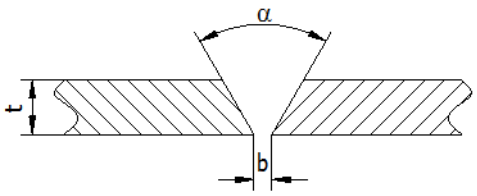
	WPS	WPS no	Rev.
		(p)WPS-PT1	
		Page 1 of 1	

Location:		Examiner or test centre:	
WPQR No.:		Method of preparation and cleaning:	Grinding
Welder qualification:	EN 287-1	Processing the root weld:	Brushing
Welding process:	135-(MAG)	Parent material specification:	Group no ISO 15608:
Joint type:	Butt weld	Group 1 (BS EN 10025-2: Sub Group 1.2; S355:JO	
Customer:		Group 1 (BS EN 10025-2: Sub Group 1.2; S355:JO	
Order no.:		Material thickness:	10 mm
Drawing no.:		Outside diameter:	0 mm
Part no.:		Welding position:	PA

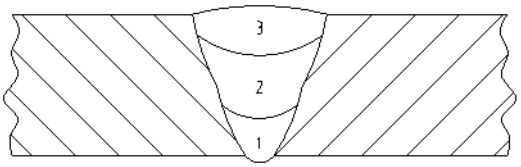
Dimensions:

a =70°
u = 2 mm
b =0 mm
t = 15 mm
Ø =0

Joint design



Welding sequence



Remark:
Flat grinding cover layer after welding

Welding details

	Welding pass	Process	Ø weld filler	Current	Voltage	Current / Polarity	Wire feed rate	Travel speed	Heat input
A	Root pass	135	1 mm	270-280 A	29-30 V	= / +	15-16 m/min	29-30 cm/min	1.253 - 1.39 kJ/mm
B	Filler + cover pass	135	1 mm	270-280 A	29-30 V	= / +	15-16 m/min	29-30 cm/min	1.253 - 1.39 kJ/mm

Welding filler / welding flux — Special regulations for drying

	Designation	Brand name	Manufacturer	Time	Temperature
A	G3Si1	OK AUTOROD	ESAB		
B	G3Si1	OK AUTOROD	ESAB		

Shielding gas

	Type	Brand name	Manufacturer	Volume	Pre-purge time	Post-purge time
A	Shielding: I1-Ar	ARGOSHIELD	BOC	10-12 l/min	1 s	4 s
B	Shielding: I1	ARGOSHIELD	BOC	10-12 l/min	1 s	4 s

Further information

	Parameter	Value
A	Nozzle /gas cup size	16
A	Material transfer	Spray
A	Distance contact tube/work piece	12-15 mm
B	Nozzle /gas cup size	16
B	Material transfer	Spray
B	Distance contact tube/work piece	12-15 mm

Weld bead form	String bead
Preheat temperature:	N/A
Interpass temperature:	N/A

Date, prepared:	Date, checked:	Date, released:
P. Teggart		
Signature	Signature	Signature