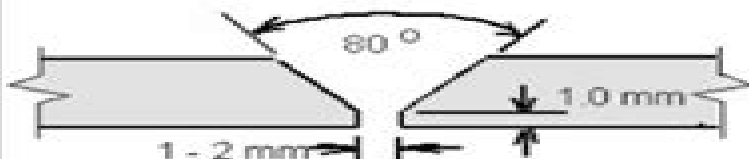



Welding Procedure Specification:- Example

Weld Procedure Number		30 P1 TIG 01 Issue A	
Qualifying Welding Procedure (WPAR)		WP T17/A	
Manufacturer:	National Fabs Ltd 25 Lane End Birkenshaw Leeds	Method Of Preparation and Cleaning:	Machine and Degrease
Location:	Workshop	Parent Metal Specification:	Grade 304L Stainless Steel
Welding Process:	Manual TIG	Parent Metal Thickness:	3 to 8mm Wall
Joint Type:	Single Sided Butt Weld	Pipe Outside Diameter:	25 to 100mm
		Welding Position:	All Positions
		Welding Progression:	Upwards

Joint Design	Welding Sequences
	

Run	Process	Size Of Filler Metal	Current A	Voltage V	Type Of Current/Polarity	Wire Feed Speed	Travel Speed	Heat Input
1 2 And Subs	TIG TIG	1.2mm 1.6mm	70 - 90 80 - 140	N/A	DC- DC-	N/A	N/A	N/A

Welding Consumables:- Type, Designation Trade Name: Any Special Baking or Drying:	BS 2901 Part 2 : 308S92 No	Production Sequence
Gas Flux:	Argon 99.99% Purity	1. Clean weld and 25mm borders to bright metal using approved solvent.
Gas Flow Rate - Shield:	8 - 12 LPM	2. Position items to be welded ensuring good fit up and apply
- Backing:	5 LPM	

Welding Procedure Guide

American Welding Society

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the American Welding Society text.

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the transition to automated assembly systems and applications **Welding Handbook: Welding processes** American Welding Society,1987 *Guidelines for Welding Procedure Specifications* Structural Engineers Association of Northern California. Construction Quality Assurance Committee,1997 **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

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