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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 & 2  Space Type & Grade: A36 To Space Type & Grade: A53,A106,A272,Gr 50 or Equivalent  AWS Group # 1  Plate or Pipe: Plate  Thickness Range: Fillet 3mm to 20mm Grove: N/A | | | | | |
| |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | | **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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