

				WELDING PROCEDURE SPECIFICATION (WPS)				WPS No.: SMV 101-1			
								Ref. stand: NS-EN ISO 15614-2			
Prod. by: Sørskår Mekaniske Verk AS Client: General				Ref. spec.: NORSOX M-102				Exam. body: Teknologisk Institutt			
Project: General				Location: Sørskår				Ref. WPQR: SMV 101 rev.2			
Welding process	131*			Shielding gas type	1 Mison Ar (I1)			Joint type	2		
Weaving (yes/no)	Yes max.: 12 mm								3		
Purging gas type	NA l/min										
Welding positions	PA, PB PC, PD PE, PF										
Joint type	BW/FW										
Joint preparation	Machining										
Cleaning method	Aceton/ SS Wire brush										
Backing	nb(mb										
Single/Double	ss-bs										
Back gouging	Grinding										
Flux designation	NA										
Flux handling	NA										
Tungsten electrode	NA mm										
Torch angle	70-90 °										
Stand off distance	10-20 mm										
Nozzle diameter(s)	16										
Tack welding proc.	SMV, Standart Rev.:										
<b>Identification of parent metal</b>				I C max:	CE max:	PCM max:	II C max:	CE max:	PCM max:		
	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]					
I	EN AW 6082	EN 573-3	23.1	T651	3,00 - 40,00	500,0 -					
II					-	-					
<b>Identification of filler metal</b>											
Index	Trade name			Classification			Group	Filler handling			
1	ESAB Autrod 5183			AWS A 5.10 ER 5183				Supplier Specification			
2											
3											
<b>Welding Parameters</b>					Equipment:						
Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Volt [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
FW				-	-	-		-			-
1	1	1,20	131	7,00-8,00	120 - 140	19 - 20	DC+	320 - 400		18-20	0,3 - 0,5
Cap	1	1,20	131	10,0-11,0	160 - 190	21 - 23	DC+	230 - 460		18-20	0,4 - 1,1
BW				-	-	-		-			-
1	1	1,20	131	7,00-8,00	110 - 140	17 - 19	DC+	320 - 350		18-20	0,3 - 0,5
Fill1	1	1,20	131	9,00-10,0	160 - 170	20 - 21	DC+	340 - 460		18-20	0,4 - 0,6
Fill2	1	1,20	131	10,0-12,0	170 - 200	21 - 22	DC+	320 - 620		18-20	0,3 - 0,8
Cap	1	1,20	131	10,0-11,0	160 - 190	21 - 23	DC+	230 - 460		18-20	0,4 - 1,1
				-	-	-		-			-
<b>Heat treatment</b>											
Method:											
Preheat min: 30 °C Interpass temp. max: 100 °C				Heat treatment proc.: Propan				Temp. control: Heat stick			
PWHT min: °C max.: °C Soaking: min/mm				Heating rate: °C/h				Cooling rate: °C/h			
Remarks: *Valid for manual welding only Throat thickness min 7,5mm											
Additional info enclosed (Yes/No): Date/Signature: <i>Øj 22.04.14</i> Approved: <i>Sørskår Mek. Verksted as</i> Produced by WeldEye®											

WELDING PROCEDURE SPECIFICATION (WPS)				WPS No.: SWWPS 102							
				Ref.: Olav Sørskår Date: Rev.: 3							
Prod. by: Sørskår Mek. Verksted AS Client: General				Ref. stand: NS EN ISO 15614-2							
Project: General Ref. spec.: NORSOX M-102				Exam. body: TI							
Location: TAU Ref. WPQR: SWW 101-1 rev.2											
Welding process	131*										
Shielding gas type	1 Mison Ar (II)		2			3					
Weaving (yes/no)	yes	max.: 12 mm		max.: mm		max.: mm					
Purging gas type	NA l/min										
Welding positions	PA, PB PC, PD PE, PF										
Joint type	BW										
Joint preparation	Machining, grinding										
Cleaning method	Acetone										
Backing	nb/mb										
Single/Double	ss/bs										
Back gouging	Grinding										
Flux designation	NA										
Flux handling	NA										
Tungsten electrode	NA mm										
Torch angle	70-90 °										
Stand off distance	10-20 mm										
Nozzle diameter(s)	16										
Tack welding proc.	SMV standard Rev.:										
<b>Identification of parent metal</b>				I C max:	CE max:	PCM max:	II C max:	CE max:	PCM max:		
	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]					
I	Aluminium 6082	EN 573-3	23.1	T651	3,00 - 40,00	500,0 - 9999					
II			23.1		-	-					
<b>Identification of filler metal</b>											
Index	Trade name		Classification			Group	Filler handling				
1	ESAB OK Autrod 18,16 AWS A5.10:ER 5183						ESAB Supplier Specification				
2											
3											
<b>Welding Parameters</b>				Equipment:							
Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Volt [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas l/min]	Heat input [kJ/mm]
1	1	1,20	131	7,00-8,00	110 - 140	17 - 19	DC+	320 - 350		18-20	0,3 - 0,5
Fill	1	1,20	131	9,00-12,0	160 - 200	20 - 22	DC+	340 - 620		18-20	0,3 - 0,8
Cap	1	1,20	131	10,0-11,0	160 - 190	21 - 23	DC+	230 - 460		18-20	0,4 - 1,1
				-	-	-		-		-	
				-	-	-		-		-	
				-	-	-		-		-	
				-	-	-		-		-	
				-	-	-		-		-	
				-	-	-		-		-	
<b>Heat treatment</b>											
Method:											
Preheat min:	30 °C	Interpass temp. max:	100 °C	Heat treatment proc.:	Propan	Temp. control:	Heat stik				
PWHT min:	°C	max.:	°C	Soaking:	min/mm	Heating rate:	°C/h	Cooling rate:	°C/h		
Remarks: * Valid for manual Welding only											
Additional info enclosed (Yes/No): Date/Signature: 26.03.14 Approved:											

