

Approved welding procedures

Pos.	WPQR No	WPS No	Technique		Material Group No				Qualification Range		P.W.H.T.	
									Thickness (mm)	Outside diameter (mm)		
												min.
1	2	First	Second	First	Sec.							
1	01 202 BG/V-040058	PP-001	141		SA 312 TP316	SA 312 TP316	8	8	2,5	5	7÷28	NO
2	01 202 BG/V-070130	PP-041	141		s 235	s 235	1.1.	1.1.	3	10	above 25	NO
3	01 202 BG/V-070131	PP-042	111		s 235	s 235	1.1.	1.1.	3	18	above 38	NO
4	01 202 BG/V-070153	PP-051	141		10CrMo9 10	10CrMo9 10	5.2.	5.2.	3	9	above 30	720 ± 20°C
5	01 202 BG/V-070154	PP-052	111		10CrMo9 10	10CrMo9 10	5.2.	5.2.	3	9	above 30	720 ± 20°C
6	01 202 BG/V-070155	PP-053	141	111	10CrMo9 10	10CrMo9 10	5.2.	5.2.	12,5	50	above 109,5	720 ± 20°C
7	01 202 BG/V-090142	PP-053a	141	111	10CrMo9 10	10CrMo9 10	5.2.	5.2.	6	24	above 302	720 ± 20°C
8	01 202 BG/V-090135	PP-054	141	111	15NiCuMoNb5	15NiCuMoNb5-	4.2.	4.2.	7	28	above 164	580 ± 10°C
9	01 202 BG/V-090137	PP-055	141	111	X10CrMoVNb9-1	X10CrMoVNb9-1	6.4.	6.4.	7,5	30	above 254	750 ± 10°C
10	01 202 BG/V-10007	PP-056	141		X10CrMoVNb9-1	X10CrMoVNb9-1	6.4.	6.4.	3	7,8	above 30	750 ± 10°C
11	01 202 BG/V-10022	PP-057	141		X10CrMoVNb9-1	X10CrMoVNb9-1	6.4.	6.4.	2	5,74	above 25	750 ± 10°C
12	01 202 BG/V-10023	PP-058	141		X10CrMoVNb9-1	SA 312 TP316L	6.4.	8	2	5,74	above 25	NO
13	01 202 BG/V-10181	PP-059	141		A 312 TP316	A 312 TP316	8	8	1	3	8÷32	NO
14	01 202 BG/V-10182	PP-060	141		A 312 TP316	A 312 TP316	8	8	1,4	4	above 25	NO