

BHARAT HEAVY ELECTRICALS LIMITED

INDUSTRIAL VALVES PLANT, GOINDWAL

WELDING PROCEDURE SPECIFICATION

WPS NO: W 001 Dated 19.09.2000

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Rev. : 00

REF (TRICHY WPS NO: A.1.1.19/02 DT 22/02/91)
(SUPPORTING PQR NO: 517)

WELDING PROCESS : SMAW ,

TYPE : MANUAL

APPLICATION : Welding of Carbon Steels Valve Components-Bush /Seat etc. to valve Body/Bonnet

Base Metal : Carbon Steels

Fillet Design : As per Production Drawing

Route Run : String base

Other Run : String or weave

Initial and inter-pass

Cleaning : Chipping, brushing & grinding.

Electrode class : E 7018 (Low Hydrogen, K, Fe-Powder)

Current and polarity : AC or DC , Reverse Polarity

Current characteristics:

Filler Dia 2.5 mm : 70 - 100 Amp.

Filler Dia 3.15mm : 100 - 140 Amp.

Filler Dia 4.0 mm : 150 - 180 Amp.

Position of the Electrode : All

Weld progression : Vertical UP.

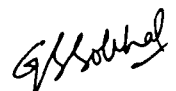
PRE-HEAT :

For thickness < 19MM : No pre-heat

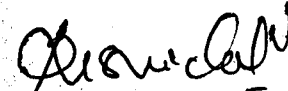
For thickness > 19 mm : 100 degree centigrade (Use thermal chalks for check)

Inter-pass temperature : 350 degree centigrade max (Use thermal chalks for check)

Post weld heat treatment (PWHT) : NOT REQUIRED.


Engineer/ Quality
(Prepared By)

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Manager/Quality
(Approved By)