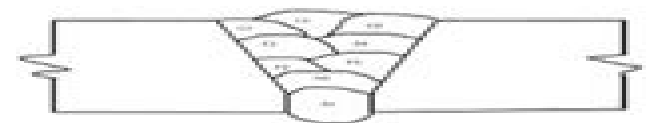


Company logo	WELDING PROCEDURE SPECIFICATION (WPS)		
PROJECT NAME			
PJT Contract Number			
WPS No. :		Date :	
Supporting PQR No. :			
Procedure for :	24" X 12.7MM		
Welding Process	SMAW / MANUAL		
Applicable Code :	ASME B31.3, ASME IX		

JOINT

Joint Design :	See Below	Bevel Angle :	30° ± 5°
Backing :	N/A	Root Gap :	2mm ± 0.4mm
Backing Material :	N/A	Root Face :	1.6mm ± 0.8mm



BASE METAL

Material Specification Type & Grade :	API 5L X60
Material Items (Name)	Pipe to Pipe or Pipe to fittings (CE shall not increase with more than 0.03)
Pipe Diameter Qualified	24"
Pipe Diameter Range	12" - 36"
Pipe Thickness Qualified:	12.7mm
Pipe Thickness Range :	9.5mm - 19.05mm

FILLER METALS

Weld Run	Size	Electrode Brand	AWS Specification	AWS Classification
ROOT	1/8" (3.2mm)	Lincoln Fleet Weld	A 5.1	E 6010 SP+
HOT PASS	1/8" (3.2mm)	Lincoln Jet Weld	A 5.1	E 7018 H4R
FILLING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R
CAPPING	5/32" (4.0mm)	Lincoln Jet Weld LH70	A 5.5	E 7018 H4R

ELECTRODE STORAGE

Electrode Drying Conditions:	E6010	As per manufacturer's recommendation for handling and storage. Re-drying not recommended
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Welding Procedure Specification Guide

Robert R. Redfield



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