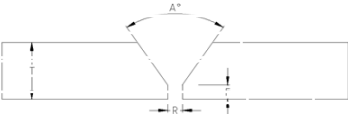
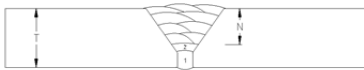


Preliminary WELDING PROCEDURE SPECIFICATION

(ISO 15609-1; BS EN ISO 15614-1 - 2017 Edition, Level 2)

DESCRIPTION	
1. WPS No.:	WPS-ACFY-03 Rev00-ISO 15614-1
2. WPQR No.:	PQR-ACFY-03 Rev00-ISO 15614-1
3. Manufacturer:	ARCHIRODON
4. Mode of metal transfer:	FUSION
5. Joint type and weld type:	BW-BUTT JOINT
6. Weld preparation details:	SIGNLE V
7. Method of preparation and cleaning:	MACHINING
8. Parent material designation:	S355JR GROUP 1 -SUB-GROUP 1.2
9. Material thickness (mm):	12 < T < 100
10. Outside diameter (mm):	D > 25
11. Welding position:	PG
12. Other:	

JOINT DESIGN	WELDING SEQUENCES
<p>Root gap: 2-3 mm Root face: 1-3 mm Groove preparation: 60-65 Angle bevel: 30-32.5</p> 	

WELDING DETAILS									
Run	Welding process	Filler metal		Current & polarity	Amperage range	Voltage range	Travel speed [mm/minute]	Heat input [kJ/mm]	Other
		Class.	Dia. [mm]						
Root	111	E 42 5 B 12 H5	2.5	DCEN	55-85	21-22	83-84	1.27	k=?
Hot	111	E 42 4 B 42 H5	3.2	DCEP	110-150	22-23	96-132	1.25	
Fill	111	E 42 4 B 42 H5	3.2	DCEP	110-190	22-24	96-132	1.25	
Cap	111	E 42 4 B 42 H5	3.2	DCEP	110-150	22	100-128	1.32	

13. Filler metal designation and make:		23. Heating and cooling rate:	
14. Any special baking and drying:	EN 499	24. Weaving:	
15. Designation gas / flux:		25. Oscillation	- Amplitude: - Frequency: - Method:
16. Gas flow rate:		26. Pulse welding details:	
17. Tungsten electrode type/size:		27. Distance contact tube/work pipe:	
18. Detail of back gouging/backing:		28. Plasma welding details:	
19. Preheat temperature:	25mm 100-150 °C	29. Touch angle:	
20. Inter-pass temperature:	< 300 °C	30. Other information:	
21. Pre-heat maintenance temperature:		-	
22. PWHT and/or ageing:	NA	-	
	- Time:	-	
	- Temperature:	-	
	- Method:	-	

WELDING ENGINEER	QA/QC MANAGER	THIRD PARTY	CLIENT