



Southern  
BRANCH

QA/QC  
DEPARTMENT

# WELDING PROCEDURE SPECIFICATION (WPS)

## ACCORDING TO API 1104

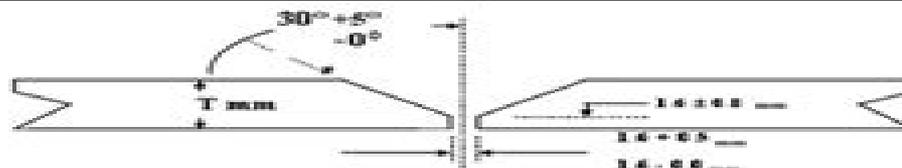
Date : 16/10/2016

WPS No. : P01

Sheet : 1 of 1

COMPANY NAME	: GASCO
PROJECT NAME	: Dabshor-Bany Swief 36" pipeline
WELDING PROCEDURE SPECIFICATION No.	: P01 Main Pipeline
REVISION NO.	: 0
SUPPORTING PQR NO.	: PQR (PL-02/2010)
TYPES (Manual, Automatic, Semi Auto.)	: MANUAL (SMAW)

### JOINTS DESIGN



### BASE METAL

Material Spec.	: API-5L
Type or Grade	: X-65
P No.	: 01
A No.	: 01
Thickness	: 4.8 ≤ T ≤ 19.05 mm
Diameter	: 36"
Other	

### FILLER METALS

Weld Metal Analysis A No.	: A1
Size of Electrode	: 3.25, 4.0 & 5.0 mm
Filler Metal No.	: F3
SFA Specification	: A 5.1 & A 5.5
AWS Classification	: E 6010 & E 80100

### POSITION

Position of Groove	: 5G
Direction of welding	: All Down-Hill
Other	

### PREHEAT

Preheat Temp. ( °C ) ( Min)	: 30°C (if needed)
Interpass Temp. ( °C ) ( Max)	: 250 °C Max
Other	: N.A.

### POSTWELD HEAT TREATMENT

Temperature Range	: N.A.
Time Range	: N.A.
Other	: N.A.

### GAS

Type of Gases	: N.A.
Composition of Gas Mixture	: N.A.
Other	: N.A.

### ELECTRICAL CHARACTERISTICS

Current	: DC
Polarity	: -ve & +ve

WELD LAYERS	FILLER METAL		CURRENT		VOLTAGE RANGE
	Class	Size (mm)	Polar.	Amp. range	
1 <sup>st</sup>	E6010	3.25	-ve	80-110	20-22
2 <sup>nd</sup>	E80100	4.00	+ve	120-180	20-27
3 <sup>rd</sup>	E80100	4.00	+ve	120-180	20-27
4 <sup>th</sup>	E80100	5.00	+ve	120-180	20-27
CAP	E80100	3.00	+ve	120-180	20-27

### TECHNIQUE

Interpass Cleaning	: Root Grinding & Wire Brush
String or Weave Bead	: Both
Orifice or Gas Cup Size	: N.A.
Multi pass or Single Pass	: Multi-passes
Single or Multiple Electrodes	: Single
LINE UP CLAMP	: Remove Internal Clamp after 100% of the Root Pass
Maximum time between 1 <sup>st</sup> and 2 <sup>nd</sup> pass ( 5 minutes)	
Maximum time between 2 <sup>nd</sup> pass and others	: Shortly

JOB TITLE	PROJECT QA / QC	Chief QA / QC
NAME	AMMED SHAWKY	ABD-ELFATTAH ABU ALI
DATE	16/10/2016	16/10/2016
SDGN		

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**Marco Casella**



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## **Table of Contents Api Welding Procedure Specification Api 1104 Qualified**

1. Understanding the eBook Api Welding Procedure Specification Api 1104 Qualified
  - The Rise of Digital Reading Api Welding Procedure Specification Api 1104 Qualified
  - Advantages of eBooks Over Traditional Books
2. Identifying Api Welding Procedure Specification Api 1104 Qualified
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Api Welding Procedure Specification Api 1104 Qualified
  - User-Friendly Interface
4. Exploring eBook Recommendations from Api Welding Procedure Specification Api 1104 Qualified
  - Personalized Recommendations
  - Api Welding Procedure Specification Api 1104 Qualified User Reviews and Ratings
  - Api Welding Procedure Specification Api 1104 Qualified and Bestseller Lists
5. Accessing Api Welding Procedure Specification Api 1104 Qualified Free and Paid eBooks
  - Api Welding Procedure Specification Api 1104 Qualified Public Domain eBooks
  - Api Welding Procedure Specification Api 1104 Qualified eBook Subscription Services
  - Api Welding Procedure Specification Api 1104 Qualified Budget-Friendly Options
6. Navigating Api Welding Procedure Specification Api 1104 Qualified eBook Formats

- ePub, PDF, MOBI, and More
  - Api Welding Procedure Specification Api 1104 Qualified Compatibility with Devices
  - Api Welding Procedure Specification Api 1104 Qualified Enhanced eBook Features
7. Enhancing Your Reading Experience
    - Adjustable Fonts and Text Sizes of Api Welding Procedure Specification Api 1104 Qualified
    - Highlighting and Note-Taking Api Welding Procedure Specification Api 1104 Qualified
    - Interactive Elements Api Welding Procedure Specification Api 1104 Qualified
  8. Staying Engaged with Api Welding Procedure Specification Api 1104 Qualified
    - Joining Online Reading Communities
    - Participating in Virtual Book Clubs
    - Following Authors and Publishers Api Welding Procedure Specification Api 1104 Qualified
  9. Balancing eBooks and Physical Books Api Welding Procedure Specification Api 1104 Qualified
    - Benefits of a Digital Library
    - Creating a Diverse Reading Collection Api Welding Procedure Specification Api 1104 Qualified
  10. Overcoming Reading Challenges
    - Dealing with Digital Eye Strain
    - Minimizing Distractions
    - Managing Screen Time
  11. Cultivating a Reading Routine Api Welding Procedure Specification Api 1104 Qualified
    - Setting Reading Goals Api Welding Procedure Specification Api 1104 Qualified
    - Carving Out Dedicated Reading Time
  12. Sourcing Reliable Information of Api Welding Procedure Specification Api 1104 Qualified
    - Fact-Checking eBook Content of Api Welding Procedure Specification Api 1104 Qualified
    - Distinguishing Credible Sources
  13. Promoting Lifelong Learning
    - Utilizing eBooks for Skill Development
    - Exploring Educational eBooks
  14. Embracing eBook Trends
    - Integration of Multimedia Elements
    - Interactive and Gamified eBooks

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