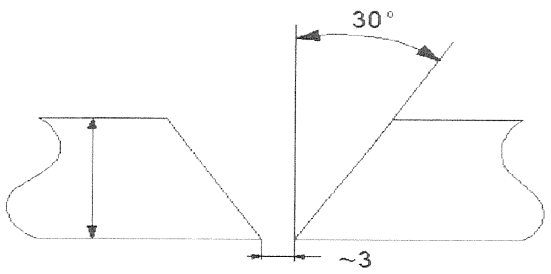
MOSMAN
ROESTVASTSTAALINDUSTRIE

WELDING PROCEDURE SPECIFICATION, EN - ISO 15614

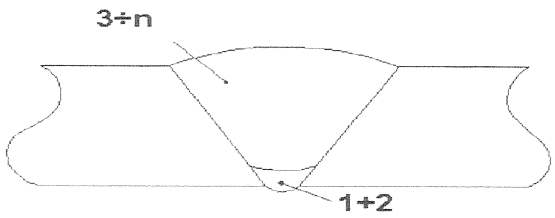
WPS nr	**051009/04**	**Parent Material Specification**	
WPQR No	RET0222273/75	EN 10088-1 table 3	Group 8.2, X1NiCrMoCu25-20-5
Manufacturer	RVI Mosman .BV	EN 10088-1 table 3	Group 8.2, X1NiCrMoCu25-20-5
Welder	M.M.J. Tijans	Dimensions:	
Welder's date of birth	07-07-78	Material thickness t	15 mm
Welding process	141, 135	Root S1	0 mm
Joint type	BW - but weld in plates or pipes	Filling S2	mm
Welding position	PA		
Single/double side	ss nb - single-side, no backing	Outside diameter	-

Methode of preparation and cleaning		**Auxillary materials if required**	
Weldpreparation	V groove	Gas/Flux:	
Method of cleaning	Grinding	Shielding	Argon I 1 Formeer 10 F2
Back gauging		Backing	Argon M 21

Joint design



Welding sequence



Welding details

Welding sequence	Process	Size of filler metal	Current A	Voltage V	Type of current	Pola-rity	Travel speed	Heat input	Metal transfer
1-2	141	2	75-85	14-16	=	-	0.8	0.78 - 1.0	NA
3÷*n	135	1.2	180-200	25-28	=	+	6.8	0.52 - 0.6	Puls

Filler metal: Mark, Class		**Other information if required**	
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: