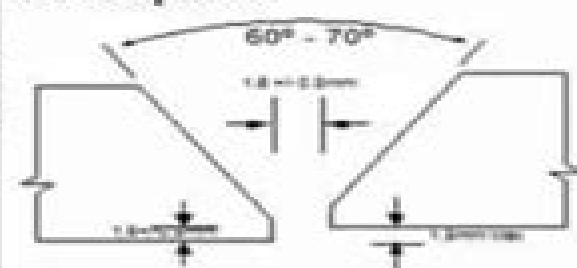


# Welding Procedure Specification

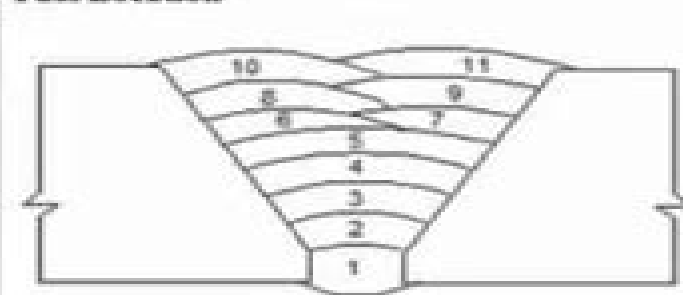
Client:	<b>Mobil</b>	Project:	<b>221010Goatee</b>	REF No.	<b>WPS 6 R1</b>
Procedure Description:	<b>12" Heavy Wall Offshore Tie-in</b>			<b>02901/WPSS</b>	
Material:	<b>AS3679.1 Grade 250 API 5L X65</b>	Diameter:	<b>168.3</b>	Thickness:	<b>18.3</b>
Position:	<b>6G</b>	Clamp Type:	<b>Internal</b>		
Preheat °C (Min):	<b>100</b>	Interpass °C (Max):	<b>300</b>		
Welding Process	<b>ROOT SMAW</b>	Welding Process	<b>HOT PASS SMAW</b>	Welding Process	<b>FILL &amp; CAP SMAW</b>
Welding Direction	Vertical Down	Welding Direction	Vertical Down	Welding Direction	Vertical Down
Filler	Lincoln SA70+	Filler	Lincoln SA70+	Filler	Bohler BVD90M
Polarity	DC +ve	Polarity	DC +ve	Polarity	DC +ve
Shielding Gas	N/A	Shielding Gas	N/A	Shielding Gas	N/A
Purge Gas	N/A	Purge Gas	N/A	Purge Gas	N/A

Pass No	Filler Size (mm)	Amps	Volts	Speed (mm/sec)	Heat Input (kJ/mm)
1	3.2mm	70-130	18-33	3.3-6.6	0.4-0.5
2	4.0mm	110-210	18-35	2.9-6.3	0.6-1.3
FILL	4.0mm	145-260	16-27	1.6-7.0	0.6-2.2
CAP	4.0mm	130-230	16-26	1.8-6.3	0.6-1.7

### Weld Preparation



### Pass Location



### NOTES

1. API Std 1104BP3094-SP-PL-3010R1
2. Clamp removal gage: 100% completion of root (external clamp may be used in the event of a breakdown - removed after 50% minimum completion of the root.)
3. Time lapse between root and second pass : 16 Minutes
4. Time lapse between second pass and 1<sup>st</sup> fill : 12 Minutes
5. Minimum number of passes before pipe movement : 2 passes
6. Minimum number of passes before break in welding : 3 passes
7. Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1
8. Method of cleaning : Grinder / Wire brush
9. Method of Preheat : Gas Torch
10. Qualification reference number : 48250/PP/WP6 R1

**Company Welding  
Engineer Approved**

**Approved for Client**

# Welding Procedure Specification Wps Sheet 1 Of 3

**Julia Schneider**



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