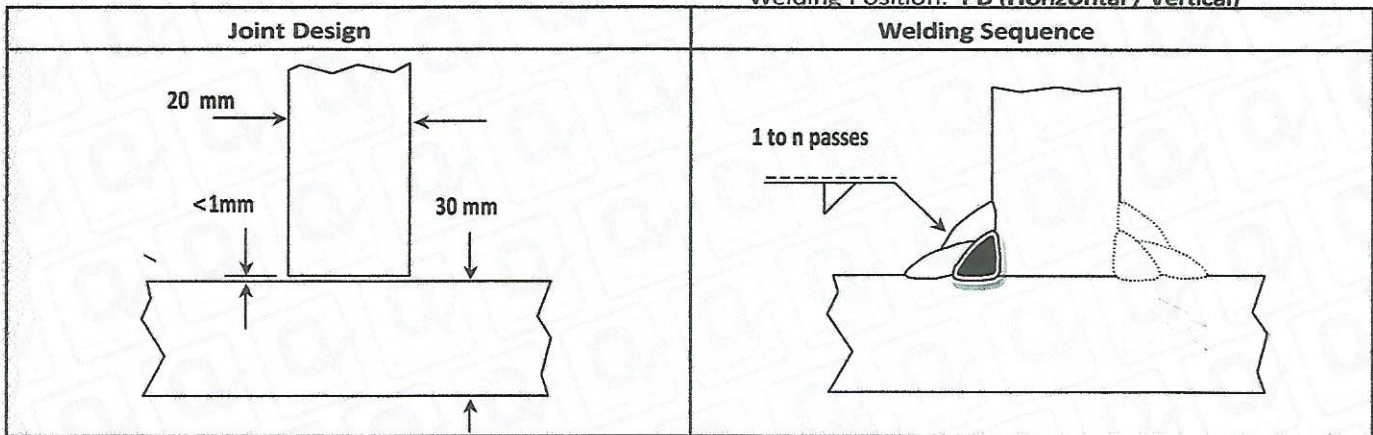


Welding Procedure Specification (WPS)

According to EN- ISO 15609-1:2004 & EN- ISO 15607:2003

Applied codes EN- ISO 15614-1:2004+A1:2008+FDAM 2:2011+ A2:2012

Location:	Manufacturer site	Method of Preparation and Cleaning:	Thermal cut and / or grinding, wire brush and degrease if required
WPS No:	QMS/PAR -01	Parent Material Designation:	According to CR ISO 15608
WPQR No:	QM/PQ-14/016 of 10.06.2016	Group 1 subgroup 1.2 to Group 1 subgroup 1.2	S 355GH to S 355GH
Manufacturer:	PARASKEVAIDIS A.B.E.E.	Material Thickness:	20 mm to 30 mm
	1° Km GIANNITSA-EDESSA GIANNITSA- HELLAS	Outside Diameter:	N/A
Welding Process	135 (MAG)	Welding Position:	PB (Horizontal / Vertical)
Joint Type:	Fillet Weld (FW)		



Welding Details:

Run	Process	Size of Filler Metal Ø mm	Current A	Voltage V	Type of Current/ Polarity	Wire Feed Speed m/min	Travel Speed mm/min	Heat Input kJ/mm
1	135 (MAG)	1.2	270-290	29-31	DC +ve	7.5 – 8.0	320-340	1.1– 1.3
2 – n	135 (MAG)	1.2	250-270	26-28	DC +ve	6.0 – 6.5	260-280	1.1– 1.4

Filler Metal Classification & Trade Name

Any Special Baking or Drying

Gas/Flux: - Shielding / Backing

Shielding Gas Flow Rate

Tungsten Electrode Type / Size

Details of Back Gouging / Backing

Preheat Temperature

Interpass Temperature

Post-Weld Heat Treatment and / or Ageing

Time, Temperature, Method

Heating & Cooling Rates

Other Information

BS EN ISO 14341-A: G3Si1 LINDE- AWS 5.18 ER 70 S-6

Stored in accordance with manufacturers recommendations

Gorgon 18 (80% Argon + 20% CO2)

11 – 13 lit/min

N/A

N/A

≥ 10°C

200 °C – 230 °C

N/A

N/A

N/A

1. Nozzle diameter = 16mm.

2. In all cases the gap between component parts shall be kept to a minimum

3. Should the gap between component parts exceed 1mm, the fillet leg length shall be increased in order to achieve the required design throat thickness. Under no circumstance should the gap between component parts exceed 3mm.

4. Weld finish to be left as-welded unless specified otherwise

For Manufacturer:

For Examiner / Examining Body:

PAPADOPOULOS DIMITRIOS

Lead Auditor - MSc. Dipl. Mechanical Engineer

Dr. Welding Engineer - Level II UT,MT,PT,RT,VT.

10.06.2016

