





Welding Procedure Specification (WPS)

Qualification Codes/Standards:

AWS

Manufacturer's Name:

Talleres Metalurgicos "DOGOMAR"

Manufacturer's Address:

**14 Calle 5a. y 6a Avenidas
 Puerto Barrios, Izabal, Guatemala, C.A.**

WPS Number and Revision:

B2.1-1-016-94

Date:

15/04/93

Welding Procedure Qualification Record

No (PQR):

Pre-qualified

PQR Certificate No:

BOA 1100298/PQR

Welding Process:

SMAW

Type:

Manual

Welding Technique:

Multi Run

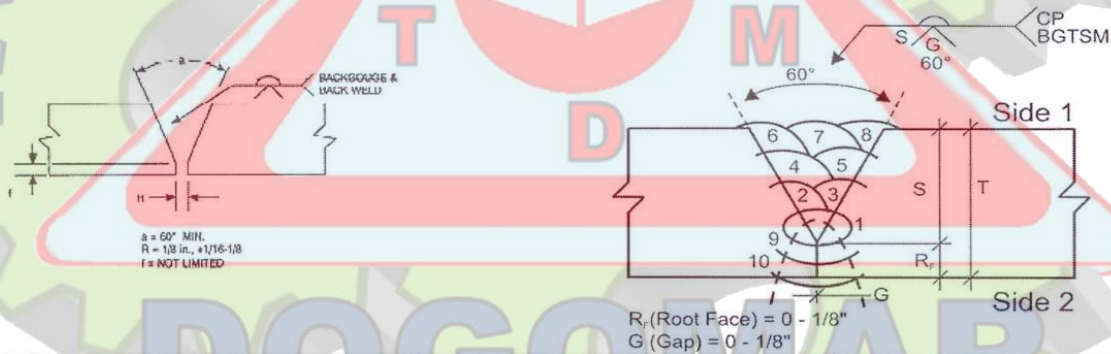
Welding Positions:

4G

Weld Preparation Details (Sketch)

Joint Design

Welding Sequences



Base Material Details

Specification and Grade – side 1:

ASTM A36; C-Mn-Si, group 1

Specification and Grade – side 2:

ASTM A36; C-Mn-Si, group 1

Form:

Platet

Thickness Range (mm):

3.2 to 38.1 for groove welds

Pipe Outside Diameter (mm):

N/A

Consumable Details

Filler Metal:

Name:

ANSI/AWS A5.1, A Number 1, F Number 4

LR Grading:

A 5.1

National Classification (if any):

E7018

Filler Metal Sizes (mm):

3.2

Flux Type and Trade Name:

N/A

Gas Composition: Shielding **N/A**
 Backing **N/A**

Gas Flow Rate: Shielding **N/A**
 Backing **N/A**

Tungsten Electrode Type & Size: **N/A**

Backing Strip Type & Size: **N/A**

*Select from dropdown menu

* Delete as appropriate

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Preheat/Heat Treatment Details:

Pre Heat Temperature °C (min): **10** Interpass Temperature °C (max): **260**
 Post weld Heat Treatment and/or Ageing:
 Method: **N/A** Temperature °C: **N/A** Time: **N/A**
 Heating and Cooling Rates: **N/A**

Technique Details:

Method of Back Gouging and Cleaning:
Mechanical or thermal
 String or Weave Bead:
 Either Weaving (Maximum width of run) **6.4**
 Oscillations: Amplitude **N/A** Frequency **N/A** Dwell time **N/A**
 Contact tube to work distance: **N/A**
 Pulse Welding Details:
 Base Current: **N/A** Base Time: **N/A** Peak Current: **N/A** Peak Time: **N/A**

Welding Details

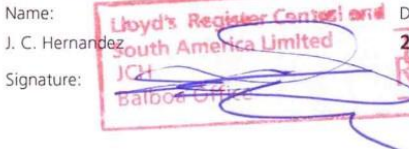

Run	Process	Size of Filler Metal	Current A	Voltage V	Type of Current/ Polarity	Wire Feed Speed	Travel Speed	Heat Input KJ/mm
1 (root)	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
2	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
3	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
4	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
5	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
6	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
7	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	
8	SMAW	3.2	90 - 150	25 - 28	DCEP (Rev)	N/A	N/A	

Other Information

Manufacturer:
Talleres Metalurgicos "DOGOMAR"

Surveyor to Lloyd's Register Central and South America Limited
 A member of the Lloyd's Register Group

Name: Carlos D. Martinez Beux
 Date: **25 November 2011**
 Signature:

Office: **Balboa**
 Name: J. C. Hernandez
 Date: **25 November 2011**
 Signature: 


1. This WPS is valid only if used by the above manufacturer.
 2. The manufacturer is responsible for ensuring that WPS meets the technical requirements for the application.