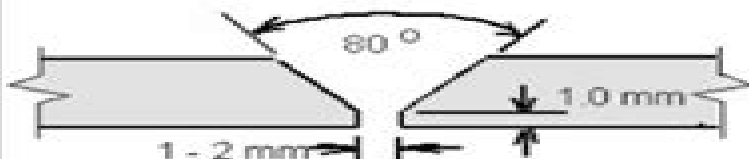



## Welding Procedure Specification:- Example

<b>Weld Procedure Number</b>		30 P1 TIG 01 Issue A	
<b>Qualifying Welding Procedure (WPAR)</b>		WP T17/A	
<b>Manufacturer:</b>	National Fabs Ltd 25 Lane End Birkenshaw Leeds	<b>Method Of Preparation and Cleaning:</b>	Machine and Degrease
<b>Location:</b>	Workshop	<b>Parent Metal Specification:</b>	Grade 304L Stainless Steel
<b>Welding Process:</b>	Manual TIG	<b>Parent Metal Thickness:</b>	3 to 8mm Wall
<b>Joint Type:</b>	Single Sided Butt Weld	<b>Pipe Outside Diameter:</b>	25 to 100mm
		<b>Welding Position:</b>	All Positions
		<b>Welding Progression:</b>	Upwards

<b>Joint Design</b>	<b>Welding Sequences</b>
	

Run	Process	Size Of Filler Metal	Current A	Voltage V	Type Of Current/Polarity	Wire Feed Speed	Travel Speed	Heat Input
1 2 And Subs	TIG TIG	1.2mm 1.6mm	70 - 90 80 - 140	N/A	DC- DC-	N/A	N/A	N/A

<b>Welding Consumables:-</b> Type, Designation Trade Name: Any Special Baking or Drying:	BS 2901 Part 2 : 308S92 No	<b>Production Sequence</b>
Gas Flux:	Argon 99.99% Purity	1. Clean weld and 25mm borders to bright metal using approved solvent.
Gas Flow Rate - Shield:	8 - 12 LPM	2. Position items to be welded ensuring good fit up and apply
- Backing:	5 LPM	

# **Welding Types And Specification Manual**

**Kathleen Armour**



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