ELECTRICAL CHARACTERISTICS

Current	: DC
Polarity	: -ve & +ve

WELD LAYERS	FILLER METAL		CURRENT		VOLTAGE RANGE
	Class	Size (mm.)	Polar.	Amp. range	
1 st	E6010	3.25	-ve	80-110	20-22
2 nd	E8010G	4.00	+ve	120-180	20-27
3 rd	E8010G	4.00	+ve	120-180	20-27
4 th	E8010G	5.00	+ve	120-180	20-27
CAP	E8010G	5.00	+ve	120-180	20-27

TECHNIQUE

Interpass Cleaning	: Root Grinding & Wire Brush
String or Weave Bead	: Both
Orifice or Gas Cup Size	: N.A.
Multi-pass or Single Pass	: Multi-passes
Single or Multiple Electrodes	: Single
LINE UP CLAMP	: Remove Internal Clamp after 100% of the Root Pass
Maximum time between 1 st and 2 nd pass (5 minutes)	
Maximum time between 2 nd pass and others	: Shortly

JOB TITLE	PROJECT QA / QC	Chief QA / QC
NAME	AMMED SHAWKY	ABD-ELFATTAH ABU ALI
DATE	16/10/2016	16/10/2016
SIGN		

Api Welding Procedure Specification Api 1104 Qualified

N T Burgess

A decorative graphic consisting of a light blue horizontal bar with a rounded right end, and a red circular shape partially visible behind it.

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Arc Welding Qualification Standards Darren Barborak, 2024-08-19 This textbook introduces the reader to the development and qualification of arc welding procedures and personnel to industry codes and standards The mechanics of using welding standards how to address their requirements and their relationship with other standards are explained The reader will gain a working knowledge of common welding standards including a review of welding processes variables the inspection and testing of welds and their acceptance criteria The reader will develop a basic understanding of Common arc welding standards Welding related documentation The welding procedure development qualification process Essential non essential supplementary essential variables for arc welding processes The requirements for the inspection testing of weld qualification coupons Purpose intent compliance of a Welding Procedure Specifications WPS Purpose intent compliance of a Procedure Qualification Records PQR The welder operator performance qualification process Purpose intent compliance of a Welder Performance Qualification Record WPQR This textbook was written for use in an undergraduate course in Welding Engineering Although the book is aimed at Welding Engineering students it should also serve as a useful guide to other engineers technicians and specialists who are working in the field of welding and are seeking how to apply relevant codes and standards to qualify welding procedures and personnel While the book focused primarily on the common arc welding processes using AWS B2.1 and ASME BPVC Section IX the principles discussed will apply to most welding processes in general and most welding qualification standards

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 understand their system and apply up to date technology to older infrastructure Includes case histories with examples of solutions to complex problems related to pipeline integrity Includes chapters on stress based and strain based design the latter being a novel type of design that has only recently been investigated by designer firms and regulators Provides information to help those who are responsible to establish procedures for ensuring pipeline integrity and safety

Handbook of Pipeline Engineering ABCM - Brazilian Society of Mechanical Sciences and Engineering, José Luiz de França Freire, Marcelo Rosa Rennó Gomes, Marcelino Guedes Gomes, 2024-07-25 This Handbook covers a large number of Pipeline Engineering topics ranging from the initial stages of designing constructing operating and managing the integrity of a pipeline to several of their fluid transportation applications such as oil gas derivatives slurry hydrogen and CO₂ Traditional onshore and offshore pipelines are covered as well as chapters on present and future interaction with modern society This Handbook serves as a first reference resource for new readers entering the field but also as a complement to those who are aware of the general principles encompassing areas of pipeline engineering This Handbook has been developed in close cooperation with ABCM the Brazilian Society of Mechanical Sciences and Engineering

Standard Specifications for Road and Bridge Construction New Jersey. Department of Transportation, 1983

Federal Register, 2004-06-14

Code of Federal Regulations, 1983

The Code of Federal Regulations of the United States of America, 1976 The Code of Federal Regulations is the codification of the general and permanent rules published in the Federal Register by the executive departments and agencies of the Federal Government

Regulations for the Transportation of Natural and Other Gas by Pipeline United States. Office of Pipeline Safety, 1974

ASME Guide for Gas Transmission and Distribution Piping Systems, 1986 American Society of Mechanical Engineers, 1986

Code of Federal Regulations, Title 49, Transportation, Pt. 178-199, Revised As of October 1 2012 U S Office of the Federal Register, 2014-02-18 The Code of Federal Regulations is a codification of the general and permanent rules published in the Federal Register by the Executive departments and agencies of the United States Federal Government

Welder - Structural (Theory) Mr. Rohit Manglik, 2024-05-18 EduGorilla Publication is a trusted name in the education sector committed to empowering learners with high quality study materials and resources Specializing in competitive exams and academic support EduGorilla provides comprehensive and well structured content tailored to meet the needs of students across various streams and levels

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Pipeline safety regulations, 2005

Quality Assurance of Welded Construction N T Burgess, 1989-04-10 Since the first edition of this book was published most developments in

welding construction have been within the quality assurance element of the process rather than in welding technology itself. The continuous pressures from worldwide clients seeking better reliability from welded structures has focused much attention on to quality. The quality ch **Pipe Welding Procedures** Hoobasar Rampaul, 2003. A standard reference for decades this new edition of Pipe Welding Procedures continues to reinforce the welder's understanding of procedures. Drawing on his extensive practical and teaching experience in the field the author describes in detail the manipulating procedures used to weld pipe joints. You will find useful information on heat input and distribution essentials of shielded metal arc technology distortion pipe welding defects welding safety essentials of welding metallurgy and qualification of the welding procedure and the welder. Look for new or expanded coverage of Features Root Bead Pulse Current Gas Tungsten Arc Welding Shielded Metal Arc Welding Electrode Welding Steel for Low Temperature Cryogenic Service Down Hill Welding Heavywall and Large Diameter Welding Metallurgy Weld Repair Piping and Pipeline Engineering George A. Antaki, 2003-05-28. Taking a big picture approach Piping and Pipeline Engineering Design Construction Maintenance Integrity and Repair elucidates the fundamental steps to any successful piping and pipeline engineering project whether it is routine maintenance or a new multi million dollar project. The author explores the qualitative details calculations and techniques that are essential in supporting competent decisions. He pairs coverage of real world practice with the underlying technical principles in materials design construction inspection testing and maintenance. Discover the seven essential principles that will help establish a balance between production cost safety and integrity of piping systems and pipelines. The book includes coverage of codes and standards design analysis welding and inspection corrosion mechanisms fitness for service and failure analysis and an overview of valve selection and application. It features the technical basis of piping and pipeline code design rules for normal operating conditions and occasional loads and addresses the fundamental principles of materials design fabrication testing and corrosion and their effect on system integrity **Regulations for the Transportation of Natural and Other Gas by Pipeline** United States. Department of Transportation, 1976. **Symposium Papers and Related Information on Nondestructive Testing for Pipe Systems** Institute of Gas Technology, 1976. **Code of Federal Regulations, Title 49, Transportation, Pt. 186-199, Revised as of October 1, 2009**, 2010-02-19.

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