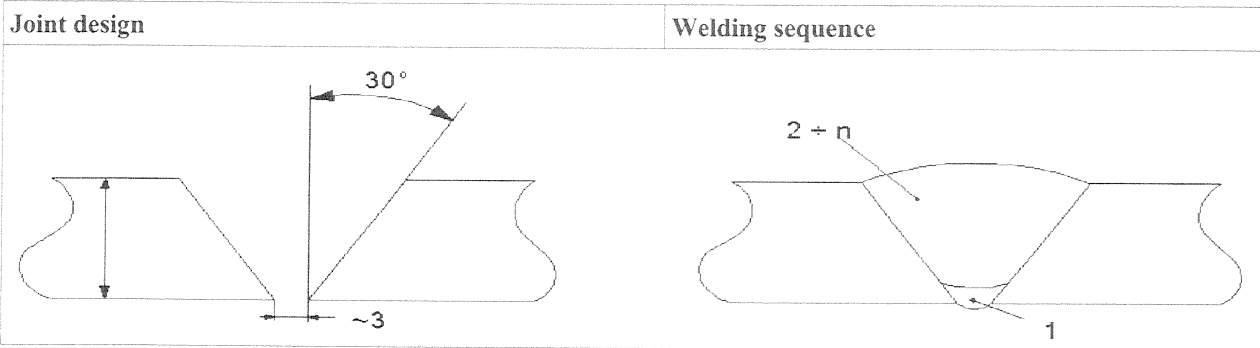


## WELDING PROCEDURE SPECIFICATION, EN - ISO 15614

<b>WPS nr</b>	<b>051009/05</b>	<b>Parent Material Specification</b>	
WPQR No	RET0222273/75	EN 10088-1 table 3	Group 8.2, X1NiCrMoCu25-20-5
Manufacturer	RVI Mosman .BV	EN 10088-1 table 3	Group 8.2, X1NiCrMoCu25-20-5
Welder	M.M.J. Tijans	Dimensions:	
Welder's date of birth	07-07-78	Material thickness t	5.49 mm
Welding process	141, 135	Root S1	0 mm
Joint type	BW - but weld in plates or pipes	Filling S2	mm
Welding position	PA	Outside diameter	88.9 mm
Single/double side	ss nb - single-side, no backing		

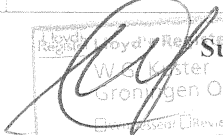
<b>Methode of preparation and cleaning</b>		<b>Auxillary materials if required</b>	
Weldpreparation	V groove	Gas/Flux:	Argon I 1
Method of cleaning	Grinding	Shielding	Formeer 10 F2
Back gauging		Backing	Argon M21
			Formeer 10



<b>Welding details</b>									
Welding sequence	Process	Size of filler metal	Current A	Voltage V	Type of current	Polarity	Travel speed	Heat input	Metal transfer
1	141	2	70-80	13-15	=	-	0.7	0.78 - 1.0	NA
2÷*n	135	1.2	120-130	22-23	=	+	4.3	0.52 - 0.5	Puls

<b>Filler metal: Mark, Class</b>		<b>Other information if required</b>	
904L Avesta	AWS A5.9	Heat treatment:	
Tungsten electrode:		Preheat temp.	10 ° C
Type and size	1,5% Lanthaan 2.4mm	Interpass temp.	150 ° C
Any special backing or drying	Na	Heat treatment	Na
		Time temp. method	Direkt
		Heating, cooling; rates	Na

Enschede, 22-10-2009

  
**Supervisor:**  
 W. P. Koster  
 Groningen Office  

 Rev. 1  
 Rev. 2  
 Rev. 3  
 Rev. 4  
 Rev. 5  
 Rev. 6  
 Rev. 7  
 Rev. 8  
 Rev. 9  
 Rev. 10