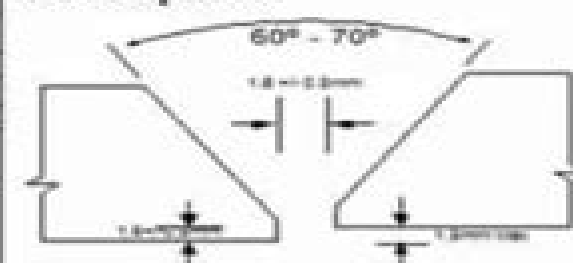


Welding Procedure Specification

Client:	Mobil	Project:	221010Goatee	REF No.	WPS 6 R1	
Procedure Description:		12" Heavy Wall Offshore Tie-in			0290/1/WPS5	
Material:	AS3679.1 Grade 250 API 5L X65		Diameter:	168.3	Thickness:	18.3
Position:	6G		Clamp Type:	Internal		
Preheat °C (Min):	100		Interpass °C (Max):	300		
Welding Process		ROOT SMAW		HOT PASS SMAW		FILL & CAP SMAW
Welding Direction		Vertical Down		Vertical Down		Vertical Down
Filler		Lincoln SA70+		Lincoln SA70+		Böhler 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	2.9-6.3	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	1.8-6.3	0.6-1.7

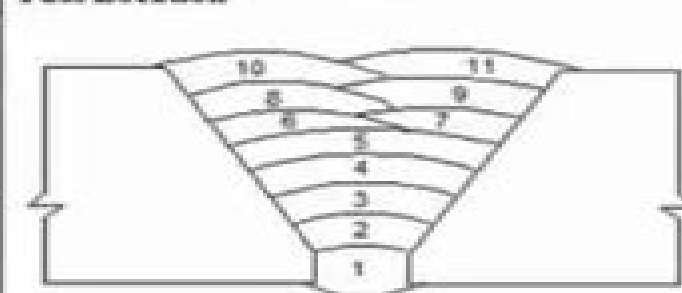
Weld Preparation



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 1st 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 : 48250/PP/WP6 R1

Pass Location



**Company Welding
Engineer Approved**

Approved for Client

Welding Procedure Specification Guide

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1. Understanding the eBook Welding Procedure Specification Guide
 - The Rise of Digital Reading Welding Procedure Specification Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Welding Procedure Specification Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Welding Procedure Specification Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Welding Procedure Specification Guide
 - Personalized Recommendations
 - Welding Procedure Specification Guide User Reviews and Ratings
 - Welding Procedure Specification Guide and Bestseller Lists
5. Accessing Welding Procedure Specification Guide Free and Paid eBooks

- Welding Procedure Specification Guide Public Domain eBooks
- Welding Procedure Specification Guide eBook Subscription Services
- Welding Procedure Specification Guide Budget-Friendly Options
- 6. Navigating Welding Procedure Specification Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Welding Procedure Specification Guide Compatibility with Devices
 - Welding Procedure Specification Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Welding Procedure Specification Guide
 - Highlighting and Note-Taking Welding Procedure Specification Guide
 - Interactive Elements Welding Procedure Specification Guide
- 8. Staying Engaged with Welding Procedure Specification Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Welding Procedure Specification Guide
- 9. Balancing eBooks and Physical Books Welding Procedure Specification Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Welding Procedure Specification Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Welding Procedure Specification Guide
 - Setting Reading Goals Welding Procedure Specification Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Welding Procedure Specification Guide
 - Fact-Checking eBook Content of Welding Procedure Specification Guide
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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