

# LIST OF WELDING PROCEDURE

ITEM NO.	MATERIAL SPECIFICATION (PQR)	P-NO.	WPS NO.	PQR NO.	WELDING PROCESS	THICKNESS RANGE(MM)	PREHEAT °C	PWHT °C	AWS CLASS	REMARKS
—	ACCORDING TO ASME SECTION IX STANDARD									
1	SA516-70 to SA-516-70	P1-P1	S1-001	R1-001	SAW	4.8-100	10(t<32MM) 95(t≥32MM)	625±25	F7P2-EM12K	
2	SA516-70 to SA-516-70	P1-P1	S1-002	R1-002	FCAW	4.8-70	10(t<32MM) 95(t≥32MM)	625±25	E71T-1	
3	SA516-70 to SA-516-70	P1-P1	S1-003	R1-003	GTAW+ SMAW	1.5-16	10	625±25	ER70S-G E-7018	
4	SA516-70 to SA-516-70	P1-P1	S1-004	R1-004	GTAW+ FCAW	1.5-18	10	625±25	ER70S-G E71T-1	
二、	ACCORDING TO CNS(TAIWAN) STANDARD									
1	SA516-70 to SA-516-70	P1 - P1	WPS-S101-001	PQR-S101-001	SMAW	5-32	16	N/A	E7016	
2	SA516-70 to SA-516-70	P1 - P1	WPS-S101-002	PQR-S101-002	SMAW	5-44	16(t<32MM) 94(t≥32MM)	625±25	E7016	
3	SA516-70 to SA-516-70	P1 - P1	WPS-S101-003	PQR-S101-003	GTAW+ SMAW	1.5-16	16	N/A	ER70S-G E-7016	
4	SA516-70 to SA-516-70	P1 - P1	WPS-S101-004	PQR-S101-004	GTAW+ SMAW	1.5-16	16	625±25	ER70S-G E-7016	
5	SA516-70 to SA-516-70	P1 - P1	WPS-S101-005	PQR-S101-005	FCAW	5-70	16(t<32MM) 94(t≥32MM)	625±25	E71T-1	
6	SA516-70 to SA-516-70	P1 - P1	WPS-S101-006	PQR-S101-006	FCAW	5-32	16	N/A	E71T-1	
7	SA516-70 to SA-516-70	P1 - P1	WPS-S101-007	PQR-S101-007	GTAW+ SMAW	5-28	16	625±25	ER80S-G E8016-C1	IMPACT TEST
8	SA240-304 to SA240-304	P8 - P8	WPS-S101-008	PQR-S101-008	GTAW+ SMAW	1.5-12	16	N/A	ER308L E308-16	