

WELDING PROCEDURE

No.	Regulations	Body	PQR WPQR	Base Material				Proceeding			Range		PWHT	P-No.	Group No.
				Subject	Ø - Th mm	Type	Position Welding	Gtaw/Smaw	Gtaw/Gmaw Gtaw/Fcaw	Thickness	Ø mm - Inc				
01	EN ISO 15614-1 2005	Bureau Veritas	01/07	Pipe	48,3 X 7,14	A333 Gr.6	A333 Gr.6	H-L045	141 + 111 141 111		3 ÷ 14,28 1,4 ÷ 4 3 ÷ 10,28	≥ 25	NO	1	1,3
02	EN ISO 15614-1 2005	Bureau Veritas	02/07	Pipe	21,3 X 4,78	A333 Gr.6	A333 Gr.6	H-L045	141 + 111 141 111		3 ÷ 9,56 1,4 ÷ 4 3 ÷ 5,56	10,65 ÷ 42,06	NO	1	1,3
03	EN ISO 15614-1 2005	Bureau Veritas	03/07	Pipe	60,3 X 8,71	A312 TP316L	A312 TP316L	H-L045	141 + 111 141 111		3 ÷ 17,42 1,4 ÷ 4 3 ÷ 13,42	≥ 30,15	NO	8	8,1
04	EN ISO 15614-1 2005	Bureau Veritas	04/07	Pipe	21,3 X 4,78	A312 TP316L	A312 TP316L	H-L045	141 + 111 141 111		3 ÷ 9,56 1,4 ÷ 4 3 ÷ 5,56	10,65 ÷ 42,06	NO	8	8,1
05	ASME IX	Bureau Veritas	05/07	Pipe	48,3 X 7,14	A333 Gr.6	A333 Gr.6	6G	Gtaw + Smaw Gtaw Smaw		1,5 ÷ 14,28 ≤ 4 ≤ 10,28	≥ 1"	NO	1	1
06	ASME IX	Bureau Veritas	06/07	Pipe	21,3 X 4,78	A333 Gr.6	A333 Gr.6	6G	Gtaw + Smaw Gtaw Smaw		1,5 ÷ 9,56 ≤ 4 ≤ 5,56	≥ 21,3	NO	1	1
07	ASME IX	Bureau Veritas	07/07	Pipe	60,3 X 8,71	A312 TP316L	A312 TP316L	6G	Gtaw + Smaw Gtaw Smaw		1,5 ÷ 17,42 ≤ 4 ≤ 13,42	≥ 1"	NO	8	1
08	ASME IX	Bureau Veritas	08/07	Pipe	21,3 X 4,78	A312 TP316L	A312 TP316L	6G	Gtaw + Smaw Gtaw Smaw		1,5 ÷ 9,56 ≤ 4 ≤ 5,56	≥ 21,3	NO	8	1

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				Subject	Ø - Th mm	Type	Position Welding	Gtaw/Smaw	Gtaw/Gmaw Gtaw/Fcaw	Thickness	Ø mm - Inc				
09	ASME IX	Bureau Veritas	01/10/A	Plate	40	A516 Gr.60	A516 Gr.70	1G	Gtaw + Smaw Gtaw Smaw		5 ÷ 200 ≤ 12 ≤ 200	≥ 73	NO	1 - 1	1 - 2
10	ASME IX	Bureau Veritas	02/10/A	Plate	20	A240 316L	A240 316L	1G	Gtaw + Smaw Gtaw Smaw		5 ÷ 40 ≤ 8 ≤ 32	≥ 73	NO	8	1
11	ASME IX	EFW	01/13-A	Plate	40	A516 Gr.60	A516 Gr.70	1G		Gtaw + Gmaw Gtaw Gmaw	5 ÷ 200 ≤ 8 ≤ 200	≥ 73	SI	1 - 1	1 - 2
12	ASME IX	EFW	02/13-A	Pipe	21,3 X 4,78	A312 TP316L	A312 TP316L	6G	Gtaw + Smaw Gtaw Smaw		1,5 ÷ 9,56 ≤ 6 ≤ 3,56	≥ 21,3	SI	8	1
13	ASME IX	EFW	03/13-A	Plate	40	A240 316L	A240 316L	1G		Gtaw + Fcaw Gtaw Fcaw	5 ÷ 200 ≤ 8 ≤ 200	≥ 73	SI	8	1
14	EN ISO 15614-1 2012	EFW	01/13-E	Plate	40	A516 Gr.60	A516 Gr.70	PA		141 + 136 141 136	20 ÷ 80 3 ÷ 8 18 ÷ 72	≥ 150	SI	1	1.1
15	EN ISO 15614-1 2012	EFW	02/13-E	Pipe	21,3 X 4,78	A312 TP316L	A312 TP316L	H-L045	141 + 111 141 111		3 ÷ 9,56 3 ÷ 6 1,25 ÷ 3,56	10,65 ÷ 42,06	SI	8	8.1
16	EN ISO 15614-1 2012	EFW	03/13-E	Plate	40	A240 316L	A240 316L	PA		141 + 136 141 136	20 ÷ 80 3 ÷ 8 18 ÷ 72	≥ 150	SI	8	8,1

