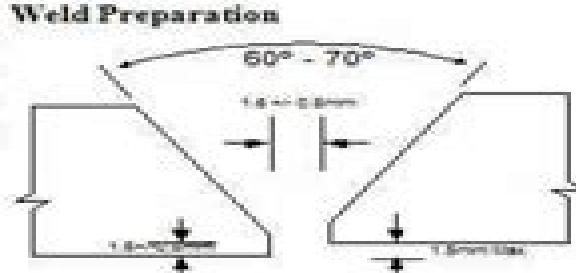
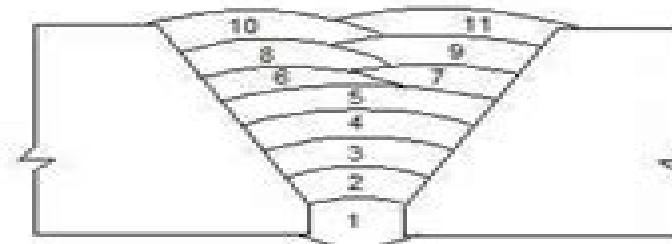


# Welding Procedure Specification

Client:	<u>Mobil</u>		Project:	<u>221010Goatee</u>		REF No.:	<u>WPS 6 R1</u>	
Procedure Description:	<u>12" Heavy Wall Offshore Tie-in</u>					02901/WPS5		
Material:	<u>AS3679.1 Grade 250 API SL X65</u>			Diameter:	<u>168.3</u>		Thickness:	<u>18.3</u>
Position:	<u>6G</u>			Clamp Type:	<u>Internal</u>			
Preheat °C (Min):	<u>100</u>			Interpass °C (Max):	<u>300</u>			
Welding Process	<b>ROOT</b> <b>SMAW</b>			<b>HOT PASS</b> <b>SMAW</b>		<b>FILL &amp; CAP</b> <b>SMAW</b>		
	Vertical Down			Vertical Down		Vertical Down		
Welding Direction	Vertical Down			Vertical Down		Vertical Down		
Filler	Lincoln SA70+			Lincoln SA70+		Bohler BVD90M		
Polarity	DC +ve			DC +ve		DC +ve		
Shielding Gas	N/A			N/A		N/A		
Purge Gas	N/A			N/A		N/A		
Pass No.	Filler Size (mm)	Amps	Volts	Speed (mm/sec)	Heat Input (kJ/mm)	<b>Weld Preparation</b> 		
1	3.2mm	70-130	18-33	<u>3.3-6.6</u>	<u>0.4-0.8</u>			
2	4.0mm	130-210	18-36	<u>2.9-6.8</u>	<u>0.6-1.3</u>			
FILL	4.0mm	145-260	16-27	<u>1.6-7.0</u>	<u>0.6-1.2</u>			
CAP	4.0mm	130-210	16-26	<u>1.8-8.3</u>	<u>0.6-1.7</u>			
<b>NOTES</b>								
<ol style="list-style-type: none"> <li>1. API Std 1104/BP3094-SP-PL-3010R1</li> <li>2. Clamp removal stage: 100% completion of root (external clamp may be used in the event of a breakdown – removed after 50% minimum completion of the root.)</li> <li>3. Time lapse between root and second pass: 16 Minutes</li> <li>4. Time lapse between second pass and 1<sup>st</sup> fill: 12 Minutes</li> <li>5. Minimum number of passes before pipe movement: 2 passes</li> <li>6. Minimum number of passes before break in welding: 3 passes</li> <li>7. Minimum Number of welders- Root &amp; second pass: 2 , Fill &amp; Cap : 1</li> <li>8. Method of cleaning: Grinder / Wire brush</li> <li>9. Method of Preheat: Gas Torch</li> <li>10. Qualification reference number: 45280/PP/WP6 R1</li> </ol>								
Pass Location								

Company Welding  
Engineer Approved

.....

Approved for Client

.....

# Asme Weld Repair Procedure

**Michael Seilmaier**

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Lewis,2012-10-10 The majority of the cost savings for any oil production facility is the prevention of failure in one of the production equipment such as pressure vessels This book provides engineers with the advanced tools to alter repair and re rate pressure vessels using ASME NBIC and API 510 codes and standards    **Piping and Pipeline Engineering** George A. Antaki,2003-05-28 Taking a big picture approach Piping and Pipeline Engineering Design Construction Maintenance Integrity and Repair elucidates the fundamental steps to any successful piping and pipeline engineering project whether it is routine maintenance or a new multi million dollar project The author explores the qualitative details calculations and techniques that are essential in supporting competent decisions He pairs coverage of real world practice with the underlying technical principles in materials design construction inspection testing and maintenance Discover the seven essential principles that will help establish a balance between production cost safety and integrity of piping systems and pipelines The book includes coverage of codes and standards design analysis welding and inspection corrosion mechanisms fitness for service and failure analysis and an overview of valve selection and application It features the technical basis of piping and pipeline code design rules for normal operating conditions and occasional loads and addresses the fundamental principles of materials design fabrication testing and corrosion and their effect on system integrity    **Weld Cracking in Ferrous Alloys**

R Singh,2008-12-12 Weld cracks are unacceptable defects that can compromise the integrity of welded structures Weld cracking can lead to structural failures which at best will require remedial action and at worst can lead to loss of life Weld cracking in ferrous alloys reviews the latest developments in the design evaluation prevention and repair of weld cracks Part one reviews the fundamentals as well as recent advances in the areas of welding technology design and material selection for preventing weld cracking Part two analyses weld crack behaviour evaluation and repair of cracking cracked welds The book benefits from an extensive and robust chapter on the topic of NDE and quality control that was contributed by one of the most respected non destructive evaluation and development groups in the world Part three covers environment assisted weld cracking With its distinguished editor and international team of contributors Weld cracking in ferrous alloys is a valuable source of reference for all those concerned with improving the quality of welding and welded components In the planning and development of this book particular care has been taken to make the chapters suitable for people from other disciplines who need to understand weld cracking and failure Reviews the latest developments in the design evaluation prevention and repair of weld cracks Assesses recent advances in welding technology design and material selection Analyses weld crack behaviour evaluation and repair including environment assisted weld cracking    **Boiler Shell Weld Repair** Institution of Mechanical Engineers (Great Britain). Pressure Systems Group,1999-12-23 This work explores the technical developments and engineering achievements from the programme of repairs successfully completed by BNFL Magnox Generation to three

shells of reactor R2 at Sizewell A Nuclear Power Station      *Periodic Inspection of Pressurized Components* Institution of Mechanical Engineers (Great Britain),1975      *Codes and Standards and Applications for Design and Analysis of Pressure Vessel and Piping Components, 1991* Robert F. Sammataro,1991      *Surface Production Operations: Volume 5: Pressure Vessels, Heat Exchangers, and Aboveground Storage Tanks* Maurice Stewart,2021-07-22 Covering both upstream and downstream oil and gas facilities Surface Production Operations Volume 5 Pressure Vessels Heat Exchangers and Aboveground Storage Tanks delivers a must have reference guide to maximize efficiency increase performance prevent failures and reduce costs Every engineer and equipment manager in oil and gas must have complete knowledge of the systems and equipment involved for each project and facility especially the checklist to keep up with maintenance and inspection a topic just as critical as design and performance Taking the guesswork out of searching through a variety of generalized standards and codes Surface Production Operations Volume 5 Pressure Vessels Heat Exchangers and Aboveground Storage Tanks furnishes all the critical regulatory information needed for oil and gas specific projects saving time and money on maintaining the lifecycle of mechanical integrity of the oil and gas facility Including troubleshooting techniques calculations with examples and several significant illustrations this critical volume within the Surface Production Operations series is crucial on every oil and gas engineer's bookshelf to solve day to day problems with common sense solutions Provides practical checklists and case studies for selection installation and maintenance on pressure vessels heat transfer equipment and storage tanks for all types of oil and gas facilities Explains restoration techniques with detailed inspection and testing procedures ensuring the equipment is revitalized to maximum life extension Supplies comprehensive coverage on oil and gas specific American and European standards codes and recommended practices saving the engineer time searching for various publications      *Federal Register* ,1993-10      *The Unfired Pressure Vessel Code Simplified* Robert Chuse,1958      Frontiers in Materials Science B. Raj,2005 This volume presents contributions by a galaxy of eminent scientists and technologists from the world over in broad spectrum of areas in materials science providing a global perspective on complex issues of current concern and the direction of research in these areas      *Welding Journal* ,1989      *Specification for Drilling and Production Hoisting Equipment (PSL 1 and PSL 2)* American Petroleum Institute. Production Department,1992      *Welding Research Council Bulletin Series* Welding Research Council (U.S.),1996      **Specification for Drilling and Production Hoisting Equipment (PSL 1 and PSL 2)** American Petroleum Institute. Exploration and Production Department,1990      **Design, Construction, Operation, and Maintenance of Offshore Hydrocarbon Pipelines (Limit State Design)** ,1999      **Modern Welding Technology** Howard B. Cary,1998 Principles and practices of welding Provides more conceptual background than most texts      **Proceedings of the ... International Pump Users Symposium** ,1995      **Integrity of High-Temperature Welds** PEP (Professional Engineering Publishers),1998-03-13      **Welding Design & Fabrication** ,1985

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