



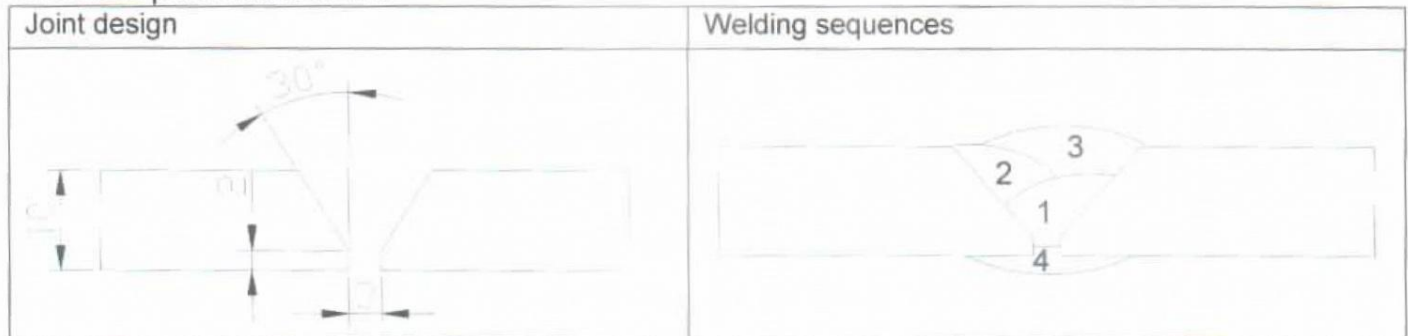
# WPS

## WELDING PROCEDURE SPECIFICATION

WPQR No	:01.....	Parent Material Grade	Part 1 AH-36	Part 2 AH-36
Method of preparation and cleaning	:CNC.....	Range of Material thickness	:3-20mm	3-20mm
Joint Type	:Brushing.....	Range of Outside diameter	:.....	.....
Parent Material Spec.	:Butt Joint.....	Range of Welding Position	:PA.....	
	:Carbon Steel.....			

### Both Sides Welding

### Weld Preparation Details



### Welding Details

Run number	1	2	3	4			
Welding process	SMAW (111)	SMAW (111)	SMAW (111)	SMAW (111)			
Autom. Welding	.nr. of heads						
	.weaving						
Filler metal: wire (W) or electrode (E)	E	E	E	E			
.Designation	GE-KA (Gedik Kaynak A.Ş.)						
.Grade	EN ISO 2560 - A : E 42 4 B 42 H5 AWS A5.1 : E 7018						
.Description	LASER B 47						
.Diameter	2.50mm	2.50mm	2.50mm	2.50mm			
Shielding: Flux (F) or gas (G)	-	-	-	-			
.Power flux	.description	-	-	-			
	.type and trade name	-	-	-			
.Gas flux	.description	-	-	-			
	.type and trade name	-	-	-			
.Backing	.flow rate (l/mn)	-	-	-			
.Shielding	.flow rate (l/mn)	-	-	-			
.Plasma		-	-	-			
Tungsten electrode: type/size							
Type of current	DC	DC	DC	DC			
Electrode or wire polarity	+	+	+	+			
Current (A)	80~100	80~100	80~100	80~100			
Voltage (V)	19~20	19~20	19~20	19~20			
Travel speed S (cm/min)	6	6	6	6			
Wire feed speed (cm/min)	-	-	-	-			
Heat input (J/cm) = [ k x V x A x 60 ] / S	17750	17750	17750	17750			
Preheat temperature in °C	-	-	-	-			
Interpass temperature in °C (min/max)	200~250						

Post heating NO Temperature°C..... Holding Time.....  
Post Weld Heat treatment NO Temperature°C..... Holding Time.....

Prepared by Shipyard Representative

Name: Hikmet Onat SAYGILI.

Signature:

Stamp

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BV Rules on Material and Welding for the  
Classification of Marine Units,  
NR216, Ch 5, Sec 4,  
Approval of Welding Procedures

WPS No: 02.....

Date of Issue: 17.09.2011

**WPS**

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## WELDING PROCEDURE SPECIFICATION

WPQR No	:02.....	Parent Material Grade	Part 1	Part 2
Method of preparation and cleaning	:CNC.....	Range of Material thickness	AH-36	316L
Joint Type	:Brushing.....	Range of Outside diameter	:3-12mm	
Parent Material Spec.	:Fillet Joint.....	Range of Welding Position	:PA, PB.....	12,5-50mm
	:Carbon Steel, Austenitic stainless steel.....			

### Single Layer

### Weld Preparation Details

Joint design	Welding sequences

### Welding Details

Run number	1								
Welding process	SMAW								
Autom. Welding	(111)								
.nr. of heads									
.weaving									
Filler metal: wire (W) or electrode (E)	E								
.Designation	GE-KA (Gedik Kaynak A.Ş.)								
.Grade	EN 1600 : E 23 12 LR 32								
.Description	AWS A5.1 : E 309 L-16								
.Diameter	ELOX R 309 L								
Shielding: Flux (F) or gas (G)	3.20mm								
.Power flux	-								
.description	-								
.type and trade name	-								
.Gas flux	-								
.description	-								
.type and trade name	-								
.Backing	-								
.flow rate (l/mn)	-								
.Shielding	-								
.flow rate (l/mn)	-								
.Plasma	-								
Tungsten electrode: type/size	-								
Type of current	DC								
Electrode or wire polarity	+								
Current (A)	85~105								
Voltage (V)	19~20								
Travel speed S (cm/min)	17								
Wire feed speed (cm/min)	-								
Heat input (J/cm) = [ k x V x A x 60 ] / S	6538								
Preheat temperature in °C	-								
Interpass temperature in °C (min/max)	175~225								
Post heating	NO	Temperature°C.....				Holding Time.....			
Post Weld Heat treatment	NO	Temperature°C.....				Holding Time.....			

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BV Rules on Material and Welding for the  
Classification of Marine Units,  
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# WELDING PROCEDURE SPECIFICATION

WPQR No	:03.....	Parent Material Grade	Part 1	Part 2
Method of preparation and cleaning	:CNC.....	Range of Material thickness	AH-36	AH-36
Joint Type	:Brushing.....	Range of Outside diameter	:3-20mm	3-20mm
	:Fillet Joint.....	Range of Welding Position	:.....	.....
	Parent Material Spec.	:Carbon Steel,.....	:PA, PB.....	.....

Single Layer

Weld Preparation Details

Joint design	Welding sequences

Welding Details

Run number	1				
Welding process	GMAW (135)				
Autom. Welding	.nr. of heads				
	.weaving				
Filler metal: wire (W) or electrode (E)	W				
.Designation	GE-KA (Gedik Kaynak A.Ş.)				
.Grade	EN ISO 636-A W3 Si 1				
.Description	AWS A5.18 ER 70 S-6				
.Diameter	SG2				
Shielding: Flux (F) or gas (G)	1.20mm				
.Power flux	G				
.description	-				
.type and trade name	-				
Gas flux	%86ARGON %12CO2- %2O2				
.description	YALIZ - YMIX 212				
.type and trade name	-				
.Backing	.flow rate (l/mn)				
.Shielding	.flow rate (l/mn)				
.Plasma	-				
Tungsten electrode: type/size	-				
Type of current	DC				
Electrode or wire polarity	+				
Current (A)	193				
Voltage (V)	31				
Travel speed S (cm/min)	26				
Wire feed speed (cm/min)	-				
Heat input (J/cm) = [ k x V x A x 60 ] / S	11045				
Preheat temperature in °C	-				
Interpass temperature in °C (min/max)	125~175				

Post heating NO Temperature°C..... Holding Time.....  
Post Weld Heat treatment NO Temperature°C..... Holding Time.....

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