

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
23	SA516-70 to SA-516-70	P1-P1	WPS-S101-023	PQR-S101-023	FCAW	5-32 , 35	16(t<32MM) 94(t≥32MM)	N/A	E71T-1	
24	SA516-70 to SA-516-70	P1-P1	WPS-S101-024	PQR-S101-024	SAW	5-32 , 35	16(t<32MM) 94(t≥32MM)	N/A	F7A2+ EM12K	
25	SB463-NO8020 to SB463-NO8020	P45-P45	WPS-S101-025	PQR-S101-025	FCAW	5-31.6	16	N/A	ERNiCr-3	
26	SB463-NO8020 to SB463-NO8020	P45-P45	WPS-S101-026	PQR-S101-026	SMAW	5-31.6	16	N/A	ENiCrMO-3	
27	SA240-316L to ERNiCr-3	P8/F43	WPS-S101-027	PQR-S101-027	FCAW	1.5-8	16	N/A	ERNiCr-3	OVERLAY
28	SA517-70 to SB463-NO8020	P1-P45	WPS-S101-028	PQR-S101-028	SMAW	5-31.6	16	N/A	ENiCrMO-3	
29	SA240-304 to SA240-304	P8-P8	WPS-S101-029	PQR-S101-029	SAW	5-50	16	N/A	ER308	
30	SA516-7- to SA240-304	P1-P8	WPS-S101-030	PQR-S101-030	FCAW	5-32	16	N/A	309LT-1	
31	SB127-NO4400 to SB127-NO4400	P42-P42	WPS-S101-031	PQR-S101-031	GTAW+ SMAW	5-24	16	N/A	ERNiCu-7 ENiCu-7	
32	SB127-NO4400 to SA516-70	P42-P1	WPS-S101-032	PQR-S101-032	GTAW	5-24	16	N/A	ERNiCu-7	
33	SB127-NO4400 to SA240-304	P42-P8	WPS-S101-033	PQR-S101-033	GTAW	5-24	16	N/A	ERNiCu-7	
34	SA387-11-2 to SA387-22-2	P4-P4	WPS-S101-035	PQR-S101-035	GTAW+ SMAW	5-25	150	675±25	ER80S-B2 E8018-B2	
35	SA387-11-2 to SA387-22-2	P4-P4	WPS-S101-036	PQR-S101-036	FCAW	5-60	150	675±25	E81T-B2	
36	SA387-11-2 to SA516-70	P4-P1	WPS-S101-036	PQR-S101-036	GTAW+ FCAW	5-60	150	675±25	ER80S-B2 E81T-B2	