

**PRELIMINARY WELDING  
PROCEDURE SPECIFICATION  
(pWPS)**

pWPS no: Sveinsprof01

Ref.:

Date:

Rev:

Prod. by: Sveinsprof

Client:

Ref. stand:

Project:

Ref. spec.:

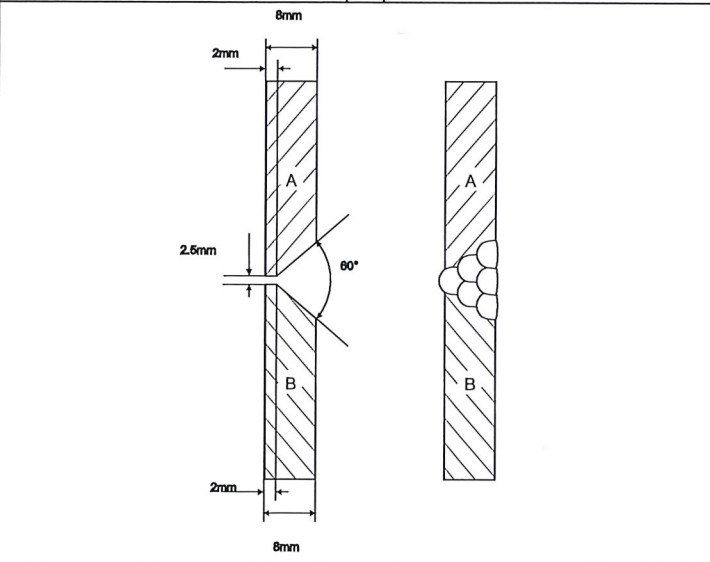
Exam. body:

Location:

Ref. Proc.:

Welding process	111				
Shielding gas type	1		2		3
Weaving (yes/no)	no	max:	mm	max:	mm

Purging gas type		l/min
Welding positions	PC	
Joint type	Butt	
Joint preparation	Grinding	
Cleaning method		
Backing		
Single/Double		
Back gouging		
Flux designation		
Flux handling		
Tungsten electrode		mm
Torch angle	°	
Stand off distance		mm
Nozzle diameter(s)		mm
Tack welding proc.		Rev:



**Identification of parent metal** I: CE max: C max: PCM max: II: CE max: C max: PCM max:

Part	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]
I	S235 JR	EN 10025	G2		8,00 - 8,00	-
II	S235 JR	EN 10025	G2		8,00 - 8,00	-

**Identification of filler metal**

Index	Trade name	Classification	Group	Filler handling
1	Filarc 36D	EN499 423P22H10		
2	Filarc 36D	EN499 423P22H10		
3				

**Welding Parameters**

Equipment:

Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Voltage [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
1		2,50	111	-	55 - 100	-	DC-	90,0 - 110,			0,7 - 0,9
2		2,50	111	-	55 - 100	-	DC+	90,0 - 110,			0,7 - 0,9
3		2,50	111	-	55 - 100	-	DC+	90,0 - 110,			0,7 - 0,9
4		2,50	111	-	55 - 100	-	DC+	90,0 - 110,			0,7 - 0,9
5		2,50	111	-	55 - 100	-	DC+	90,0 - 110,			0,7 - 0,9
6		2,50	111	-	55 - 100	-	DC+	90,0 - 110,			0,7 - 0,9
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-

**Heat treatment**

Method:

Preheat min: °C Interpass temp. max: °C Heat treatment proc.: Temp. control:  
 PWHT min: °C max: °C Soaking: min/mm min Heating rate: °C/h Cooling rate: °C/h

Remarks:  
 Sveinspróf í pinnasuðu (111), í stöðu PC lárétt inn með bsískum vír. Nota skal basískan vír amkvæmt EN499 og velja pól samkvæmt því.

Additional info enclosed (Yes/No):  
 Date/Signature:  
 Approved:

Prod. by: Sveinsprof

Client:

Ref. stand:

Project:

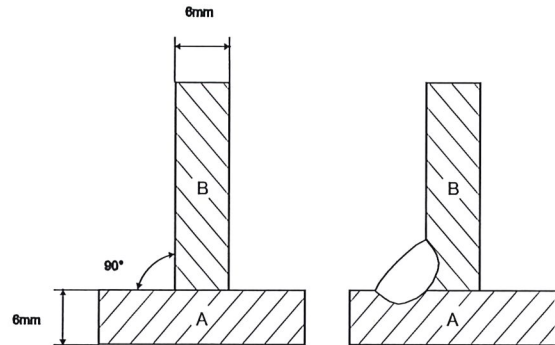
Ref. spec.:

Exam. body:

Location:

Ref. Proc.:

Welding process	135				
Shielding gas type	1	Argon/CO2/O2MIX	2		3
Weaving (yes/no)	no	max:	mm	max:	mm
Purging gas type					
Welding positions	PB				
Joint type	Fillet				
Joint preparation	Grinding				
Cleaning method	Grinding				
Backing					
Single/Double					
Back gouging					
Flux designation					
Flux handling					
Tungsten electrode					
Torch angle	°				
Stand off distance					
Nozzle diameter(s)					
Tack welding proc.	Rev:				



**Identification of parent metal** I: CE max: C max: PCM max: II: CE max: C max: PCM max:

Part	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]
I	S 235 JR	EN 10025	G2		6,00 -	-
II	S 235 JR	EN 10025	G2		6,00 -	-

**Identification of filler metal**

Index	Trade name	Classification	Group	Filler handling
1	MIGA INDUSTRI WIRE	EN 440 G 38 2 C G3 Si1		
2				
3				

**Welding Parameters**

Equipment:

Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Voltage [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
1		0,80	135	10,8 - 13,2	80 - 240	19,8 - 26,2	DC+	270, - 330,		13-16	0,3 - 1,4
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-

**Heat treatment**

Method:

Preheat min: °C Interpass temp. max: °C Heat treatment proc.:

Temp. control:

PWHT min: °C max: °C Soaking: min/mm

min Heating rate: °C/h Cooling rate: °C/h

Remarks:

Sveinspróf í MAG suðu (135), kverksuða í suðustellingu PB standandi lárétt a mál 4mm. Nota skal fyllivír samkvæmt EN499

Additional info enclosed (Yes/No):

Date/Signature:

Approved:

**PRELIMINARY WELDING  
PROCEDURE SPECIFICATION  
(pWPS)**

pWPS no: Sveinsprof03

Ref.:

Date:

Rev:

Prod. by: Sveinsprof

Client:

Ref. stand:

Project:

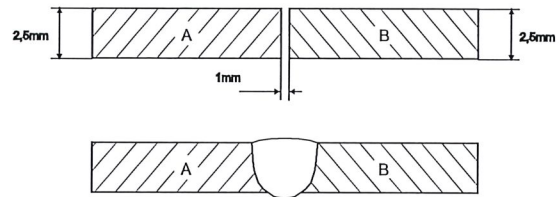
Ref. spec.:

Exam. body:

Location:

Ref. Proc.:

Welding process	311			
Shielding gas type	1		2	3
Weaving (yes/no)	no	max:	mm	max: mm
Purging gas type	l/min			
Welding positions	PA			
Joint type				
Joint preparation				
Cleaning method				
Backing				
Single/Double				
Back gouging				
Flux designation				
Flux handling				
Tungsten electrode	mm			
Torch angle	°			
Stand off distance	mm			
Nozzle diameter(s)	mm			
Tack welding proc.	Rev:			



**Identification of parent metal** I: CE max: C max: PCM max: II: CE max: C max: PCM max:

Part	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]
I	S 235 JR	EN 10025	G2		2,50 -	48,30 -
II	S 235 JR	EN 10025	G2		2,50 -	48,30 -

**Identification of filler metal**

Index	Trade name	Classification	Group	Filler handling
1	AGA H44	EN 12536 O II		
2				
3				

**Welding Parameters**

Equipment:

Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Voltage [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-

**Heat treatment**

Method:

Preheat min: °C Interpass temp. max: °C Heat treatment proc.: Temp. control:  
 PWHT min: °C max: °C Soaking: min/mm Heating rate: °C/h Cooling rate: °C/h

Remarks:  
Suðuferill fyrir logsuðu Ö48.3 x 2,5mm lengd 70mm

Additional info enclosed (Yes/No):

Date/Signature:

Approved:

Prod. by: Sveinspróf

Client:

Ref. stand:

Project:

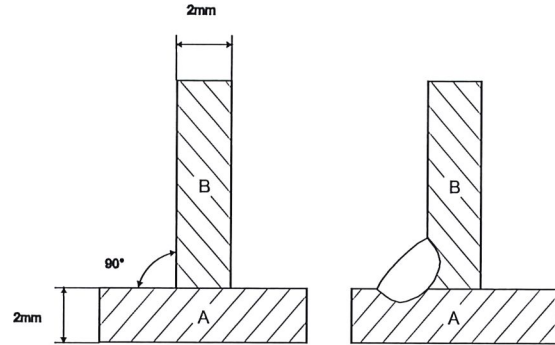
Ref. spec.:

Exam. body:

Location:

Ref. Proc.:

Welding process	141			
Shielding gas type	1 Argon	2		3
Weaving (yes/no)	no max: mm		max: mm	max: mm
Purging gas type	l/min			
Welding positions	PA			
Joint type	Fillet			
Joint preparation	Machining			
Cleaning method				
Backing				
Single/Double				
Back gouging				
Flux designation				
Flux handling				
Tungsten electrode	mm			
Torch angle	°			
Stand off distance	mm			
Nozzle diameter(s)	mm			
Tack welding proc.	Rev:			



**Identification of parent metal** I: CE max: C max: PCM max: II: CE max: C max: PCM max:

Part	Name/Grade	Standard	Group	Delivery cond.	Thickness range [mm]	Diameter range [mm]
I	AISI 316 L	EN 10216-5			2,00 -	-
II	AISI 316 L	EN 10216-5			2,00 -	-

**Identification of filler metal**

Index	Trade name	Classification	Group	Filler handling
1	ELGA Cromatig 316 SI	EN 12072 W 19 12 3 L Si		
2				
3				

**Welding Parameters**

Equipment:

Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Voltage [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
1				-	-	-	DC-	270, - 330,		5-7	-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-

**Heat treatment**

Method:

Preheat min: °C Interpass temp. max: °C Heat treatment proc.:

Temp. control:

PWHT min: °C max: °C Soaking: min/mm

min Heating rate: °C/h Cooling rate: °C/h

Remarks:  
Suðuferill fyrir TIG suðu 30x30x2mm, kverksuða PA stöðu

Additional info enclosed (Yes/No):

Date/Signature:

Approved:



**IDAN**  
fræðslusetur

# WELDING INSTRUCTION (WI)

WI no

Sveinsprof05

Ref.:

Date:

Rev:

Project:

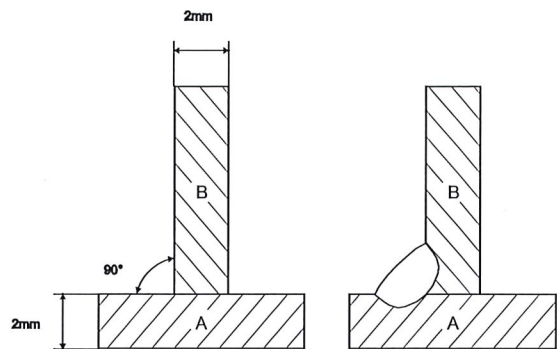
Client:

Location:

Ref. stand:

Ref. WPS:

Welding process	1	141	2		3
Shielding gas type	1	Argon	2		3
Weaving (yes/no)		no max: mm		max: mm	max: mm
Purging gas type	l/min				
Welding positions	PA				
Cleaning before welding					
Cleaning after welding					
Backing					
Single/Double					
Flux designation					
Tungsten electrode	mm				
Torch angle	°				
Stand off distance	mm				
Nozzle diameter(s)	mm				
Ref. procedures					



## Identification of parent metal

Part	Name/Grade	Thickness range [mm]	Diameter range [mm]
I	AISI 316 L	2,00 -	-
II	AISI 316 L	2,00 -	-

## Identification of filler metal

Index	Trade name	Classification
1	ELGA Cromatig 316 SI	EN 12072 W 19 12 3 L Si
2		
3		

## Welding Parameters

Equipment:

Pass no.	Index	Dia. [mm]	Welding process	Wire feed speed [m/min]	Current [A]	Voltage [V]	Current / Polarity	Welding speed [mm/min]	Run Out Length [mm]	Gas [l/min]	Heat input [kJ/mm]
1				-	-	-	DC-	270, - 330,		5-7	-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-
				-	-	-		-			-

## Heat treatment

Preheat min: °C Interpass temp. max: °C

Method:

PWHT min: °C max: °C

Temp. control:

Remarks:

Suðuferill fyrir stúfsuðuhluta í TIG prófilli 30x30x2mm. PA staða

Additional info enclosed (Yes/No):

Date/Signature:

Approved:

Logskurður:

Taka skal PF stykkið. Handbrenna skal aðra langhliðina með sama fasi og sýnt er á pWPS No: Sveinspróf 01, þó ekki þá hlið sem sjóða skal saman.

Á hinum hluta stykkisins skal einnig handbrenna annað hornið með beinum skurði með radíus R60 mm. Vanda skal áferð, form og frágang.

Kveiking:

Kveikja skal saman tvo koparhólka. Tryggja skal fyllingu, gegnum kveikingu og góða áferð.