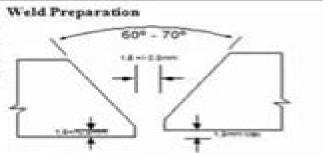
Welding Procedure Specification

					-						
Client:	Mobil			Project:	221010Goatee		REFNo. WPS		6 R1		
Procedure Description: 12" Heavy Wall Offsh			hore Tie-iz	1		0	0290/1/WPS5				
Material:			rade 2	rade 250API 5L X65		Diameter:	168.3	1	hickness:	18.3	
Position:	6G					Clamp Type	Inter	Internal			
Preheat °C (Min): 100						Interpass *C	(Max):	300			
AND HOLD VICE	ROOT				HOT PASS			FILL & CAP			
Welding Process				SMAW		SMAW			SMAW		
Welding Direction			1	Vertical Down		Vertical Down		- 13	Vertical Down		
Filler			I	Lincoln SA70+		Lincoln SA70+			Bohler BVD90M		
Polarity			I	DC +ve		DC +ve			DC +ve		
Shielding Gas			2	N/A		N/A		3	N/A		
Parge Gas			5	ě.A.	N/A			N/A			
Paus No. Filler Size Ames Vales Speed					Heat Input   Weld Preparation						

Pau No	Filler Size (mm)	Amps	Value	Speed (mm/sec)	Heat Input (hJ/mm)
10	3.2 mm	70-130	18-33	3.3-6.6	0.4-0.5
- 2	4.0 mm	110-210	18-35	2.9-6.5	0.6-1.3
FILL	4.0 mm	145-260	16-27	1.6-7.0	0.6-2.2
CAP	4.0 man	130-230	16-36	15-63	0.6-1.7
	***************************************	30.000	PERSONAL PROPERTY.	-	

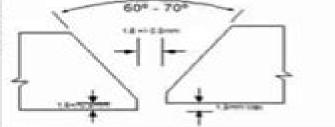


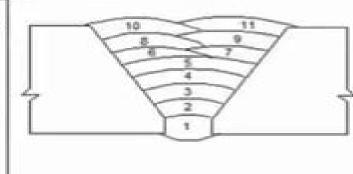
## NOTES

- AFI Std 1104BP3094-SP-PL-3010R1
- 2. 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.
- 7. Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1

PROPERTY OF THE PROPERTY OF TH

- 8. Method of cleaning: Grinder / Wire brush
- 9. Method of Preheat : Gas Torch
- 10. Qualification reference number: 48280/PP/WP6 R1





CONTRACTOR OF THE PARTY OF THE

Company Welding Engineer Approved

Approved for Client

Pass Location

# **Welding Procedure Specification Guide**

Alan Hayward, Frank Weare, A. C. Oakhill

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A Quick Guide to Welding and Weld Inspection S E Hughes, 2009-10-20 A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector In covering both European and US based codes the book gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector Covers both European and US based codes Gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter Construction Inspector's Guide: Architectural and structural features in building construction ,1982

Handbook of Oil and Gas Piping Murali Sambasivan, Sekar Gopal, 2018-09-20 The objective of this practical oil and gas piping handbook is to facilitate project management teams of oil and gas piping related construction projects to understand the key requirements of the discipline and to equip them with the necessary knowledge and protocol It provides a comprehensive coverage on all the practical aspects of piping related material sourcing fabrication essentials welding related items NDT activities erection of pipes pre commissioning commissioning post commissioning project management and importance of ISO Management systems in oil and gas piping projects This handbook assists contractors in ensuring the right understanding and application of protocols in the project One of the key assets of this handbook is that the technical information and the format provided are practically from real time oil and gas piping projects hence the application of this information is expected to enhance the credibility of the contractors in the eyes of the clients and to some extent simplify the existing operations Another important highlight is that it holistically covers the stages from the raw material to project completion to handover and beyond This will help the oil and gas piping contractors to train their project management staff to follow the best practices in the oil and gas industry Furthermore this piping handbook provides an important indication of the important project related factors hard factors and organizational related factors soft factors to achieve the desired project performance dimensions such as timely completion cost control acceptable quality safe execution and financial performance Lastly the role of ISO management systems such as ISO 9001 ISO 14001 and OHSAS 18001 in construction projects is widely known across the industry however oil and gas specific ISO quality management systems such as ISO 29001 and project specific management systems such as ISO 21500 are not widely known in the industry which are explained in detail in this handbook for the benefit of the oil and gas construction organizations Features Covering the stages from the raw material to project completion to handover and beyond Providing practical guidelines to oil and gas piping contractors for training purposes and best practices in the oil and gas industry Emphasizing project related factors hard factors and organizational related factors soft factors with a view to achieve the desired project performance Highlighting the roles of ISO management systems in oil and gas projects Quality Assurance Representative's Guide ,1992 **Ouality** Assurance Representative's Guide: Architectural and structural features in building construction ,1992

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 Facilities Engineering Handbook United States. National API Std 1104 Interview Questions and Answers: The Guide for Aeronautics and Space Administration, 1974 Welding Professionals Chetan Singh, Are you preparing for an API Std 1104 interview or seeking to elevate your expertise in welding inspection Look no further API Std 1104 Interview Questions and Answers The Guide for Welding Professionals is your essential companion for mastering the key concepts of welding inspection codes and practices related to the American Petroleum Institute API Whether you re a welding professional inspector engineer or someone aspiring to join the field this API 1104 code book equips you with the tools to excel The clear concise language and structured format make it an invaluable resource for both beginners and experienced professionals Don t miss the chance to gain a competitive edge in your career Master API 1104 ace your interviews and advance your welding expertise with this all in one guide Manager's Guide to ISO 9000 Kenneth L. Arnold, 1994 This step by step guide to ISO 9000 presents an in depth study of the 5 phases of certification lists requirements for certification and provides examples of implementation Quality Management in Welded Fabrication Serhii Fomichov, Yevgenia Chvertko, Serhii Guidelines ,1995 Minakov, Igor Skachkov, Anna Banin, 2023-08-23 This book focuses on topics in the field of welding science technologies and equipment with a particular emphasis on quality management The textbook consists of four modules covering quality management basics measurement imperfections and non destructive testing The material is presented in an illustrated and uncomplicated manner The textbook is based on the experience of professors of the National Technical University of Ukraine and the Approved Training Body for International Welding Engineers and Technologists of the International Institute of Welding making it an ideal resource for graduate and postgraduate students university professors and welding specialists

The Welding Engineer's Guide to Fracture and Fatigue Philippa L Moore, Geoff Booth, 2014-11-21 The Welding Engineer's Guide to Fracture and Fatigue provides an essential introduction to fracture and fatigue and the assessment of these failure modes through to the level of knowledge that would be expected of a qualified welding engineer Part one covers the basic principles of weld fracture and fatigue It begins with a review of the design of engineered structures provides descriptions of typical welding defects and how these defects behave in structures undergoing static and cyclical loading and explains the range of failure modes Part two then explains how to detect and assess defects using fitness for service assessment procedures Throughout the book assumes no prior knowledge and explains concepts from first principles Covers the basic principles of weld fracture and fatigue Reviews the design of engineered structures provides descriptions of typical welding defects and how these defects behave in structures undergoing static and cyclical loading and explains the range of failure modes Explains how to detect and assess defects using fitness for service assessment procedures

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**570 Certified Pipework Inspector Syllabus** Clifford Matthews, 2009-05-22 The API Individual Certification Programs ICPs are well established worldwide in the oil gas and petroleum industries This Quick Guide is unique in providing simple accessible and well structured guidance for anyone studying the API 570 Certified Pipework Inspector syllabus by Summarising and helping them through the syllabus Providing multiple example questions and worked answersTechnical standards covered include the full API body of knowledge for the examination i e API570 Piping inspection code API RP 571 Damage mechanisms affecting fixed equipment in the refining industry API RP 574 Inspection practices for piping system components API RP 577 Welding and metallurgy API RP 578 Material verification program for new and existing alloy piping systems ASME V Non destructive examination ASME IX Welding qualifications ASME B16 5 Pipe flanges and flanged fittings and ASME B 31 3 Process piping Provides simple accessible and well structured guidance for anyone studying the API 570 Certified Pipework Inspector syllabus Summarizes the syllabus and provides the user with multiple example questions and worked answers Technical standards covered include the full API body of knowledge for the examination to API 653 Certified Storage Tank Inspector Syllabus Clifford Matthews, 2011-10-25 The API Individual Certification Programs ICP are well established in the oil gas petroleum industries API runs multiple examination sites around the world at 6 monthly intervals The three main ICPs are API 570 Certified pipework inspector API 510 Certified pressure vessel inspector API 653 Certified storage tank inspector Reviews one of API s three main ICPs API 653 Certified storage tank inspector Discusses key definitions and scope inspection regimes and testing techniques relating to tank design linings welds protection systems repair and alteration API Individual Certification Programs ICP are well established in the oil gas petroleum industries Scientific and Technical Aerospace Reports, Resources in Education ,1997 **Pipeline** Accident/incident Summary Reports , Welding Handbook American Welding Society, 2001 Steel Detailers' Manual Alan Hayward, Frank Weare, A. C. Oakhill, 2011-03-01 This highly illustrated manual provides practical guidance on structural steelwork detailing It describes the common structural shapes in use and how they are joined to form members and complete structures explains detailing practice and conventions provides detailing data for standard sections bolts and welds emphasises the importance of tolerances in order to achieve proper site fit up discusses the important link between good detailing and construction costs Examples of structures include single and multi storey buildings towers and bridges The detailing shown will be suitable in principle for fabrication and erection in many countries and the sizes shown will act as a guide to preliminary design The third edition has been revised to take account of the new Eurocodes on structural steel work together with their National Annexes The new edition also takes account of developments in 3 D modelling techniques and it includes more CAD standard library details Handbook of Valves and Actuators Brian Nesbitt, 2011-04-19 Industries that use pumps seals and pipes will also use valves and actuators in their systems This key reference provides anyone who designs uses specifies or maintains valves and valve systems with all of the critical design specification performance and

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