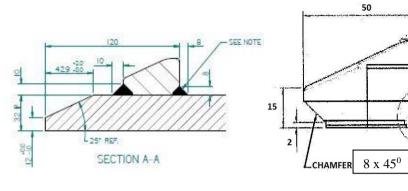
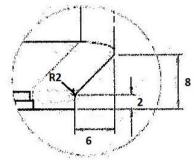
SANDVIK SHARK (G.E.T.) PRODUCT WELDING DOCUMENTATION

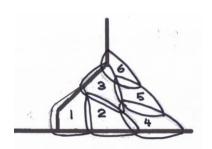
WELD PROCEDURE SPECIFICATION WPS: SS-005 REV: 1 DATE: 05/02/14

WELDING CODE: SANDVIK Drg. No. MD0032

Joint details: Compound 6mm x 45⁰ Bevel Butt and 8mm Fillet Weld on Rear Edge of Boss onto 32mm Lip Plate Compound 8mm x 45⁰ Bevel Butt and 10mm Fillet Weld on 2 sides and front edge of Boss onto 32mm Lip Plate







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Detail A: Joint Edge Preparation

Welding Sequence (bevel butt with 12mm fillet)

CLEANING: Wire brush or grind to achieve clean metal surface

PREHEAT: Preheat lip from 150°C to 250°C and maintain this temperature

TORCH SETUP: Face of contact tip must not be recessed within gas nozzle more than 5mm.

APPROACH ANGLE: Use PUSH TECHNIQUE with Torch Lead Angle of 5-10°C.

ARC STARTING: TOUCH START, run at constant speed and HOLD Welding Position for 2-4 secs after releasing trigger

Γ	Process	Wire	Gas	Gas Flow	Electrode		Material	Thickness	
		Diam	Shield	Rate	Classification		Qualified	mm	
	GMAW	0.9mm	Ar+16	16 L/min	AWS A5.18		BOSS SS2000	33	
			20%	(nozzle)	ER70S-6		LIP PLATE	32	
Γ			CO_2				Hardox 400/450		

WELDING DETAILS

The 6 weld runs to complete the bevel butt with 12mm fillet are to be made by running on at the rear corner, along one side, across the nose, and along the other side with run-out onto the lip plate surface.

Grinding of run-on and run-outs to clean metal surface to be done prior to commencing the welding of the bevel butt with 8mm fillet across the back of the boss. These welds are to be made by running on from the plate surface and running out onto the plate surface.

Grinding of run-on and run-outs to be done after completion of welding.

Weld Size	Pass No.	Pos	Amps	Volts	Polarity	Travel Speed mm/min	Heat Input kJ/mm
6 x 45°	1-3	2G					
8mm	4	2F				250 - 270	0.69 – 0.94
8×45^{0}	1 - 3	2G	130-150	24-26	DC+		
12mm	4 - 6	2F				230 -250	0.74 - 1.02

SANDVIK SHARK (G.E.T.) PRODUCT WELDING DOCUMENTATION

WELD PROCEDURE SPECIFICATION WPS: SS-005 REV: 1 DATE: 05/02/14

 $\overline{\mathbf{SECTION}} \, \overline{\mathbf{2.0}}$ WELDING SUPERVISION DATA **TESTING**

CONSUMABLE TREATMENT: Packaged spools in dry storage.

Spools on wire feeders to be dry

and free of dirt/dust.

Rusted wire to be discarded.

Remove weld spatter, silicate

patches and wire brush surface

Welder MUST visually examine weld to ensure absence of exposed porosity, absence of undercut, and to ensure that smooth transitions from weld face to material

surfaces have been achieved.

Refer WPOR-SS005

SECTION 3.0

POST-WELD TREATMENT:

PROJECT SPECIFIC DATA

CLIENT NAME: SANDVIK SHARK (G.E.T.)

APPROVATS

AIIKOVALS					
FABRICATOR:	FABRICATOR REPRESENTATIVE:	DATE:			
CLIENT: SANDVIK SHARK (G.E.T.)	NAME: MARTEN KARLSSON, ENG. MANAGER	DATE:			
THIRD PARTY: AWS(WA) - CONTRACTOR	NAME: IAN HENDERSON, IWE	DATE:			