



WELDING PROCEDURE SPECIFICATION

WPS: 7000-xxxx-HDPE

REV. NO.: 0

DATE: 2/28/2011

****APPLICABILITY****

WELDING PROCESS: TF - and TF -

CODE: ASME IX

OTHER: ANSI B31.3 Ch. VII

SUPPORTING PQR: 7200-HDPE Butt weld

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: Butt

Class: N/A

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

Preparation: Cut pipe and rough bonding surfaces

Root Opening: N/A

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:

Class: N/A and N/A

A No: N/A

SFA Class: N/A and N/A

F No: N/A and N/A

Size: 0 0 0 0

Insert: N/A

Insert Type: N/A

Weld Metal Thickness Ranges:

Flux: Type: N/A

Size: N/A

AWS Root Pass: 0 thru 0

Filler Material Note: N/A

AWS Balance: 0 thru 0

ASME Root Pass: 0 thru 0

ASME Balance: 0 thru 0

BASE MATERIAL:

P No: N/A

Gr No.: N/A

to P No.: N/A

Gr No.: N/A

Spec.: ASME PE 3408

Grade: N/A

to Spec.: ASME PE 3408

Grade: N/A

Qualified Pipe Dia. Range: >=

AWS: 0

ASME: 4

Qualified Thickness Range:

AWS: 0 thru 0

ASME:

QUALIFIED POSITIONS:

AWS: N/A

ASME: N/A

Vert. Prog.: N/A

Preheat Min. Temp.: 400

GAS: Shielding: N/A or N/A

Interpass Max. Temp.: 450 °F

Gas Composition: 0 / 0 / 0 % 0 / 0 / 0 %

Preheat Maintenance: N/A °F

Gas Flow Rate cfh: 0 to 0 0 to 0

PWHT: Time @ °F Temp.: 0

Backing Gas/Comp: N/A 0 %

Temperature Range: N/A °F to N/A °F

Backing Gas Flow cfh: 0 to 0

Trailing Gas/Comp: N/A 0 %

WELDING CHARACTERISTICS:

Current: N/A and N/A

Tungsten Type: N/A

Transfer Mode: N/A

Ranges: Amps: 0 to 0

Tungsten Dia.: 0

Pulsing Cycle: N/A to N/A

Volts: 0 to 0

Background Current: N/A

Fuel Gas: N/A

Flame: N/A

Braze Temp °F: N/A to N/A

WELDING TECHNIQUE: For fabrication specific requirements such as fitup, cleaning, grinding, PWHT and inspection criteria, refer to Volume 2, Welding Fabrication Procedures.

Technique: Thermal fusion

Cleaning Method: Scrap to remove surface film

