



Southern
BRANCH

QA/QC
DEPARTMENT

WELDING PROCEDURE SPECIFICATION (WPS)

ACCORDING TO API 1104

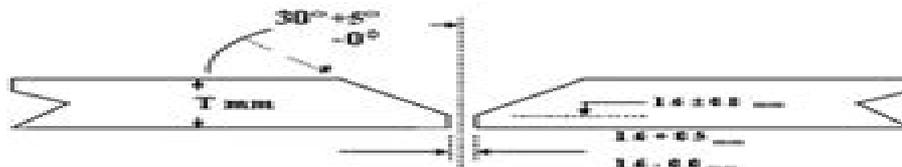
Date : 16/10/2016

WPS No. : P01

Sheet : 1 of 1

COMPANY NAME	: GASCO
PROJECT NAME	: Dabshor-Bany Swief 36" pipeline
WELDING PROCEDURE SPECIFICATION No.	: P01 Main Pipeline
REVISION NO.	: 0
SUPPORTING PQR NO.	: PQR (PL-02/2010)
TYPES (Manual, Automatic, Semi Auto.)	: MANUAL (SMAW)

JOINTS DESIGN



BASE METAL

Material Spec.	: API-5L
Type or Grade	: X-65
P No.	: 01
A No.	: 01
Thickness	: 4.8 ≤ T ≤ 19.05 mm
Diameter	: 36"
Other	

FILLER METALS

Weld Metal Analysis A No.	: A1
Size of Electrode	: 3.25, 4.0 & 5.0 mm
Filler Metal No.	: F3
SFA Specification	: A 5.1 & A 5.5
AWS Classification	: E 6010 & E 8010G

POSITION

Position of Groove	: SG
Direction of welding	: All Down-Hill
Other	

PREHEAT

Preheat Temp. (°C) (Min)	: 30°C (if needed)
Interpass Temp. (°C) (Max)	: 250 °C Max
Other	: N.A.

POSTWELD HEAT TREATMENT

Temperature Range	: N.A.
Time Range	: N.A.
Other	: N.A.

GAS

Type of Gaser Gases	: N.A.
Composition of Gas Mixture	: N.A.
Other	: N.A.

ELECTRICAL CHARACTERISTICS

Current	: DC
Polarity	: -ve & +ve

WELD LAYERS	FILLER METAL		CURRENT		VOLTAGE RANGE
	Class	Stem (mm)	Polar.	Amp. range	
1 st	E6010	3.25	-ve	80-110	20-22
2 nd	E8010G	4.00	+ve	120-180	20-27
3 rd	E8010G	4.00	+ve	120-180	20-27
4 th	E8010G	5.00	+ve	120-180	20-27
CAP	E8010G	3.00	+ve	120-180	20-27

TECHNIQE

Interpass Cleaning	: Root Grinding & Wire Brush
String or Weave Bead	: Both
Orifice or Gas Cup Size	: N.A.
Multi pass or Single Pass	: Multi-passes
Single or Multiple Electrodes	: Single
LINE UP CLAMP	: Remove Internal Clamp after 100% of the Root Pass
Maximum time between 1 st and 2 nd pass (5 minutes)	
Maximum time between 2 nd pass and others	: Shortly

JOB TITLE	PROJECT QA / QC	Chief QA / QC
NAME	AMMED SHAWKY	ABD-ELFATTAH ABU ALI
DATE	16/10/2016	16/10/2016
SIGN		

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