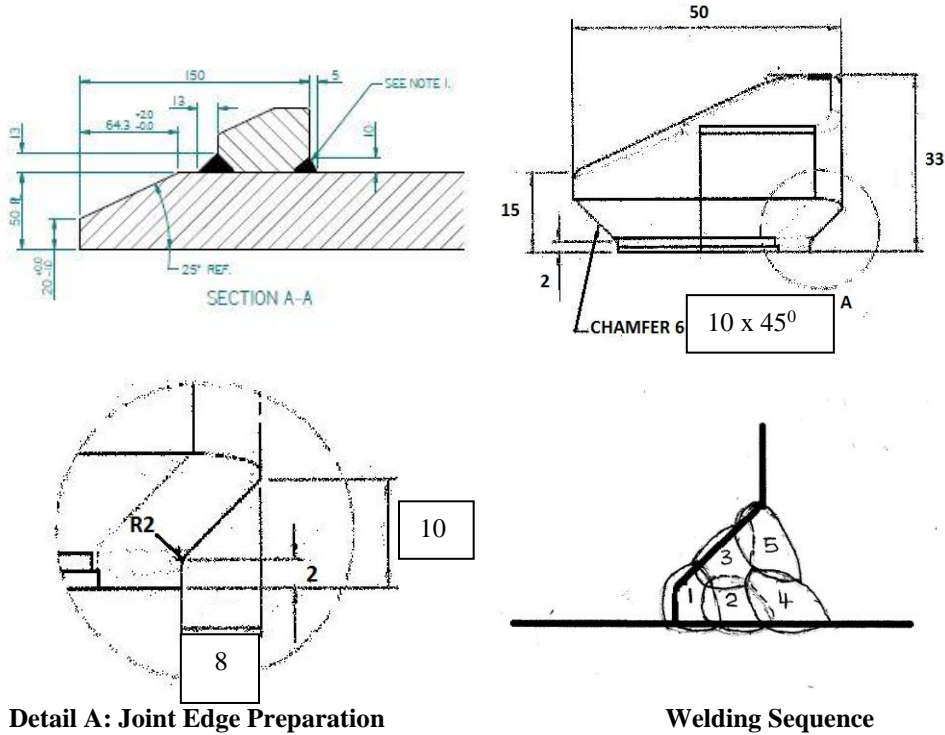


SANDVIK SHARK (G.E.T.) PRODUCT WELDING DOCUMENTATION

WELD PROCEDURE SPECIFICATION WPS: SS-006 REV: 0 DATE: 29/12/13

WELDING CODE: SANDVIK Drg. No. MD0007

Joint details: Compound 8mm x 45° Bevel Butt and 10mm Fillet Weld on 3 sides of Boss onto 50mm Lip Plate
Compound 10mm x 45° Bevel Butt and 12mm Fillet Weld on front edge of Boss onto 50mm Lip Plate



CLEANING: Wire brush or grind to achieve clean metal surface
PREHEAT: 70°C furnace heating of Boss and 150°C of Lip Plate before tack welding and joint welding
INTERPASS TEMPERATURE: Boss and Lip Plate temperature not to exceed 200°C.
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°.
ELECTRICAL STICKOUT (ESO): Maintain ESO at 18mm +2/-0
ARC STARTING: TOUCH START, run at constant speed and HOLD Welding Position for 2-4 secs after releasing trigger

Process	Wire Diam	Gas Shield	Gas Flow Rate	Electrode Classification	Material Qualified	Thickness mm
GMAW	1.2mm	Ar+16	16 L/min	AWS A5.18	BOSS	33
		20%	(nozzle)	ER70S-6	HARDOX	50
		CO ₂			400 / 450	

WELDING DETAILS

Weld Size	Pass No.	Pos	Amps	Volts	Polarity	Travel Speed mm/min	Heat Input kJ/mm
8 x 45°	1 - 3	2G	220-240	26-28	DC+	300 -320	1.07 – 1.34
10mm	4 - 5	2F					
10 x 45°	1 - 3	2G					
12mm	4 – 5 (6)	2F				250 - 290	1.18 – 1.61

SECTION 2.0 WELDING SUPERVISION DATA

CONSUMABLE TREATMENT: Packaged spools in dry storage .
 Spools on wire feeders to be dry and free of dirt/dust.
 Rusted wire to be discarded.
POST-WELD TREATMENT: Remove weld spatter, silicate patches and wire brush surface

TESTING

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 WPQR-SS005

SANDVIK SHARK (G.E.T.) PRODUCT WELDING DOCUMENTATION
WELD PROCEDURE SPECIFICATION WPS: SS-006 REV: 0 DATE: 29/12/13

SECTION 3.0

PROJECT SPECIFIC DATA

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

APPROVALS

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: