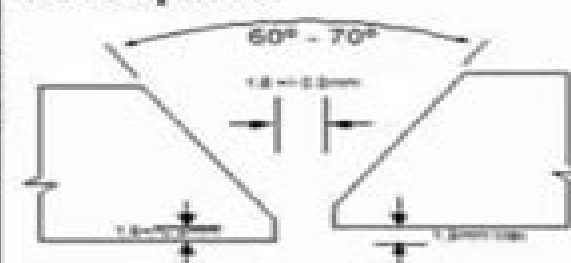


# Welding Procedure Specification

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

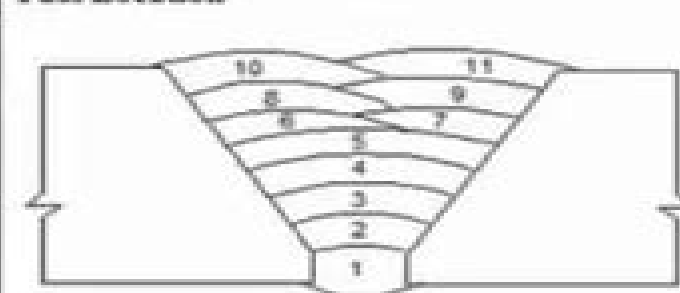
## Weld Preparation



## 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 1<sup>st</sup> 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

**Penny Swift**



### **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

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 FCS Engineering Fabrication & Sheet Metalwork L3 Christopher George Brink,2008 *The Welding of Aluminium and Its Alloys* G Mathers,2002-09-24 The Welding of Aluminium and its Alloys is a practical user s guide to all aspects of welding aluminium and aluminium alloys It provides a basic understanding of the metallurgical principles involved showing how alloys achieve their strength and how the process of welding can affect these properties The book is intended to provide engineers with perhaps little prior understanding of metallurgy and only a brief acquaintance with the welding processes involved with a concise and effective reference to the subject It is intended as a practical guide for the Welding Engineer and covers weldability of aluminium alloys process descriptions advantages limitations proposed weld parameters health and safety issues preparation for welding quality assurance and quality control issues along with problem solving The book includes sections on parent metal storage and preparation prior to welding It describes the more frequently encountered processes and has recommendations on welding parameters that may be used as a starting point for the development of a viable welding procedure Included in these chapters are hints and tips to avoid some of the pitfalls of welding these sometimes problematic materials The content is both descriptive and qualitative The author has avoided the use of mathematical expressions to describe the effects of welding This book is essential reading for welding engineers production engineers production managers designers and shop floor supervisors involved in the aluminium fabrication industry A practical user s guide by a respected expert to all aspects of welding of aluminium Designed to be easily understood by the non metallurgist whilst covering the most necessary metallurgical aspects Demonstrates best practice in fabricating aluminium structures

**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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*Modern Welding Technology* Howard B. Cary, 1994 This well respected introductory welding book contains coverage of the latest codes materials and processes necessary to become proficient in an ever more complex industry The technology of welding is growing and the book s focus on arc welding processes and the use of steel in construction reflect those changes while continuing to provide a comprehensive coverage of basic principles and theory Contains content on hybrid welding and stir friction welding background concepts and basic welding techniques the latest standards codes and specifications provided by the AWS the most recent information on the use of high strength metals laser welding and arc and oxyacetylene welding specifications for filler materials electrodes brazing fluxes etc computer aided welding processes the latest information on the training of welding personnel and welding power sources For any welding related occupations especially welding inspectors technicians or engineers

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

*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

This book presents the latest research findings from experts in critical infrastructure protection and management It explores various aspects of both cyber and physical attack scenarios focusing on crisis management and response strategies A significant portion of the work addresses how different critical infrastructure sectors can withstand and recover from attacks with an emphasis on practical solutions and real world applications Several chapters also delve into the human element of crisis management highlighting the psychological and organizational challenges faced during emergencies The book demonstrates how human decision making behaviour and coordination play pivotal roles in the effectiveness of response efforts One of the emerging topics in critical infrastructure protection discussed in the book is using Unmanned Aerial Vehicles UAVs in firefighting and other accident related crisis situations This innovative technology is shown to enhance emergency response capabilities offering new ways to monitor assess and manage crises from a distance Additionally the research includes detailed analyses of ballistic and blast effects offering insights into how these physical threats can impact infrastructure and how to mitigate their effects The book combines cutting edge research with practical insights providing a comprehensive overview of the current trends and challenges in protecting critical infrastructures from a wide range of threats This book also addresses the evolving role of humans in modern warfare particularly in the context of increasing reliance on artificial intelligence As AI technologies reshape military strategies they emphasize the need to balance automation with human oversight ensuring that human security remains central to decision making processes in complex and high stakes environments

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