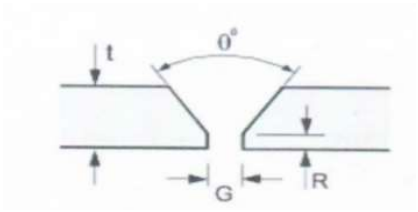
Eco Turnkey Solution Pvt. Ltd

WELDING PROCEDURE SPECIFICATION

Company Name	M/s Eco Turnkey solution Pvt Ltd	**PQR No.**	ETSPL/ /PQR/2022/04
Welder Process	GMAW	**Date & Revision**	01-10-2022
Supporting WPS no.	ETSPL/ /PQR/2022/0	**Authorised by**	Mr.Pardeep bagri
Date & Revision	01-10-2022	**Type**	Semi Automatic

JOINT DESIGN USED

Joint Design	Single V Butt Joint Groove Weld
Backing	NA
Backing Material	NA
Root Gap(A)	0-3 mm
Root Face(B)	0-2mm
Groove Angle(C.)	60-70 deg.
Back Gouging	NA
Method of Back Gouging	NA



BASE MATERIAL		**FILLER MATERIAL**	
Material Specification	IS2062	**AWS Specification**	SFA 5.18
Type or grade	E 350 BR	**AWS Classification**	ER-70S-6
Thickness of Groove(t)	10 mm	**F Number**	6
Thickness of fillet	NA	**A Number**	1
Pipe diameter	NA	**Size of Filler Metal**	1.20mm
Maximum Pass Thickness	Less than 13 mm	**Filler Metal Form**	bare
POSITION		**Electrode Trade Name**	Maruti
Position of Groove	3G	**Consumble Insert**	NA
Position of Fillet	NA	**Flux type**	NA
Welding Progression	Forward		
POST WELD HEAT TREATMENT		**PREHEAT**	
Temperature Range	NA	**Preheat Temperature**	>20 C
Time range	NA	**Interpass Temperature**	105 C-175 C
Other	NA	**Other**	NA
ELECTRICAL CHARACTERSTICS		**SHIELDING (GAS)**	
Mode of Metal Transfer	NA	**Shielding Gas(es)**	Co2
Current Type	DC	**Mixture(%)**	99.90%
Polarity	DCEP	**Flow Rate**	12-20 LPM
Tungsten Electrode Size	NA	**Backing**	NA
Currenr Range	See Table	**Other**	NA
Voltage Range	See Table	**Trailing**	NA
TECHNIQUE			
String or Weave Bead	All	**Multiple or Single Pass**	Multiple
Initial or Interpass Cleaning	Brushing,grinding	**Multiple or Single Electrode**	Single(Wire)
Method of Gouging	NA	**Wire Feed Speed**	NA
Oscillation	NA	**Travel Speed**	See Table
Other	NA	**Peening**	Not allowed

WELDING PROCEDURE

Pass or Weld Layer(s)	**Process**	**Filler Metals**		**Current**		**Volts**	**Travel speed**
		Class	**Dia(mm)**	**Type & polarity**	**Value(Amp.)**		
1	GMAW	ER 70S-6	1.20 mm	DCEP	120-250	20-24	100-180

Prepared by	Reviewed by	Approved by.