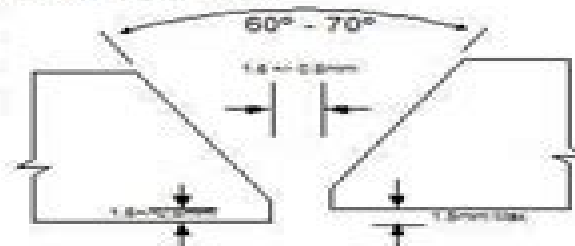


# Welding Procedure Specification

Client:	<b>Mobil</b>	Project:	<b>221010Goatee</b>	REF No.	<b>WPS 6 R1</b>
Procedure Description:	<b>12" Heavy Wall Offshore Tie-in</b>			<b>0290/L/WPS5</b>	
Material:	<b>AS3679.1 Grade 250 API 5L X65</b>	Diameter:	<b>168.3</b>	Thickness:	<b>18.3</b>
Position:	<b>6G</b>	Clamp Type:	<b>Internal</b>		
Preheat °C (Min):	<b>100</b>	Interpass °C (Max):	<b>300</b>		
Welding Process	<b>ROOT SMAW</b>	<b>HOT PASS SMAW</b>	<b>FILL &amp; CAP SMAW</b>		
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)
1	3.2mm	70-130	18-33	3.3-6.6	0.4-0.8
2	4.0mm	110-210	18-35	7.9-6.8	0.6-1.3
FILL	4.0mm	145-260	16-27	1.6-7.0	0.6-2.2
CAP	4.0mm	130-230	16-26	1.8-8.3	0.6-1.7

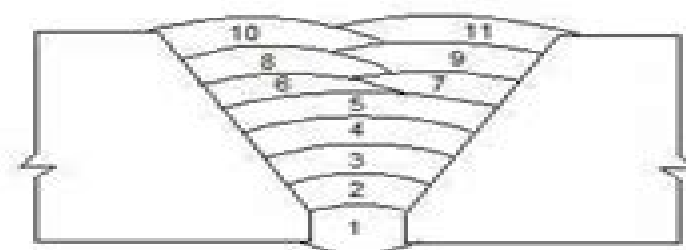
## Weld Preparation



## NOTES

- API Std 1104BP3094-SP-PL-3010R1
- 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.)
- Time lapse between root and second pass : 16 Minutes
- Time lapse between second pass and 1<sup>st</sup> fill : 12 Minutes
- Minimum number of passes before pipe movement : 2 passes
- Minimum number of passes before break in welding : 3 passes
- Minimum Number of welders- Root & second pass: 2 , Fill & Cap : 1
- Method of cleaning : Grinder / Wire brush
- Method of Preheat : Gas Torch
- Qualification reference number : 48280/PP/WP6 R1

## Pass Location



Company Welding  
Engineer Approved

Approved for Client

# Asme Weld Repair Procedure

**Michael Seilmaier**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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