

# EUROZETA S.r.l.

Via Drione,10 – 24060 – CASAZZA (BG)

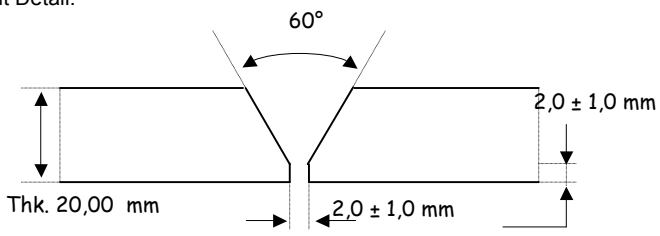
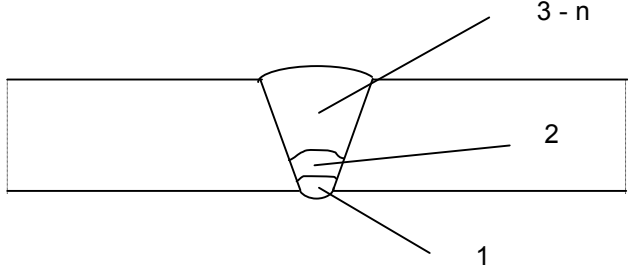
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## SPECIFICA DI PROCEDIMENTO SALDATURA WELDING PROCEDURE SPECIFICATION (WPS)

According to ASME code Section IX QW-482

foglio 1 di 2 / sheet 1 of 2

SOCIETA' Company Name:		<b>EUROZETA S.r.l. - 24060 - CASAZZA (BG)</b>		
SPECIFICA DI SALDATURA No. Welding Procedure Specification No.:		<b>02-2012 Rev.00</b>	QUALIFICA DI SUPPORTO N° Supporting PQR No.:	<b>02-2012 Rev.00</b>
DATA Date:		<b>12 / 09 / 2012</b>	CLIENTE Customer:	-----
TIPO Type:	<b>Partially Mechanized</b>		COMMESSA N° Job No.:	-----
PROCEDIMENTO DI SALDATURA Welding Process:		<b>GMAW</b>	DISEGNO N° Drawing No.:	-----
<b>Joints ( QW 402 )</b>				
Joint Detail:				
				
<b>Plate Thk. 20,0 mm</b>				

<b>METALLO BASE / BASE MATERIALS (QW-403)</b>							
P.No.:	----	GRUPPO N°: Group No.:	-----	To P.No.:	-----	GRUPPO N°: Group No.:	-----
O SPECIFICA TIPO E GRADO Or Specification Type and Grade:		<b>EN 10025-2 S375 JR</b>		CON SPECIFICA TIPO E GRADO To Specification Type and Grade:		<b>EN 10025-2 S275 J2</b>	
O ANALISI CHIMICA E PROP. MECC. Or Chem. Analysis and Mech. Prop.:		-----		CON ANALISI CHIMICA E PROP. MECC. Or Chem. Analysis and Mech. Prop.:		-----	

SPESSORI / Thickness:				
METALLO BASE Base Metal:	SMUSSO Groove:	<b>5,0 ÷ 40,0 mm</b> <b>(Low Temperature 16,0 ÷ 40,0 mm)</b>	ANGOLO Fillet:	<b>All</b>
DIAMETRI TUBI Pipe Dia.:	SMUSSO Groove:	<b>≥ 73,0 mm</b>	ANGOLO Fillet:	<b>All</b>
ALTRO: Other:				

<b>METALLO D'APPORTO / FILLER METALS (QW-404)</b>			
PROCEDIMENTO/Process:	<b>1 st pass (GMAW)</b>	<b>2 nd pass (GMAW)</b>	<b>3 - n passes (GMAW)</b>
Spec.No. (SFA):	<b>5.18</b>	<b>5.18</b>	<b>5.18</b>
AWS No. (Class):	<b>ER 70S-6</b>	<b>ER 70S-6</b>	<b>ER 70S-6</b>
F-NO No.:	<b>6</b>	<b>6</b>	<b>6</b>
A-NO No.:	<b>1</b>	<b>1</b>	<b>1</b>
DIAM. METALLO D'APPORTO: Size of filler metals:	<b>Wire Ø 1,2 mm</b>	<b>Wire Ø 1,2 mm</b>	<b>Wire Ø 1,2 mm</b>
INSERTO: Consum. Insert	<b>None</b>	<b>None</b>	<b>None</b>
SPESSORI / Thickness:	<b>(2,0 mm) 4,00 mm max</b>	<b>(2,0 mm) 4,00 mm max</b>	<b>(16,0 mm) 32,0 mm max</b>
FILO PIENO O ANIMATO: Solid or metal cored:	<b>Solid</b>	<b>Solid</b>	<b>Solid</b>
FILO-FLUSSO / Electrode - Flux (Class):	<b>LAFILI LA/S6N</b>	<b>LAFILI LA/S6N</b>	<b>LAFILI LA/S6N</b>
DENOM. COMMERCIALE FLUSSO Flux Trade Name:	-----	-----	-----

ALTRO Other:	<b>QW403.9 GMAW process : t pass &lt; 13,0 mm</b>
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SPECIFICA DI PROCEDIMENTO SALDATURA  
WELDING PROCEDURE SPECIFICATION (WPS)  
According to ASME code Section IX QW-482

WPS No. : **02-2012** Rev.00 foglio 2 di 2 / sheet 2 of 2

POSIZIONE / POSITION (QW-405)		TRATTAMENTO TERMICO DOPO SALDATURA POSTWELD HEAT TREATMENT (QW-407)						
POSIZIONE SMUSSO Position(s) Groove:	<b>(Welded 2G) ALL</b>	GAMMA DI TEMPERATURA Temperat. Range :	-----					
PROGRESSIONE SALDATURA Welding progression (up/down):	<b>N/A</b>	TEMPO DI MANTENIMENTO Time Range :	-----					
POSIZIONE SALD. ANGOLO Position(s) of Fillet :	<b>ALL</b>	<b>GAS (QW-408)</b>	% COMPOSIZIONE Percent compos.					
<b>PRERISCALDO / PREHEAT (QW-406)</b>		Process Gas(es)	MISCELA (Mixture)	PORTATA Flow rate lt/1'				
TEMP. PRERISCALDO MIN. Preheat Temp. Min.:	<b>10 C°</b>	PROTEZIONE Shielding:	<b>Argon + CO<sub>2</sub></b>	<b>82% + 18%</b>	<b>12 - 14</b>			
TEMP. DI INTERPASS MAX. Interpass Temp. Max:	<b>280 C°</b>	PROTEZIONE Shielding:	<b>None</b>	<b>None</b>	<b>None</b>			
MANTENIMENTO PRERISC. Preheat Maintenance:	<b>N/A</b>	ROVESCIO Backing:	<b>None</b>	<b>None</b>	<b>None</b>			
CARATTERISTICHE ELETTRICHE / ELECTRICAL CHARACTERISTICS (QW-409)								
CORRENTE Current A.C.or D.C.:	<b>1st &amp; 2<sup>nd</sup> Pass Pulsed Other Passes DC</b>		POLARITA' Polarità :	<b>Reverse (+)</b>				
CAMPO AMPERAGGIO Amps (Range) :	<b>See table</b>		CAMPO VOLTS Volts (Range):	<b>See table</b>				
TIPO E DIAMETRO ELETTRODO TUNGSTENO Tungsten Electrodes Size and Type:	<b>N/A</b>							
CARATTERISTICHE DELL'ARCO PER GMAW Mode of Metal Transfer for GMAW :	<b>Pulsed &amp; Spray Arc</b>							
GAMMA DI VELOCITA' ALIMENTAZIONE FILO Electrodes Wire Feed Speed Range :	<b>2 – 3 mt / min</b>							
TECNICA / TECHNIQUE (QW-410)								
PASSATA STRETTA O LARGA String or Weave Bead :	<b>String.</b>							
DIMENSIONE UGELLO Orifice or Gas Cup Size :	<b>20 mm</b>							
PULIZIA (spazzolatura, molatura, etc.) Cleaning (Brushing, Grinding, etc.):	<b>Brushing and / or Grinding.</b>							
METODO DI RIPRESA AL ROVESCIO Method of Back Gouging:	<b>N/A</b>							
OSCILLAZIONE Oscillation :	<b>N/A</b>							
DISTANZA UGELLO DI CONTATTO/PEZZO Contact Tube to Work Distance :	<b>15 – 20 mm</b>							
PASSATA SINGOLA O MULTIPLA (per lato) Single or Multiple Pass (For Side) :	<b>Multiple</b>							
ELETTRODO MULTIPLA O SINGOLO Multiple or Single Electrodes :	<b>N/A</b>							
CAMPO VELOCITA' SALDATURA Travel speed (range) :	<b>See Table</b>							
MARTELLATURA Peening :	<b>No peening is allowed</b>							
ALTRO Other :	<b>QW 410.64 "use of tthermal process": N/A</b>							
STRATI DI SALDATURA Weld Layer(s)	PROCED. DI SALDATURA Welding Process	METALLO D'APPORTO Filler Metal		CORRENTE Current		CAMPO VOLTS	GAMMA VELOCITA' DI LAVORO Travel speed Range (cm/1')	APPORTO TERMICO Heat input KJ/mm
		Classif.	Dia.(mm)	POLARITA' Polarity	CAMPO AMPERE Amp.Range	Voltage Range		
<b>1</b>	<b>GMAW</b>	<b>5.18 ER 70S-6</b>	<b>Ø 1,2</b>	<b>Pulsed RP (+)</b>	<b>160 ÷ 180</b>	<b>24 ÷ 26</b>	<b>18 ÷ 20</b>	<b>Max 1,560</b>
<b>2</b>	<b>GMAW</b>	<b>5.18 ER 70S-6</b>	<b>Ø 1,2</b>	<b>Pulsed RP (+)</b>	<b>170 ÷ 190</b>	<b>24 ÷ 26</b>	<b>22 ÷ 24</b>	<b>Max 1,347</b>
<b>3 - n</b>	<b>GMAW</b>	<b>5.18 ER 70S-6</b>	<b>Ø 1,2</b>	<b>DC RP (+)</b>	<b>190 ÷ 200</b>	<b>24 ÷ 26</b>	<b>22 ÷ 24</b>	<b>Max 1,418</b>
Redatto/prepared by :		Approvazione ispettorato/Inspection agency approval :					Data/Date :	
EUROZETA S.r.l.							12/09/2012	