

Weld Requirements

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) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.

Notes: Test

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		

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 / Sandvik25-22-2LMnB	F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP305	GTAW (TIG) root, SMAW (stick) fill and cap.	E7018-1	F4	1/16" to 2.6"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

Process: GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.

Notes: None

Weld Procedure	Process	Weld Filler	Filler Group	Approved Thickness	Material	Position	Position Description	Welder Qualification Certificate Notes	Notes
WP309	GTAW (Tig) root, fill and cap.	ER70S-2	F6	1/16" to 0.43"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP333	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	ER316L / E316L	F5	1/16" to 1.5"	P1 / P1	2G	Pipe vertical, weld deposited in horizontal plane.		

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

Notes: 250 F Preheat required

Weld Procedure	Process	Weld Filler	Filler Group	Approved Thickness	Material	Position	Position Description	Welder Qualification Certificate Notes	Notes
WP309	GTAW (Tig) root, fill and cap.	ER70S-2	F6	1/16" to 0.43"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP345	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	Sandvik 25-22-2L Mn / Sandvik25-2 2-2LMnB	Root - F6 / Fill - F5	1/16" to 0.75"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP334	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	Sandvik 25-22-2L Mn / Sandvik25-2 2-2LMnB	Root - F6 / Fill - F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

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
WP337	GTAW (TIG) root, SMAW (stick) fill and cap.	E316L	Root - F6 / Fill - F5	1/16" to 0.75"	P45 / P45	5G	Pipe horizontal, weld deposited in vertical plane		
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		

Process: GTAW (TIG) root, SMAW (stick) fill and cap.

Notes: Delete after test

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		
WP9000	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		

Process: GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) 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 / Sandvik25-22LMnB	F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP555	GTAW (Tig) root, fill and cap.	E320	F5	1/16" to 0.86"	P45 / P45	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

Process: GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.

Notes: None

Weld Procedure	Process	Weld Filler	Filler Group	Approved Thickness	Material	Position	Position Description	Welder Qualification Certificate Notes	Notes
WP386	GTAW (Tig) root, fill and cap.	Sandvik 25-22-2L Mn	F5	1/16" to 0.75"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

Process: GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) 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 / Sandvik25-22LMnB	F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP309	GTAW (Tig) root, fill and cap.	ER70S-2	F6	1/16" to 0.43"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

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
WP305	GTAW (TIG) root, SMAW (stick) fill and cap.	E7018-1	F4	1/16" to 2.6"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

Process: GTAW (TIG) or SMAW (stick) root, SMAW (stick) 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		
WP309	GTAW (Tig) root, fill and cap.	ER70S-2	F6	1/16" to 0.43"	P1 / P1	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		
WP334	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	Sandvik 25-22-2L Mn / Sandvik25-2 2-2LMnB	Root - F6 / Fill - F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

Process: GTAW (TIG) root, SMAW (stick) fill and cap.

Notes: None

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WP9000	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		

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

Notes: None

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WP DELETE	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	Sandvik 25-22-2L Mn / Sandvik25-22LMnB	F5	1/16" to 0.86"	P8 / P8	6G	Pipe at 45 degree angle, weld deposited in vertical plane right angles to pipe		

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

Notes: None

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

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WP333	GTAW (TIG) or SMAW (stick) root, GTAW (TIG) or SMAW (stick) fill and cap.	ER316L / E316L	F5	1/16" to 1.5"	P1 / P1	2G	Pipe vertical, weld deposited in horizontal plane.		
WP9000	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		

