

Weld Requirements for AAC-1EF2

These weld procedures are indicators only.
Actual details are needed from the WPS sheets.
Either supplied by the company or supplied by
the fabricator and approved by the company.

Process: GTAW (Tig) root, fill and cap.

Notes: None

Weld Procedure	Process	Weld Filler	Filler Group	Approved Thickness	Material	Position	Position Description	Welder Qualification Certificate Notes	Notes
WP DELETE	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	Sandvik 25-22-2L Mn / Sandvik25-2 2-2LMnB	F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		