



BTMboru
PIPE & FITTINGS

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

WPS

WPS No: 3

Date of Issue: 31.12.2018

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WELDING PROCEDURE SPECIFICATION

WPQR No	: 3	Parent Material Grade	: GR-B	Part 1	Part 2
Method of preparation	: CNC	Range of Material thickness	: 3-7,46 mm	3-7,46 mm	GR-B
Cleaning	: Grinding, Brushing	Range of Outside diameter	: 10,65 mm – 42,6 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	1,6 mm	1,6 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)	61	71							
Voltage (V)	19	19							
Travel speed S (cm/min)	6	5							
Wire feed speed (cm/min)									
Heat input (J/cm) = [k x V x A x 60] / S	6954	9713							
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

Endorsed by BV Surveyor

Name: ÖMER DEMİR

Signature:

Stamp

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