

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
9	SA516-70+SA240-410 to SA516-70+SA240-410	P1+6-P1+6	WPS-S101-009	PQR-S101-009	FCAW	5-20	150	YES	E71T-1 E309LT-1	CLAD STEEL
10	SA240-304L to SA240-304L	P8 - P8	WPS-S101-010	PQR-S101-010	FCAW	5-25.4	16	N/A	E308LT-1	
11	SA516-70 to SA240-304L	P1 - P8	WPS-S101-011	PQR-S101-011	GTAW+ SMAW	5-24	16	N/A	ER309 E309-16	
12	SA516-70 to E309-16 and 308-16	P1/F5	WPS-S101-012	PQR-S101-012	SMAW	1.5-16	16	625±25	E309-16 E308-16	OVERLAY
13	SA240-304 to SA240-304	P8 - P8	WPS-S101-013	PQR-S101-013	FCAW	5-60	16	N/A	E308LT-1	
14	SA516-70 to SA179	P1 - P1	WPS-S101-014	PQR-S101-014	GTAW	1.5-5.4	16	N/A	ER70S-G	TUBE to TUBESHEET
15	SA516-70 to SA-516-70	P1 - P1	WPS-S101-015	PQR-S101-015	GTAW+ SMAW	1.5-16	16	N/A	ER70S-G E-7016	
16	SA516-70 to SA-516-70	P1 - P1	WPS-S101-016	PQR-S101-016	GTAW+ SMAW	1.5-16	16	625±25	ER70S-G E-7016	
17	SA516-70 to SA-516-70	P1 - P1	WPS-S101-017	PQR-S101-017	FCAW	5-32 , 38	16(t < 32MM) 94(t ≥ 32MM)	N/A	E71T-1	
18	SA516-70 to SA-516-70	P1 - P1	WPS-S101-018	PQR-S101-018	SAW	5-32 , 38	16(t < 32MM) 94(t ≥ 32MM)	N/A	F7A2+ EM12K	
19	SA516-70 to SA-516-70	P1 - P1	WPS-S101-019	PQR-S101-019	SAW	5-100	16(t < 32MM) 94(t ≥ 32MM)	625±25	F7A2+ EM12K	
20	SA516-70 to SA-516-70	P1-P1	WPS-S101-020	PQR-S101-020	GTAW+ FCAW	1.5-18	16	N/A	ER70S-G E71T-1	
21	SA516-70 to SA-516-70	P1-P1	WPS-S101-021	PQR-S101-021	GTAW+ FCAW	1.5-18	16	625±25	ER70S-G E71T-1	
22	SA240-304 to SA240-304	P8 - P8	WPS-S101-022	PQR-S101-022	GTAW+ FCAW	1.5-16	16	N/A	ER308L E308LT-1	