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| **WELDING PROCEDURE SPECIFICATION (PWS)** |
| COMPANY NAME: MODERN CONTINENTS CONST.EST |
| **WPS #** | WPS/EL/021 Rev: 01 | **SUPPORTING PQR#** | MCC-PQR-021 |  |
| **Welding Process** | SMAW | **TYPE** | MANUAL |  |
| **Cognizant Code**  | AWAS D1.1 | **DATE** | 03-OCT-2017 |  |
| Backing | N/A |  |
| Root Gap | N/A |
| Bevel Angle | N/A |
| Root Face | N/A |
| Thickness | 10mm |
| Retainers | None |
| **BASE MATEL** |
| Group No: 1 To Group No: 1 & 2Space Type & Grade: A36 To Space Type & Grade: A53,A106,A272,Gr 50 or Equivalent AWS Group # 1 Plate or Pipe: PlateThickness Range: Fillet 3mm to 20mm Grove: N/A |
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| **FILLER METAL** | **ROOT & GAP** | **POSITIONS** | **POST WELD HEAT TREATMENT** |
| Space No (SFA) | 5.1 | Position(s) of Groove | 3F | Temperature Range  | NO PWHT |
| AWS No (Class) | E-7018 | Welding progression | UPHILL | Time Range | N/A |
| F No | 4 | Other | N/A | Other | Nil  |
| A NO | 1 | **Deposited Weld Metal Thickness Range** | **PREHEAT** |
| Size of Filler Metal | 2.5, 3.2 & 4.0 | Groove | N/A | Method | N/A |
| Electrode Trade Name | ESAB | Electrode-Flux (Class)  | N/A | Temperature  | Ambient |
| Welding Material Thickness | 10mm | Flux or Electrode Trade Name  | N/A | Interpass Temperature | 250 Deg C |
| Consumable Insert | N/A | Consumable Insert | N/A | Other | Nil |
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