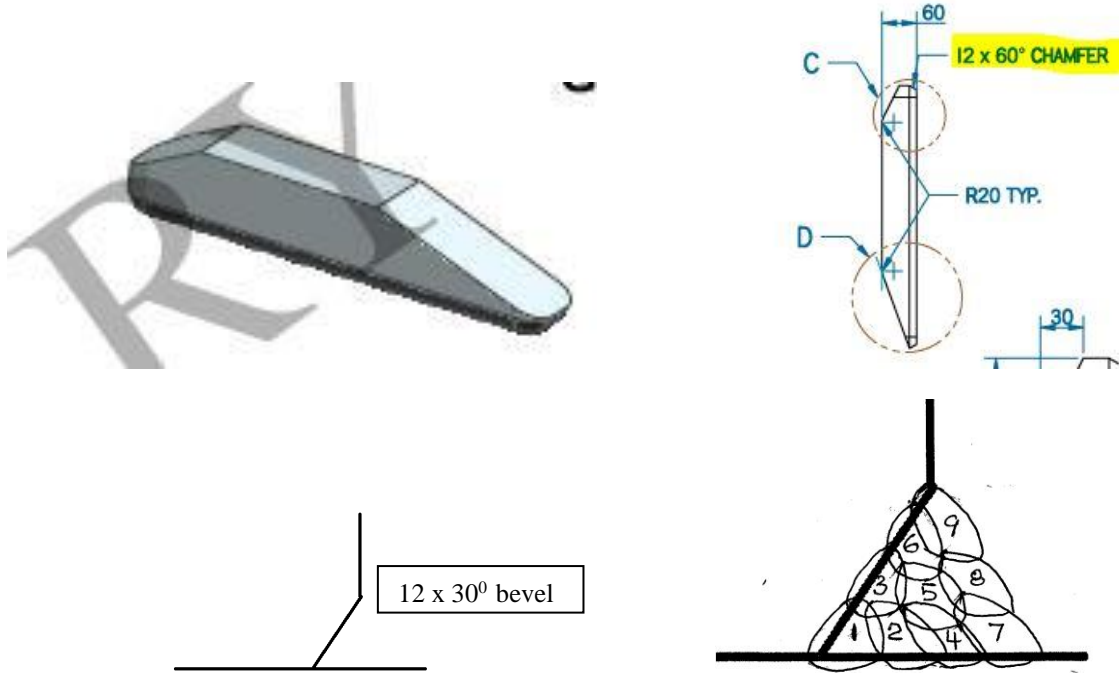


SANDVIK SHARK (G.E.T.) PRODUCT WELDING DOCUMENTATION

WELD PROCEDURE SPECIFICATION WPS: SS-009 REV: 0 DATE: 31/12/13

WELDING CODE: SANDVIK Drg. No. MD0111

Joint details: Compound 7mm x 60° Bevel Butt and 12mm Fillet Weld on 4 edges of Ramp Bars onto 32mm Lip Plate



Detail C: Joint Edge Preparation
No Root Gap permitted

Welding Sequence

CLEANING: Wire brush or grind to achieve clean metal surface
PREHEAT: 125°C of Lip Plate and Ramp Bar before tack welding and joint welding
INTERPASS TEMPERATURE: Ramp Bar 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	LIP PLATE	32
		20%	(nozzle)	ER70S-6	RAMP BAR	60
		CO ₂			HARDOX 400 / 450	

WELDING DETAILS

Weld Size	Pass No.	Pos	Amps	Volts	Polarity	Travel Speed mm/min	Heat Input kJ/mm
7 x 60°	1 - 6	2G	220-240	26-28	DC+	350 - 400	0.86 - 1.15
Butt							
12mm	7 - 9	2F					
Fillet							

SECTION 2.0

WELDING SUPERVISION DATA

TESTING

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

WELD PROCEDURE SPECIFICATION

WPS: SS-009 REV: 0 DATE: 31/12/13

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

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

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: