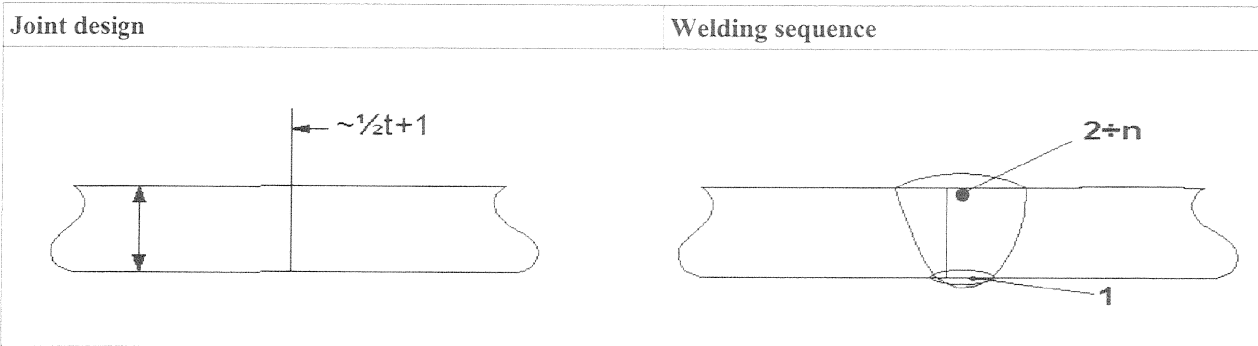


### WELDING PROCEDURE SPECIFICATION, EN - ISO 15614

<b>WPS nr</b>	<b>051009/03</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	1.5 mm
Welding process	141	Root S1	-
Joint type	BW - but weld in plates or pipes	Filling S2	-
Welding position	PA		
Single/double side	ss nb - single-side, no backing	Outside diameter	18 mm

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



<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	1.2	45-55	13-15	=	-	0.8	0.43 - 0.6	Na
2+*n	141	1.2	45-55	13-15	=	-	0.8	0.43 - 0.6	Na

<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

Register Nederland B.V.
   
 Supervisor:
   
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