



WELDING PROCEDURE SPECIFICATION

WPS: 7100-xxxx-HPDE-EF-02
WELDING PROCESS: TF
SUPPORTING PQR: 7100-EF-TEGA

REV. NO.: 0
CODE: ANSI B31.3

DATE: 3/20/2018
OTHER:

****APPLICABILITY****

JOINT: This WPS shall be used in conjunction with the General Welding Standards (GWS) and Welding Fabrication Procedure (WFP) sections and criteria for joint details, repairs, NDE, inspection, etc.

Weld Joint Type: Electrofusion Coupling

Class: Full thermal fusion

See GWS 1-06 and WFP's for joint details.

Preparation: Remove surface to virgin material

Root Opening:

Backing: N/A

Backgrind Root: N/A

Backing Mat.: N/A

Bkgrd Method: N/A

GTAW Flux: N/A

Backing Retainer: N/A

FILLER METALS:

A No: N/A

SFA Class: N/A

Class: N/A

Insert: N/A

Insert Type: N/A

F No: N/A **Size:** N/A

Flux: **Type:** N/A

Size: N/A

Weld Metal Thickness Ranges:

Filler Material Note: The largest pipe diameter to be fused is 16" per ASME B31.3 A328.2.5(a)(2).

AWS Root Pass:

AWS Balance:

ASME Root Pass:

ASME Balance:

BASE MATERIAL:

	P No: N/A	Gr No.:	to P No.: N/A	Gr No.:
Spec.: ASTM D-3035	Grade:	to Spec.: ASTM D-3035		Grade:
Qualified Pipe Dia. Range: >=	AWS:	ASME: 0.5		
Qualified Thickness Range:	AWS:	ASME:		

QUALIFIED POSITIONS: **AWS:** N/A **ASME:** All **Vert. Prog.:** N/A

Preheat Min. Temp.: 50	GAS: Shielding: N/A	or	N/A
Interpass Max. Temp.: N/A °F	Gas Composition: / / %		/ / %
Preheat Maintenance: N/A °F	Gas Flow Rate cfh:		
PWHT: Time @ °F Temp.:	Backing Gas/Comp: N/A		
Temperature Range:	Backing Gas Flow cfh:		
	Trailing Gas/Comp: N/A		

QA REVIEWED BY: _____
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DATE:

APPROVED BY: _____
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DATE: