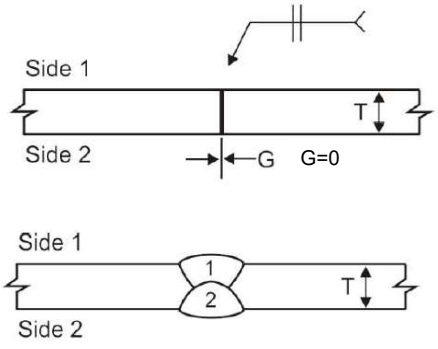
POLAR POCKET WPDS	Pocket-POLAR-07	0	April 17, 2025
	WPDS No.	Rev.	Date

Seaspan Vancouver Shipyards Co. Ltd.	Applicable Standard(s)	Lloyds Register - Rules for the Manufacture, Testing and Certification of Materials 2022

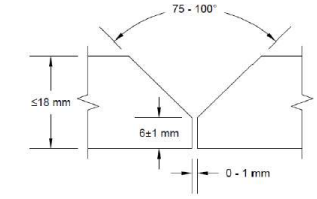
	Process/Mode	Wire/Flux Classification	Brand Name	Manufacturer
1	SAW	**AWS A5.23 : F7A4-EA1-A2**	**Lincolnweld L-70 / 888**	**Lincoln Electric**

Material Designation	Base material 1	Base material 2	Min. Preheat / Interpass Temp.	As per VSY Preheat and Interpass Temperature Requirements for Welding
	EH 36 and all lower toughness grades	EH 36 and all lower toughness grades		
Delivery Condition(s)	All except QT	All except QT		
Thickness or Dia	**6mm - 100 mm**	**6mm - 100 mm**	Max. Interpass Temp.	**180°C**
Nominal Pipe Size	**150mm and above**	**150mm and above**	PWHT	**N/A**
Welding Position	**1G**		Joint Design	**Butt Square, Single/Double Bevel/Vee**

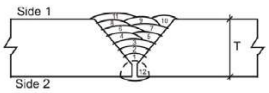
EP-217



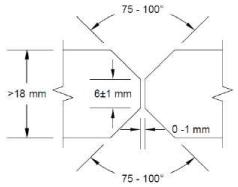
EP-206



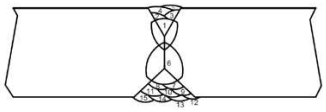
THK≤18mm



EP-207



18mm<THK



TYPICAL JOINT PREPARATION FOR THK≤13mm

TYPICAL JOINT PREPARATION FOR THK>13mm

COMPLETE JOINT PENETRATION	JOINT TYPE
■ **Back-gouged to sound metal**	■ **BUTT**
☐ Welded onto steel backing	☐ CORNER
☐ Welded form one side without backing	☐ LAP
■ **Welded both sides w or w/o back-gouging**	☐ TEE
☐ Welded onto other than steel backing	☐ EDGE

Back Purge	N/A	Contact Tip to Work Distance	20-55 mm	
Backing type	N/A			
Welding Technique	Stringer	Shielding Gas	N/A	
Max. Bead Width	N/A			
Tungsten Electrode	N/A	Gas Flow	N/A	☐ Cfph ☐ Lpm
Cleaning	Grinding and Wire Wheel			

Edge Prep	BM Thickness (mm)	Layers / Passes	Position	Electrode Size (mm)	Welding Process	Power Mode	Consumable	Amperage	Voltage	WFS (IPM)	Travel Speed (IPM)	Heat Input kJ/mm
217	6≤T≤14.3	Side 1	1G	3.2 & 4.0	SAW	CC/DC+	F7A4-EA1-A2	398 - 688	24 - 43	45-79	18-30	Note 4
217	6≤T≤14.3	Side 2	1G	3.2 & 4.0	SAW	CC/DC+	F7A4-EA1-A2	417 - 850	24 - 43	47-91	18-30	
206 207	10<T≤100	Side 1 **Root**	1G	3.2 & 4.0	SAW	CC/DC+	F7A4-EA1-A2	360-838	22-41	13-55	17-34	Note 5
206 207	10<T≤100	Side 2 **Root**	1G	3.2 & 4.0	SAW	CC/DC+	F7A4-EA1-A2	397-900	25-41	13-55	16-29	
206 207	10<T≤100	Side 1&2 **Fill/Cap**	1G	3.2 & 4.0	SAW	CC/DC+	F7A4-EA1-A2	338-825	23-40	13-55	15-36	

Note 1: Joint must be free from any source of contamination

Note 2: Heat Input (kJ/mm) = [V x A x 60] / [Travel Speed (mm/min) x 1000]

Note 3: Grind joint and adjacent surfaces to bright metal prior to welding to remove all traces of paint, primer, scale, rust, moisture and any other contaminants. Wire brush, grinding to be used for interpass cleaning.

Note 4	**Base Metal THK (mm)**	**6 ≤ T < 9.7**	**9.7 ≤ T ≤ 9.9**	**10 < T ≤ 14.3**
	Root Heat Input (kJ/mm)	Side1: 1.3 - 2.1 | Side2: 1.3 - 2.2	Side1: 1.3 - 2.2 | Side2: 1.3 - 2.9	Side1: 1.3 - 2.2 | Side2: 1.7- 2.9
Note 5	**Base Metal THK (mm)**	**10 ≤ T < 25**	**25 ≤ T ≤ 40**	**40 < T ≤ 100**
	Root Heat Input (kJ/mm)	Side1: 0.9 - 1.5 | Side2: 1.4 - 2.2	Side1: 0.9 - 3.4 | Side2: 1.4 - 3.5	Side1: 2.0 - 3.4 | Side2: 2.0- 3.5
	Fill/Cap Heat Input (kJ/mm)	1.0 - 2.1	1.0 - 3.6	1.3 - 3.6

Reference WPS No.	SA-CS-G-01 (Rev. 1) SA-CS-G-02 (Rev. 1)	**Engineer Stamp**

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