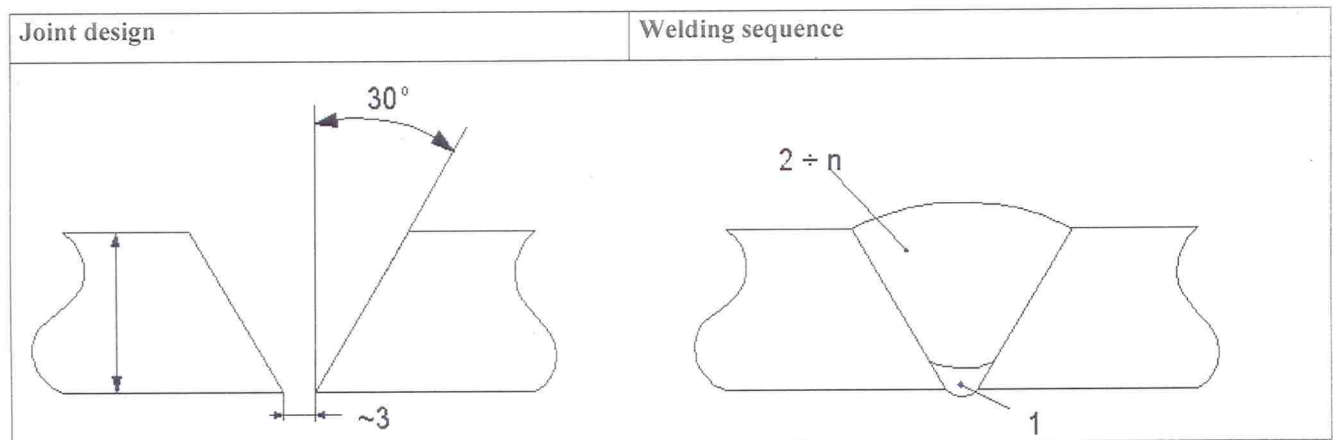


WELDING PROCEDURE SPECIFICATION, EN – ISO 15614-1

WPS nr:	260608/1	Parent Material Specification	
PQR nr	RET0222273/4/2	EN 10088-1 table 3	Group 8.1 X2CrNiN18-10
Manufacturer	RVI Mosman BV	EN 10222-5	Group 8.1 X2CrNiMo17-12-2
Welder	M Tijans	Dimensions	
Welding process	141	Material thickness	3.0 mm
Joint type	BW butt weld in plates or pipes	Root S1	-
Weld position	H-L045	Filling S2	-
Single/double side	ss nb – single side, no backing	Outside diameter	60.3 mm

Method of preparation and cleaning		Auxiliary materials if required	
Weld preparation	V-groove	Gas-shielding 1	Argon 99.995% (i-1)
Method of cleaning	Grinding	Gas-shielding 2	
Back gauging	-	Backing gas	Formeer 5/10 (f-2)
		Flux shielding	
		Other kinds	



Welding details							
Welding sequence	Process	Size of filler metal	Current	Voltage	Type of current polarity	Travel speed Cm / min	Heat input
1÷*n	141	2	60	14	= / -	3	0.16kj/mm

Filler metal		Other information if required	
Mark	LNT304LSi	Stick out length	SS
Class	AWS A5.9-93 ER308LSi	Pulse welding details	
Type (1) (2)	Lincoln G-W19.9LSi	Maximal osc. width	
Any spec. backing	-	Oscillation (frequency)	
Special drying	-	Torch angle	
Heat treatment		Single / double side	
Preheat temp.	10°C	Plasma welding details	
Interpass temp.	150°C	Tungsten electrode	
Heat treatment	none	Type and size	1.5% Lanthane 2.4 mm
Name / Date		Hengelo	
R P Deen (IWS)		July 10, 2008	

Lloyd's Register
 Lloyd's Register Nederland B.V.
 A. Compagne
 Groningen Office
 Witnessed Reviewed Examined

16-08-2012