



BV Rules on Material and Welding for the
Classification of Marine Units,
NR216, Ch 5, Sec 4,
Approval of Welding Procedures

WPS No: 2

Date of Issue: 31.12.2018

WPS

Page 1/1

WELDING PROCEDURE SPECIFICATION

| | | | | | |
|-----------------------|----------------------|-----------------------------|--------------|--------|------------|
| WPQR No | : 2 | Parent Material Grade | : GR-B | Part 1 | Part 2 |
| Method of preparation | : CNC | Range of Material thickness | : 3-11,08 mm | GR-B | GR-B |
| Cleaning | : Grinding, Brushing | Range of Outside diameter | : >=30,15 mm | | 3-11,08 mm |
| Joint Type | : Butt Joint | Range of Welding Position | : HL045 | | |
| Parent Material Spec. | : Carbon Steel | | | | |
| One side welding | | | | | |

Weld Preparation Details

| Joint design | Welding sequences |
|--------------|-------------------|
| | |

Welding Details

| Run number | 1 | 2 | | | | | | | |
|--|-----------------------|------------|--|--|--|--|--|--|--|
| Welding process | TIG (141) | TIG (141) | | | | | | | |
| Autom. Welding | | | | | | | | | |
| nr. of heads | | | | | | | | | |
| weaving | | | | | | | | | |
| Filler metal: wire (W) or electrode (E) | W | W | | | | | | | |
| Designation | GEKA SG2 | GEKA SG2 | | | | | | | |
| Grade | 4YM | 4YM | | | | | | | |
| Description | AWS A5.18 | AWS A5.18 | | | | | | | |
| Diameter | 2,4 mm | 2,4 mm | | | | | | | |
| Shielding: Flux (F) or gas (G) | G | G | | | | | | | |
| Power flux | | | | | | | | | |
| description | | | | | | | | | |
| type and trade name | | | | | | | | | |
| Gas flux | | | | | | | | | |
| description | %100 Argon | %100 Argon | | | | | | | |
| type and trade name | Linde | Linde | | | | | | | |
| Backing | | | | | | | | | |
| flow rate (l/mn) | | | | | | | | | |
| Shielding | | | | | | | | | |
| flow rate (l/mn) | | | | | | | | | |
| Plasma | | | | | | | | | |
| Tungsten electrode: type/size | | | | | | | | | |
| Type of current | DC | DC | | | | | | | |
| Electrode or wire polarity | (-) | (-) | | | | | | | |
| Current (A) | 107 | 126 | | | | | | | |
| Voltage (V) | 19 | 19 | | | | | | | |
| Travel speed S (cm/min) | 8 | 6 | | | | | | | |
| Wire feed speed (cm/min) | | | | | | | | | |
| Heat input (J/cm) = [k x V x A x 60] / S | 9149 | 14364 | | | | | | | |
| Interpass temperature in °C (min/max) | Min 150°C / Max 250°C | | | | | | | | |
| Welding equipment / Trade mark-type | KOLARC T 270 DC | | | | | | | | |

Pre heat :YES
Post heating :NO
Post weld heat treatment :NO

Temperature°C. 20 – 30 °C
Temperature°C.....
Temperature°C.....

Holding Time.....
Holding Time.....

Prepared by Firm Representative

Name: ÖMER DEMİR
Signature:
Stamp

BTM BORU
ENDÜSTRİYEL DENİZ ÜRÜNLERİ
Paz.İth.İhr. San. ve Tic. Ltd. Şti
Hersek Mah. Ahmetpaşa Cad. No:14/7/2
Altınova, YALOVA
Mersis. 0187 1176 4360 0001
Altınova Mal Müd. 187 117 64 36

Endorsed by BV Surveyor

Name: HAKAN TIRYAKI
Signature:
BV Stamp

