

	MAG (135) Butt weld-multi pass (p)Welding Procedure Specification (EN15614-Pt1:2004+A2:2012)	
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Manufacturers Name:			Procedure: (p)WPS-SDBMP 1	
Welders Name		Date of Birth: 29/01/1981	Date:	
Joint Type:	T- joint (Fillet weld)		Weld piece preparation: All test piece material to be clean and free from: Grease; scale; rust; paint etc	
Material:	Plate: S355 Carbon steel Shaft: 41CrM04			
Position	PB	Welding Position	Horizontal - Vertical	
Preheat °C (Min)	250	Welding Process	Metal Active Gas (MAG) 135	
Filler material	EN ISO 14341-A, G42, 3Ci, 3Si1		Polarity	DC +ve
Shielding Gas	Argoshield Universal		Shielding Gas Flow Rate	14 – 18 l / min

<p>Test Piece Dimensions: millimetres</p> <p>150mm</p> <p>100mm</p> <p>150mm</p> <p>150mm</p> <p>100mm</p> <p>40 °</p> <p>8mm</p> <p>10mm</p>	<p>Welding Sequence</p>
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Run	Process	Size of Filler Metal Ø mm	Current A	Voltage V	Type of Current / Polarity	Wire feed speed m/min	Travel speed mm/min	Heat Input kJ/mm	Transfer Mode
1	135 (MAG)	1.0	280-290	29-30	DC +ve	10 – 11	300 – 320		All Spray
2			280-290	29-30		10 – 11	460 – 480		

Other Information:	Testing
<ol style="list-style-type: none"> 1. Test piece to be machine prepped to ensure Joint fit-up is tight with no gaps 2. Interpass temperature 250°C max 3. Weld finish to be left as welded 4. Completed Test Piece to be stamped with welders name or Company I.D 5. Test piece to be submitted for testing as per BS EN 15614-Pt1:2004+A2:2012requirements 6. Preheat to be checked with tempilstik or IR meter 7. Cooldown controlled to 50°/hr 	<p>Test piece submitted to UKAS Centre Intertek and tested as per BS EN 15614-Pt1:2004+A2:2012requirements</p> <p>MPI Test –</p> <p>Macro 1 –</p> <p>Macro 2 –</p> <p>Hardness Survey EN ISO 6507-1:2005 –</p> <p>See attached Intertek Report Ref No: Dated:</p> <p>Signed.....</p>