



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: 5

Date of Issue: 31.12.2018

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WELDING PROCEDURE SPECIFICATION

WPQR No	: 5	Parent Material Grade	: ER316L	Part 1	Part 2
Method of preparation	: CNC	Range of Material thickness	: 1,4-2,2 mm		ER316L
Cleaning	: Grinding, Brushing	Range of Outside diameter	: 10,6 mm – 42,6 mm		
Joint Type	: Butt Joint	Range of Welding Position	: HL045		
Parent Material Spec.	: Stainless Steel				
One side welding					

Weld Preparation Details

Joint design	Welding sequences

Welding Details

Run number	1								
Welding process	TIG (141)								
Autom. Welding	.nr. of heads								
	.weaving								
Filler metal: wire (W) or electrode (E)	W								
.Designation	ESAB								
.Grade	ER316L								
.Description	AWS A5.9								
.Diameter	2,4 mm								
Shielding: Flux (F) or gas (G)	G								
.Power flux	.description								
	.type and trade name								
.Gas flux	.description	%100 Argon							
	.type and trade name	Linde							
.Backing	.flow rate (l/mn)	Argon							
.Shielding	.flow rate (l/mn)								
.Plasma									
Tungsten electrode: type/size									
Type of current	DC								
Electrode or wire polarity	(-)								
Current (A)	59								
Voltage (V)	19								
Travel speed S (cm/min)	9								
Wire feed speed (cm/min)	4484								
Heat input (J/cm) = [k x V x A x 60] / S									
Interpass temperature in °C (min/max)	Min 150 °C / Max 250°C								
Welding equipment / Trade mark-type	KOLARC T 270 DC								

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

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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