



Seaspan Vancouver Shipyards Co. Ltd.
Seaspan Victoria Shipyards Co. Ltd.
Seaspan Vancouver Drydock Co. Ltd.

WPS No:
DNVGL-Pipe-03-02 (CS GTAW)
Revision No:
2

WELDING PROCEDURE SPECIFICATION (WPS)

General information pWPS

Manufacturer:	Seaspan Vancouver Shipyards Co. Ltd.			
Manufacturer address:	50 Pemberton Ave., North Vancouver, B.C. V7P 2R2			
Welding procedure qualification test records:	PQR DNVGL-Pipe-03-02 (CS GTAW) PQR DNVGL-Pipe-03-02-1			

Welding process (ISO 4063):	141-GTAW Manual	Number of electrodes:	1	Tungsten electrode designation and Ø:	2 % Thoriated 3.2 mm
Welding position(s) (ISO/ASME):	All ex. 3G down	Joint type:	Pipe and Plate Butt, T, K, Y CJP, PJP Groove, Fillet weld	Stringer/weave, max. bead width:	Stringer 16 mm
Welding layer:	Multi-layer One/ Two side	Backing: Gas flow rate:	Without or With 8 – 15 (l/min)	Method of preparation:	Plasma / Oxy fuel cut
Min. preheating tempertaure:	Ambient °C	Max. interpass temperature:	144 °C	PWHT details:	None

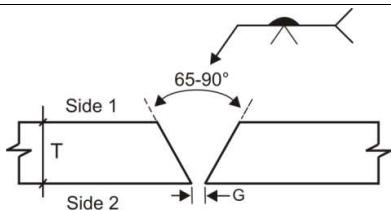
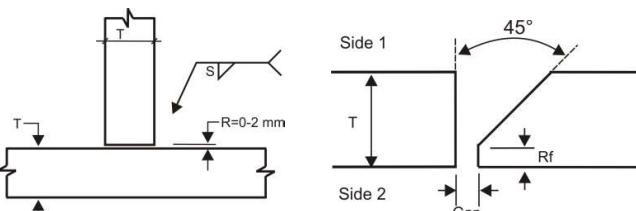
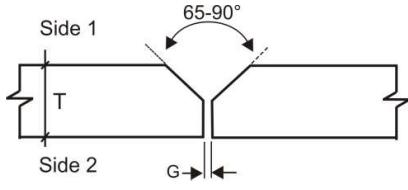
Material specification

Base material 1 group:	ASTM A106 Gr. B and all P-No 1, Group No. 1 materials	Base material 2 group:	ASTM A106 Gr. B and all P-No 1, Group No. 1 materials
Delivery condition(s):	AR Hot Rolled Seamless pipe	Delivery condition(s):	AR Hot Rolled Seamless pipe
Max. C _{eq} :	N/A	Max. C _{eq} :	N/A
Thickness range		Thickness range	
Butt:	3 – 19 mm	Butt:	3 – 19 mm
Fillet		Fillet	
Throat:	3 – 19 mm	Throat:	3 – 19 mm
Leg size:	4.2 – 26.8 mm	Leg size:	4.2 – 26.8 mm
Outside diameter range:	> 63 mm	Outside diameter range:	> 63 mm

Welding consumables

No.	Filler metal and flux			ISO or AWS classification	Shielding gas		Nozzle diameter (mm)	DNV GL grade(s)
	Type	Manufacturer	Brand Name/Designation		Type	Purity		
1	Rod	HARRIS	ER70S-2 (GTAW) TIG	AWS A5.18 ER70S-2	Argon	100%	8	

Joint preparation (sketch) and welding details

Joint design	Welding sequences
<p>State rolling direction, if applicable</p>  <p>Thickness $T = 3 - 19$ mm Groove angle = $65 - 90^\circ$ Root face $Rf = 0 - 2$ mm Root gap $G = 2 - 4$ mm</p> <p>All position except 3G down Single or Double Vee groove, Butt, T, K, Y Complete/ Partial Joint Penetration</p>   <p>Note: * Pipes rolling direction transverse to the weld. * Branch connections shall be qualified separately * This procedure is applicable for welding from one side with/ without backing (gas purging) and both side with/ without gouging * Grind weld joint preparation edges 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. * This procedure is also applicable for other double side and single side welded preparation. Also this procedure covers single bevel joint design. * Any change in welding consumable brand name/designation is permitted as long as AWS/ISO consumable classification remains the same as PQR.</p>	<p>For multiple welding process qualification, the deposited weld metal thickness shall be recorded for each filler metal and process used.</p> <p>Multi Runs/ Multi layers as required</p>

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Run ⁽¹⁾	Process ⁽²⁾	C ⁽³⁾	Ø ⁽⁴⁾ (mm)	Gas flow (l/min)	Current (A)	Voltage (V)	C&P ⁽⁵⁾	v ⁽⁶⁾ (cm/min)	s ⁽⁷⁾ (mm/s)	F/B ⁽⁸⁾	HI ⁽⁹⁾ (kJ/cm)
Root	141-GTAW	1	2.4	8 – 15	75 – 135	11 – 17.5	DC-	3.7 – 7	N/A	B and F	7.7 – 26
Hot, Fill, Cap	141-GTAW	1	2.4, 3.2, 4.0	8 – 15	95 – 220	11 – 18	DC-	6.6 – 11	N/A	B and F	7.4 – 21.2

(1) Root, fill or cap. (2) Ref. ISO4063. (3) Welding consumable, see previous table. (4) Filler metal diameter. (5) Current and polarity, /P for pulse welding. Details to be specified below. (6) Travel speed. (7) Wire feed speed. (8) Forehand "F" or backhand "B" progression. (9) Heat input not compensated for process efficiency (arc energy).

Note:

- * The values for the Current (A) and Voltage (V) are -15%, +25% and ±15% for Travel speed (V) based on the PQRs DNVGL-Pipe-03-02 (CS GTAW) and DNVGL-Pipe-03-02-1.
- * Range of the Heat Inputs are ± 25% based on the actual values in the PQRs DNVGL-Pipe-03-02 (CS GTAW) and DNVGL-Pipe-03-02-1.
- * **Selection of Current (A), Voltage (V) and Travel speed (V) shall be in compliance with approved range of heat input provided above.**

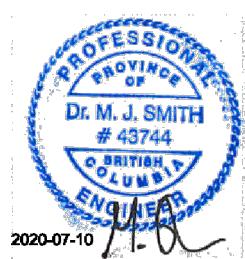
Further information

Shop primer for fillet weld	Brand name: N/A	Max. dry film thickness: N/A µm
Manufacturer: N/A	Brand name: N/A	Max. dry film thickness: N/A µm

Survey station:

Vancouver DNVGL - Maritime

Place : **Vancouver, BC, Canada**
 Date: **May-22-2020**



for **DNV GL**



Volodymyr Chumak
Seniro surveyor - DNV GL Maritime Vancouver

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