

Weld Procedure Specification (WPS)

WPS No.	Procach_001_FW	Method of preparation and cleaning	Flame cutting and grinding
WPS Rev.	PL 001-001	Parent metal designation	BS EN 10025-2 - S275JR-A4
Manufacturer	Procach Industrial Limited	Material thickness	12mm
Joint Type	Fillet weld	Outside diameter	N/A
Weld type	Multi-run	Welding position	FB

Joint design	Welding sequence
Thickness range t1 = 12mm t2 = 12mm 	Indicative number of runs 

No.	Process	Size of filler material	Current (A)	Voltage (V)	Type of current / Polarity	Wire feed speed	Travel speed (mm/s)	Heat input (kJ/mm)
1	100 (MAG)	1.0mm	250	28	DC - rev	8.5mm/min	5.8mm/sec	0.87
2 - 6	100 (MAG)	1.0mm	250	28	DC - rev	8.5mm/min	6.2mm/sec	0.95

Filler make	Lincoln Electric - Supramag ultra	Filler designation	BS EN ISO 14343 A, G 50 S M21, R51
Backing/Backing	As per manufacturer's recommendations		
Gas designation - shield	EN ISO 14175 M24	Gas brand - Shield	Argonshield Ar 80%, CO ₂ , 12%, CO ₂ 2% - EN ISO 14175 M24
Gas flow rate - shield	15 - 20 L/min	Gas flow rate - backing	N/A
Tungsten electrode - type	N/A	Tungsten electrode - size	N/A
Back gouging / backing	N/A	Mode of transfer	Spray
Preheat temperature	5°C	Interpass temperature	120°C, maximum / 170°C, max allowable
Min pre heat maintenance	5°C	Post heating	N/A
Stick out	30-45mm		
Notes			

* Includes thermal efficiency factor to EN 10012-2

Manufacturer	Welding Coordination	
Name Signature Date		