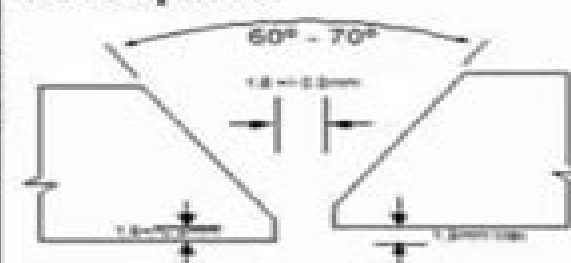


Welding Procedure Specification

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	130-230	16-26	1.8-6.3	0.6-1.7

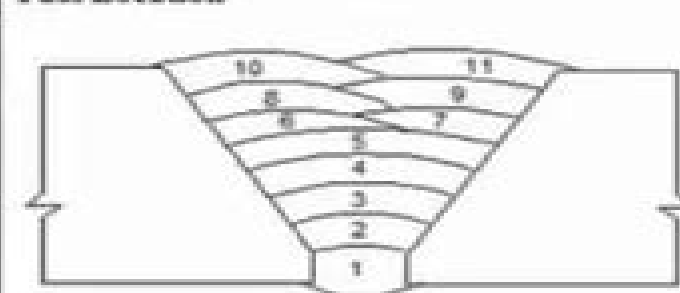
Weld Preparation



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

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Yi-Tong Ma



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