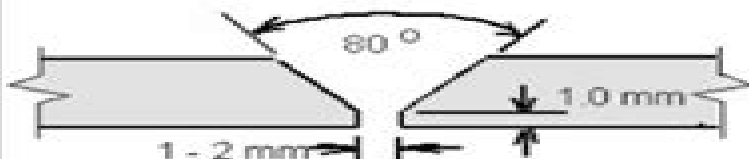



Welding Procedure Specification:- Example

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

Joint Design	Welding Sequences
	

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

Welding Consumables:- Type, Designation Trade Name: Any Special Baking or Drying:	BS 2901 Part 2 : 308S92 No	Production Sequence
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	

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