



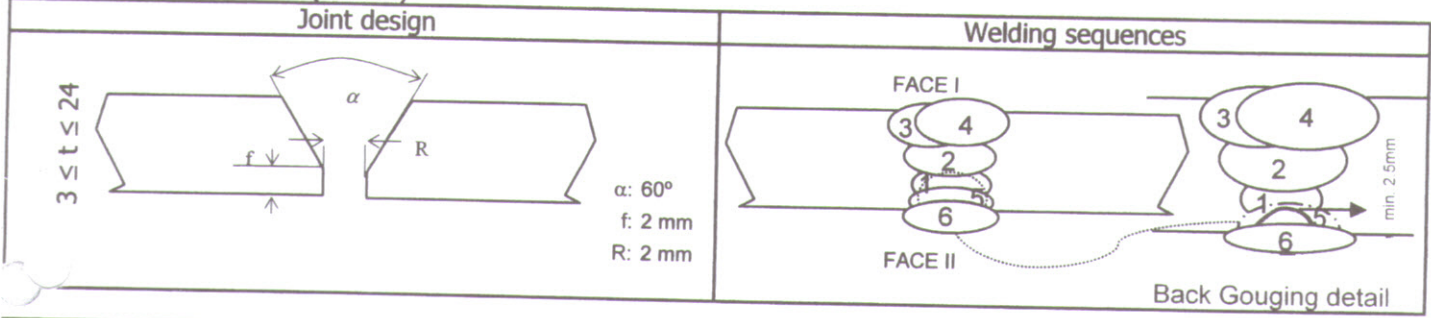
WELDING PROCEDURE SPECIFICATION (WPS)

WPS No : CGR E-01
Rev No : 0
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Governing Code/Standard : EN 15609-1
WPQR No : CGR E-01
Manufacturer : ÇAĞRI KAZAN
Welding Process : 111 (SMAW)
Joint Type : Butt Weld

Method of Prep. and Cleaning : Grinding/Brushing
Parent Material Designation : EN10025-2 S235JR
Parent Material Group (CR ISO 15608) : 1.1
Material Thickness (mm) : $3 \leq t \leq 24$
Outside Diameter (mm) : N/A
Welding Position : ALL

Weld Preparation Details (Sketch)*



Welding Details								
Run	Welding Process	Size of Filler Material (mm)	Current (A)	Voltage (V)	Current Type Polarity	Wire Feed Speed (mm/min)	Travel Speed (mm/min)	Heat Input (kJ/mm)
1 (Face I)	111	3.25	120 - 135	20 - 25	DC - SP	N/A	140 - 200	0,72 - 1,45
2 (Face I)	111	4.0	155 - 175	22 - 27	DC - SP	N/A	145 - 205	1,00 - 1,96
3 (Face I)	111	4.0	155 - 175	22 - 27	DC - SP	N/A	130 - 190	1,08 - 2,18
4 (Face I)	111	4.0	155 - 175	22 - 27	DC - SP	N/A	105 - 165	1,24 - 2,70
5 (Face II)	111	3.25	125 - 140	20 - 25	DC - SP	N/A	150 - 210	0,71 - 1,40
6 (Face II)	111	4.0	155 - 185	22 - 30	DC - SP	N/A	135 - 195	1,05 - 2,47

Filler material designation and make : EN 499 E 42 0 RR 12

Any Special Baking or Drying : N/A
Gas/Flux Shielding : N/A
Backing : N/A
Gas Flow Rate Shielding : N/A
Backing : N/A
Tungsten Electrode Type/Size : N/A
Details of Back Gouging/Backing : Grinding
Preheat Temperature : 27 °C
Interpass Temperature : 250 °C
Post-heating : N/A
Pre-heat maintenance temp. : N/A
Post-Weld Heat Treatment : N/A
Time, Temperature, Method : N/A
Heating and Cooling Rates* : N/A

Other information* :
Weaving (max. width of run) : N/A
Oscillation : N/A
Amplitude, Frequency, Dwell Time : N/A
Pulse Welding Details : N/A
Distance contact tube/work piece : N/A
Plasma Welding Details : N/A
Torch Angle : N/A

* if required

Manufacturer	Examiner or Examining Body
Çağrı Kazan Mak. Tes. San. Tic. Ltd. Şti. Ahmet Turan EROĞLU 23.02.2007	Bureau Veritas Göz. Hiz. Ltd. Şti. Firat UZER 23.02.2007