



BV Rules on Material and Welding for the
Classification of Marine Units,
NR216, Ch 5, Sec 4,
Approval of Welding Procedures

WPS

WPS No: 4

Date of Issue: 31.12.2018

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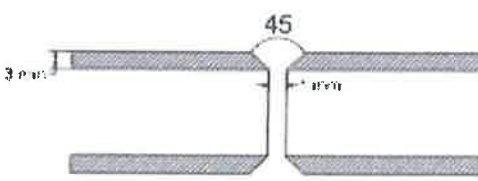
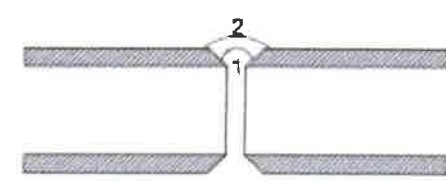
WELDING PROCEDURE SPECIFICATION

WPQR No : 4
Method of preparation : CNC
Cleaning : Grinding, Brushing
Joint Type : Butt Joint
Parent Material Spec. : Stainless Steel
One side welding

Parent Material Grade : ER316L
Range of Material thickness : 1,93-5,54mm
Range of Outside diameter : >=30,15 mm
Range of Welding Position : HL045

Part 1 : ER316L
Part 2 : ER316L
1,93-5,54 mm

Weld Preparation Details

Joint design	Welding sequences
	

Welding Details

Run number	1	2					
Welding process	TIG (141)	TIG (141)					
Autom. Welding .nr. of heads							
.weaving							
Filler metal:wire (W) or electrode (E)	W	W					
.Designation	ESAB	ESAB					
.Grade	ER316L	ER316L					
.Description	AWS A5.9	AWS A5.9					
.Diameter	2,4 mm	2,4 mm					
Shielding:Flux (F) or gas (G)	G	G					
.Power flux .description							
.type and trade name							
.Gas flux .description	%100 Argon	%100 Argon					
.type and trade name	Linde	Linde					
.Backing .flow rate (l/mn)	Argon	Argon					
.Shielding .flow rate (l/mn)							
.Plasma							
Tungsten electrode: type/size							
Type of current	DC	DC					
Electrode or wire polarity	(-)	(-)					
Current (A)	67	71					
Voltage (V)	19	19					
Travel speed S (cm/min)	13	6					
Wire feed speed (cm/min)							
Heat input (J/cm) = [k x V x A x 60] / S	3525	8094					
Interpass temperature in °C (min/max)	Min 150°C / Max 250°C						
Welding equipment / Trade mark-type	KOLARC T 270 DC						

Pre heat :NO
Post heating :NO
Post weld heat treatment :NO

Temperature°C.....
Temperature°C.....

Holding Time.....
Holding Time.....

Prepared by Firm Representative

Name: ÖMER DEMİR

Signature:

Stamp

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