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DEPARTMENT

WELDING PROCEDURE SPECIFICATION (WPS)

ACCORDING TO API 1104

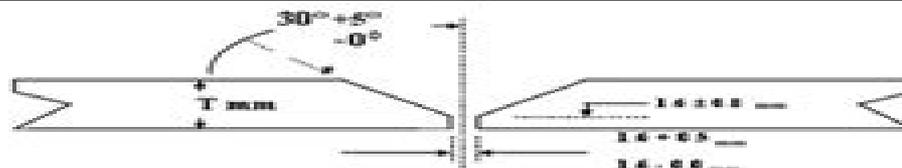
Date : 16/10/2016

WPS No. : P01

Sheet : 1 of 1

COMPANY NAME	: GASCO
PROJECT NAME	: Dabshor-Bany Swief 36" pipeline
WELDING PROCEDURE SPECIFICATION No.	: P01 Main Pipeline
REVISION NO.	: 0
SUPPORTING PQR NO.	: PQR (PL-02/2010)
TYPES (Manual, Automatic, Semi Auto.)	: MANUAL (SMAW)

JOINTS DESIGN



BASE METAL

Material Spec.	: API-5L
Type or Grade	: X-65
P No.	: 01
A No.	: 01
Thickness	: 4.8 ≤ T ≤ 19.05 mm
Diameter	: 36"
Other	

FILLER METALS

Weld Metal Analysis A No.	: A1
Size of Electrode	: 3.25, 4.0 & 5.0 mm
Filler Metal No.	: F3
SFA Specification	: A 5.1 & A 5.5
AWS Classification	: E 6010 & E 80100

POSITION

Position of Groove	: 5G
Direction of welding	: All Down-Hill
Other	

PREHEAT

Preheat Temp. (°C) (Min)	: 30°C (if needed)
Interpass Temp. (°C) (Max)	: 250 °C Max
Other	: N.A.

POSTWELD HEAT TREATMENT

Temperature Range	: N.A.
Time Range	: N.A.
Other	: N.A.

GAS

Type of Gases	: N.A.
Composition of Gas Mixture	: N.A.
Other	: N.A.

ELECTRICAL CHARACTERISTICS

Current	: DC
Polarity	: -ve & +ve

WELD LAYERS	FILLER METAL		CURRENT		VOLTAGE RANGE
	Class	Stem (mm)	Polar.	Amp. range	
1 st	E6010	3.25	-ve	80-110	20-22
2 nd	E80100	4.00	+ve	120-180	20-27
3 rd	E80100	4.00	+ve	120-180	20-27
4 th	E80100	5.00	+ve	120-180	20-27
CAP	E80100	3.00	+ve	120-180	20-27

TECHNIQUE

Interpass Cleaning	: Root Grinding & Wire Brush
String or Weave Bead	: Both
Orifice or Gas Cup Size	: N.A.
Multi pass or Single Pass	: Multi-passes
Single or Multiple Electrodes	: Single
LINE UP CLAMP	: Remove Internal Clamp after 100% of the Root Pass
Maximum time between 1 st and 2 nd pass (5 minutes)	
Maximum time between 2 nd pass and others	: Shortly

JOB TITLE	PROJECT QA / QC	Chief QA / QC
NAME	AMMED SHAWKY	ABD-ELFATTAH ABU ALI
DATE	16/10/2016	16/10/2016
SIGN		

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Arc Welding Qualification Standards Darren Barborak, 2024-08-19 This textbook introduces the reader to the development and qualification of arc welding procedures and personnel to industry codes and standards. The mechanics of using welding standards, how to address their requirements, and their relationship with other standards are explained. The reader will gain a working knowledge of common welding standards, including a review of welding processes, variables, the inspection and testing of welds, and their acceptance criteria. The reader will develop a basic understanding of Common arc welding standards, Welding related documentation, The welding procedure development qualification process, Essential non essential supplementary essential variables for arc welding processes, The requirements for the inspection testing of weld qualification coupons, Purpose intent compliance of a Welding Procedure Specifications WPS, Purpose intent compliance of a Procedure Qualification Records PQR, The welder operator performance qualification process, Purpose intent compliance of a Welder Performance Qualification Record WPQR. This textbook was written for use in an undergraduate course in Welding Engineering. Although the book is aimed at Welding Engineering students, it should also serve as a useful guide to other engineers, technicians, and specialists who are working in the field of welding and are seeking how to apply relevant codes and standards to qualify welding procedures and personnel. While the book focused primarily on the common arc welding processes using AWS B2.1 and ASME BPVC Section IX, the principles discussed will apply to most welding processes in general and most welding qualification standards.

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mechanical damage fracture and corrosion protection inspection and monitoring pipeline cleaning direct assessment repair risk management and abandonment Links modern and vintage practices to help integrity engineers better understand their system and apply up to date technology to older infrastructure Includes case histories with examples of solutions to complex problems related to pipeline integrity Includes chapters on stress based and strain based design the latter being a novel type of design that has only recently been investigated by designer firms and regulators Provides information to help those who are responsible to establish procedures for ensuring pipeline integrity and safety *Federal Register* ,1986-06-04 **How to Prepare Welding Procedures for Oil & Gas Pipelines** Mohamed Ahmed Elsayed P E,2024-04-17 The latest edition of API 1104 22nd edition has major changes in its structure and has included the requirements of Standard WPS qualification and hardness toughness WPS qualification for first time which you will learn in details in this book This book results from many years spent in the fabricating and construction of products under the guidance and regulation of API 1104 standard both national and international that are used to help make pipeline systems safer In this book you will learn How to prepare and fill WPS matrix Essential non essential variables for Manual and semi automatic welding processes How to prepare Preliminary Welding Procedure Specification pWPS How to prepare Procedure Qualification Record PQR and applicable mechanical tests Tensile test Nick break test and Bend test How to prepare Welding Procedure Specification WPS So if you re looking to take your Welding Procedure preparation skills to the next level by incorporating the more technical aspects of your profession then this is the book for you **"Code of Massachusetts regulations, 2006"** ,2006 Archival snapshot of entire looseleaf Code of Massachusetts Regulations held by the Social Law Library of Massachusetts as of January 2020

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