



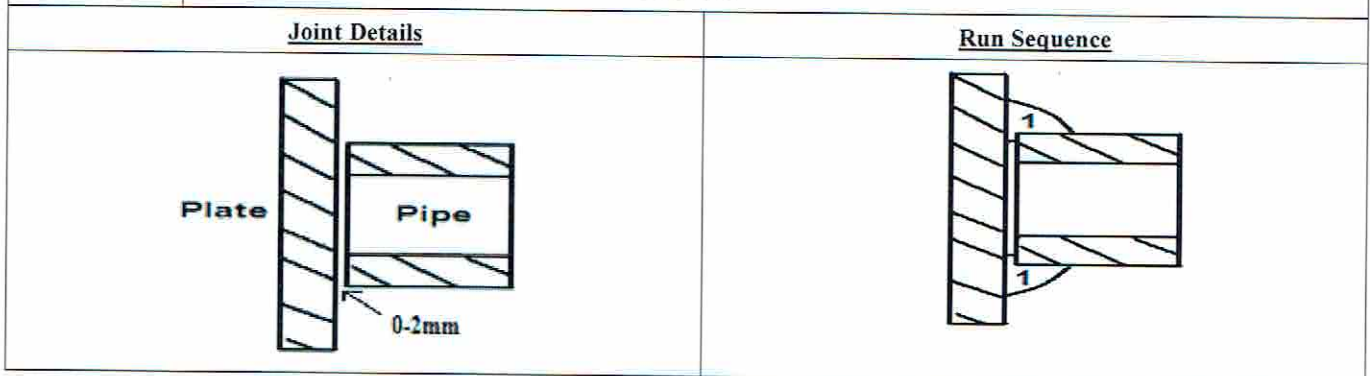
Weld Procedure Specification

WPS No: MDK 003

Supporting PQR(s).	MDK 003		
ELEMENT Reference No.	EPQ 84319		
Welding Specifications.	ASME IX:2015		
Joint Type(s) Qualified.	Single & Multi Run Fillet Welds		
Material(s) Tested.	API 5L X52 pipe	To	BS4360:1986 50DD plate
Material(s) Group No.	P no.1 Group no.1	To	Unclassified
Dimensions Tested.	2" Sch XS (5.54mm w/t)	To	10mm
Thickness Range Qualified.	All		
Fillet Size Qualified.	All		
Diameter Qualified.	All		
Position Qualified.	All		
Progression Qualified.	All except Vertical Down		
Welding Process.	SMAW – Shielded Metal Arc Welding		
Preheat Method / Control.	Ambient moisture free/Digital Thermometer		
Preheat Temperature.	Ambient (20°C)		
Interpass Temperature.	195°C		
Heat Treatment.	N/A (as welded)		
Stringer Bead / Weave.	Stringer Bead		

Run No	Welding Process	Filler Make	Trade Name	Dia (mm)	Spec (AWS)	Grade	AC/DC	Amps (A)	Volts (V)	Travel Speed (mm/sec)	Heat Input (KJ/mm)
All	SMAW	ESAB	FILARC 565	3.2	AWS A5.1	E7016-1 H4 R	DC+VE	101 - 109	22.1-24.0	1.1-1.6	1.6-2.1

Notes: Consumable to be stored as per manufacturers instructions.



Element Aberdeen
Date

A. Rude
31/05/2017

Client Representative
Date



Weld Procedure Qualification Record

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Company: MDK Fabrications

ELEMENT Ref: EPQ 84319

Weld Procedure (PQR No): MDK 003

Welding Date: 26/05/2017

Specification: ASME IX:2015

Joint Type: Single Run Fillet Weld

Welder(s): Mark Kelman

ADDITIONAL INFORMATION

Material: API 5L X52
Dimensions: 2" Sch XS (5.54mm w/t)
Cast No: 53504

Material: BS4360:1986 50DD
Dimensions: 10mm thick plate
Cast No: 48698C1

Consumable: ESAB FILARC 56S
Size: 3.2mm
Spec / Grade: AWS A5.1 : E7016-1 H4 R
Lot No: SB541234

NOTES:

Consumables were clean / dry and stored in accordance with manufacturers instructions.

ELEMENT ABERDEEN

CLIENT AUTHORITY

Signed: A. Rude

Signed: _____

Date: 31/05/2017

Date: _____