WPS Welding Procedure Specification

Sald Ok Mig. DP.	6/9/2005	15:31:11	172.18.1.101

06/09/05 15:31:11	06/09/05 15:31:58	00:00:47
0.09 Kwh	0.060 Kg	6.946 l

194 A	29.4 V	8.9 l/min	0.0 m/min	12.5 m/min

Info		
GENERAL INFO	COMPANY	Selco S.r.l
	Document Designer	Cristiano Serafin
	Approved	Franco Mela
	Specification n°	36
	Date	5/5/1994
	Revision n°	3
	Revision Date	8/7/1994
JOINT CONDITION	Part Name	Outer casing
	Base Metal	Low carbon steel (ST 52.3 DIN 17100)
	Base Metal Thickness	3 mm
	Type	T-Joint
	Preparation	Not Require
	N° of Passes	Single Pass
FILLER METAL	Type	Low carbon steel SG3
	Diameter	1.0 mm
GAS PROTECTION	Type	82% Argon 18% CO2
	Gas Flow	15 l/min
	Reverse Protection	Not require
WELDING CONDITION	Weld Process	Mig/Mag
	Welding Type	Semiautomatic
CONTROL	Test Required	Radiografic

1 **Fe-Ar 20%CO^2-1.0 mm**

06/09/05 15:31:11	06/09/05 15:31:58	00:00:47
0.09 Kwh	0.060 Kg	6.946 l

194 A	29.4 V	8.9 l/min	0.0 m/min	12.5 m/min

12.5 m/min	0.0 s	224 A	2.0 s	8.5 mm
29.5 + 0.0 V	399 + 0 A	84 + 0 A	186 + 0 Hz	50 %
2.0 s	0.0 V	0.08 s	50 %	

	MIN	MAX
A		
V		
l/min		
m/min		
Warning	Off	Off
Alarm	Off	Off

0.25 s

00:00:00.25	90.0 A	33.0 V	13.5 l/min	0.0 m/min	11.1 m/min
00:00:00.50	214.0 A	25.7 V	11.8 l/min	0.0 m/min	15.5 m/min
00:00:00.75	238.0 A	31.0 V	10.7 l/min	0.0 m/min	15.4 m/min
00:00:01.00	244.0 A	31.0 V	9.9 l/min	0.0 m/min	15.8 m/min
00:00:01.25	246.0 A	30.0 V	9.5 l/min	0.0 m/min	15.6 m/min
00:00:01.50	208.0 A	28.5 V	9.3 l/min	0.0 m/min	8.7 m/min
00:00:01.75	178.0 A	28.0 V	9.1 l/min	0.0 m/min	9.3 m/min
00:00:02.00	172.0 A	27.5 V	9.0 l/min	0.0 m/min	9.2 m/min
00:00:02.25	170.0 A	27.2 V	8.9 l/min	0.0 m/min	9.5 m/min
00:00:02.50	214.0 A	29.0 V	8.9 l/min	0.0 m/min	15.9 m/min
00:00:02.75	240.0 A	31.0 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:03.00	246.0 A	31.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:03.25	246.0 A	32.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:03.50	212.0 A	28.0 V	8.8 l/min	0.0 m/min	8.9 m/min
00:00:03.75	178.0 A	28.7 V	8.8 l/min	0.0 m/min	9.2 m/min
00:00:04.00	170.0 A	28.5 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:04.25	166.0 A	27.5 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:04.50	210.0 A	30.7 V	8.8 l/min	0.0 m/min	16.1 m/min
00:00:04.75	234.0 A	29.7 V	8.8 l/min	0.0 m/min	15.9 m/min
00:00:05.00	240.0 A	31.5 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:05.25	242.0 A	31.5 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:05.50	214.0 A	27.5 V	8.8 l/min	0.0 m/min	9.0 m/min
00:00:05.75	176.0 A	28.7 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:06.00	168.0 A	28.5 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:06.25	166.0 A	27.5 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:06.50	202.0 A	32.2 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:06.75	230.0 A	32.0 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:07.00	238.0 A	31.2 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:07.25	240.0 A	32.2 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:07.50	202.0 A	29.0 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:07.75	170.0 A	28.2 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:08.00	164.0 A	28.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:08.25	162.0 A	27.0 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:08.50	192.0 A	31.5 V	8.8 l/min	0.0 m/min	16.2 m/min
00:00:08.75	228.0 A	31.0 V	8.8 l/min	0.0 m/min	15.9 m/min
00:00:09.00	234.0 A	31.7 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:09.25	236.0 A	32.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:09.50	214.0 A	27.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:09.75	172.0 A	28.7 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:10.00	164.0 A	28.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:10.25	160.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:10.50	180.0 A	32.5 V	8.8 l/min	0.0 m/min	14.3 m/min
00:00:10.75	222.0 A	31.2 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:11.00	232.0 A	31.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:11.25	234.0 A	31.7 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:11.50	234.0 A	29.2 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:11.75	192.0 A	30.2 V	8.8 l/min	0.0 m/min	9.9 m/min
00:00:12.00	166.0 A	28.7 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:12.25	160.0 A	28.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:12.50	158.0 A	27.5 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:12.75	188.0 A	31.7 V	8.8 l/min	0.0 m/min	15.9 m/min
00:00:13.00	224.0 A	31.2 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:13.25	230.0 A	31.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:13.50	232.0 A	31.5 V	8.8 l/min	0.0 m/min	15.6 m/min

	220.0 A	23.7 V	8.8 l/min	0.0 m/min	9.8 m/min
	172.0 A	29.7 V	8.8 l/min	0.0 m/min	9.4 m/min
	160.0 A	28.0 V	8.8 l/min	0.0 m/min	9.2 m/min
	158.0 A	28.0 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:14.75	158.0 A	29.2 V	8.8 l/min	0.0 m/min	9.8 m/min
00:00:15.00	210.0 A	31.0 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:15.25	228.0 A	31.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:15.50	230.0 A	28.2 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:15.75	232.0 A	32.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:16.00	216.0 A	23.7 V	8.8 l/min	0.0 m/min	12.9 m/min
00:00:16.25	168.0 A	28.5 V	8.8 l/min	0.0 m/min	9.2 m/min
00:00:16.50	160.0 A	27.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:16.75	156.0 A	27.0 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:17.00	166.0 A	31.5 V	8.8 l/min	0.0 m/min	11.4 m/min
00:00:17.25	218.0 A	31.2 V	8.8 l/min	0.0 m/min	15.2 m/min
00:00:17.50	228.0 A	33.0 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:17.75	230.0 A	31.5 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:18.00	222.0 A	26.0 V	8.8 l/min	0.0 m/min	14.8 m/min
00:00:18.25	174.0 A	29.5 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:18.50	160.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:18.75	156.0 A	26.7 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:19.00	158.0 A	29.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:19.25	208.0 A	27.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:19.50	226.0 A	32.7 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:19.75	228.0 A	31.0 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:20.00	228.0 A	30.2 V	8.8 l/min	0.0 m/min	15.0 m/min
00:00:20.25	182.0 A	30.7 V	8.8 l/min	0.0 m/min	9.8 m/min
00:00:20.50	160.0 A	28.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:20.75	156.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:21.00	156.0 A	29.0 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:21.25	204.0 A	30.0 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:21.50	224.0 A	31.2 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:21.75	228.0 A	31.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:22.00	230.0 A	33.2 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:22.25	208.0 A	28.5 V	8.8 l/min	0.0 m/min	9.1 m/min
00:00:22.50	164.0 A	27.7 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:22.75	158.0 A	27.5 V	8.8 l/min	0.0 m/min	9.1 m/min
00:00:23.00	154.0 A	27.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:23.25	174.0 A	32.2 V	8.8 l/min	0.0 m/min	13.5 m/min
00:00:23.50	216.0 A	30.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:23.75	226.0 A	31.5 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:24.00	228.0 A	31.7 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:24.25	222.0 A	26.0 V	8.8 l/min	0.0 m/min	13.8 m/min
00:00:24.50	174.0 A	29.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:24.75	158.0 A	27.7 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:25.00	156.0 A	27.7 V	8.8 l/min	0.0 m/min	9.1 m/min
00:00:25.25	166.0 A	30.7 V	8.8 l/min	0.0 m/min	10.2 m/min
00:00:25.50	206.0 A	31.0 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:25.75	224.0 A	31.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:26.00	228.0 A	31.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:26.25	228.0 A	32.0 V	8.8 l/min	0.0 m/min	15.3 m/min
00:00:26.50	220.0 A	22.2 V	8.8 l/min	0.0 m/min	13.9 m/min
00:00:26.75	172.0 A	29.5 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:27.00	158.0 A	28.0 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:27.25	154.0 A	27.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:27.50	154.0 A	26.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:27.75	194.0 A	27.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:28.00	224.0 A	31.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:28.25	226.0 A	31.0 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:28.50	228.0 A	32.0 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:28.75	214.0 A	27.7 V	8.8 l/min	0.0 m/min	10.4 m/min
00:00:29.00	168.0 A	27.7 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:29.25	158.0 A	28.0 V	8.8 l/min	0.0 m/min	9.2 m/min
00:00:29.50	156.0 A	27.2 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:29.75	174.0 A	32.0 V	8.8 l/min	0.0 m/min	14.5 m/min
00:00:30.00	216.0 A	31.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:30.25	226.0 A	30.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:30.50	228.0 A	31.5 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:30.75	218.0 A	23.0 V	8.8 l/min	0.0 m/min	10.6 m/min
00:00:31.00	168.0 A	28.5 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:31.25	158.0 A	28.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:31.50	156.0 A	27.7 V	8.7 l/min	0.0 m/min	9.6 m/min
00:00:31.75	172.0 A	32.2 V	8.8 l/min	0.0 m/min	13.5 m/min
00:00:32.00	216.0 A	31.2 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:32.25	224.0 A	31.5 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:32.50	228.0 A	31.5 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:32.75	226.0 A	29.0 V	8.8 l/min	0.0 m/min	15.3 m/min
00:00:33.00	180.0 A	30.0 V	8.8 l/min	0.0 m/min	9.6 m/min
00:00:33.25	160.0 A	28.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:33.50	154.0 A	27.5 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:33.75	154.0 A	27.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:34.00	170.0 A	32.5 V	8.8 l/min	0.0 m/min	10.9 m/min
00:00:34.25	210.0 A	28.0 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:34.50	224.0 A	30.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:34.75	224.0 A	31.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:35.00	220.0 A	29.2 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:35.25	172.0 A	29.2 V	8.8 l/min	0.0 m/min	9.9 m/min
00:00:35.50	158.0 A	28.2 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:35.75	154.0 A	27.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:36.00	162.0 A	31.5 V	8.8 l/min	0.0 m/min	10.3 m/min
00:00:36.25	204.0 A	27.2 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:36.50	220.0 A	31.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:36.75	222.0 A	31.2 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:37.00	226.0 A	31.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:37.25	190.0 A	29.0 V	8.8 l/min	0.0 m/min	8.5 m/min
00:00:37.50	160.0 A	28.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:37.75	154.0 A	27.5 V	8.8 l/min	0.0 m/min	9.3 m/min
00:00:38.00	152.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:38.25	180.0 A	32.2 V	8.8 l/min	0.0 m/min	16.0 m/min
00:00:38.50	216.0 A	27.7 V	8.8 l/min	0.0 m/min	16.0 m/min
00:00:38.75	224.0 A	31.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:39.00	224.0 A	31.5 V	8.8 l/min	0.0 m/min	15.7 m/min
00:00:39.25	212.0 A	23.7 V	8.8 l/min	0.0 m/min	12.2 m/min
00:00:39.50	166.0 A	27.7 V	8.8 l/min	0.0 m/min	9.2 m/min
00:00:39.75	156.0 A	28.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:40.00	154.0 A	27.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:40.25	170.0 A	31.7 V	8.8 l/min	0.0 m/min	12.5 m/min
00:00:40.50	210.0 A	28.2 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:40.75	222.0 A	30.7 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:41.00	224.0 A	31.7 V	8.8 l/min	0.0 m/min	15.3 m/min
00:00:41.25	218.0 A	27.0 V	8.8 l/min	0.0 m/min	14.4 m/min
00:00:41.50	170.0 A	29.5 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:41.75	156.0 A	28.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:42.00	154.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:42.25	162.0 A	31.5 V	8.8 l/min	0.0 m/min	10.4 m/min
00:00:42.50	208.0 A	31.0 V	8.8 l/min	0.0 m/min	15.5 m/min
00:00:42.75	220.0 A	31.7 V	8.8 l/min	0.0 m/min	15.1 m/min
00:00:43.00	222.0 A	30.5 V	8.8 l/min	0.0 m/min	15.8 m/min
00:00:43.25	216.0 A	28.2 V	8.8 l/min	0.0 m/min	15.0 m/min
00:00:43.50	170.0 A	30.2 V	8.8 l/min	0.0 m/min	9.8 m/min
00:00:43.75	154.0 A	27.0 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:44.00	152.0 A	27.5 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:44.25	160.0 A	31.2 V	8.8 l/min	0.0 m/min	10.3 m/min
00:00:44.50	206.0 A	30.7 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:44.75	216.0 A	31.0 V	8.8 l/min	0.0 m/min	15.4 m/min
00:00:45.00	218.0 A	31.5 V	8.8 l/min	0.0 m/min	15.6 m/min
00:00:45.25	212.0 A	25.0 V	8.8 l/min	0.0 m/min	15.1 m/min
00:00:45.50	166.0 A	29.2 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:45.75	152.0 A	28.2 V	8.8 l/min	0.0 m/min	9.4 m/min
00:00:46.00	148.0 A	27.2 V	8.8 l/min	0.0 m/min	9.5 m/min
00:00:46.25	156.0 A	31.7 V	8.8 l/min	0.0 m/min	9.9 m/min