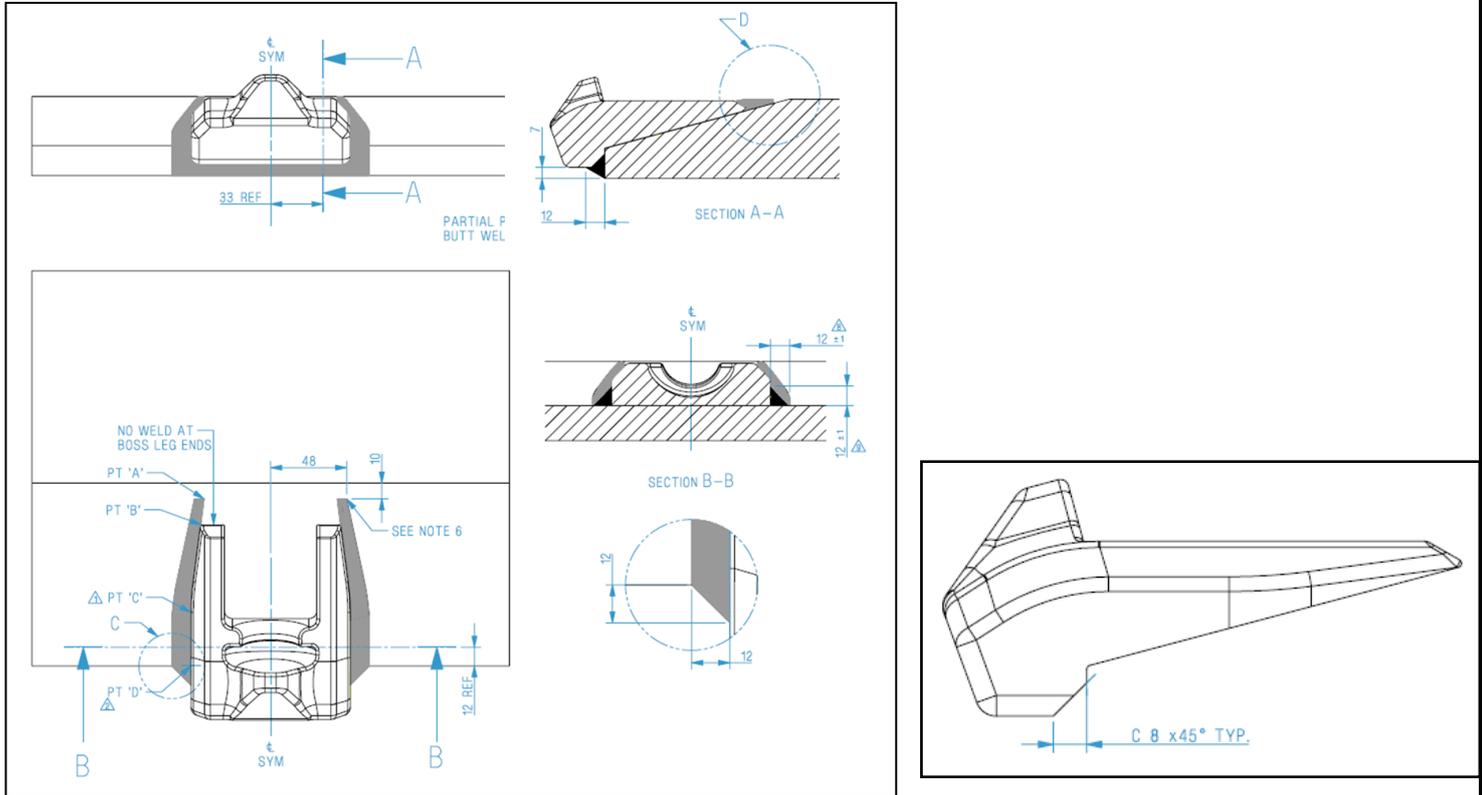


WELDING CODE: SANDVIK WELD Drawing # BU00037748

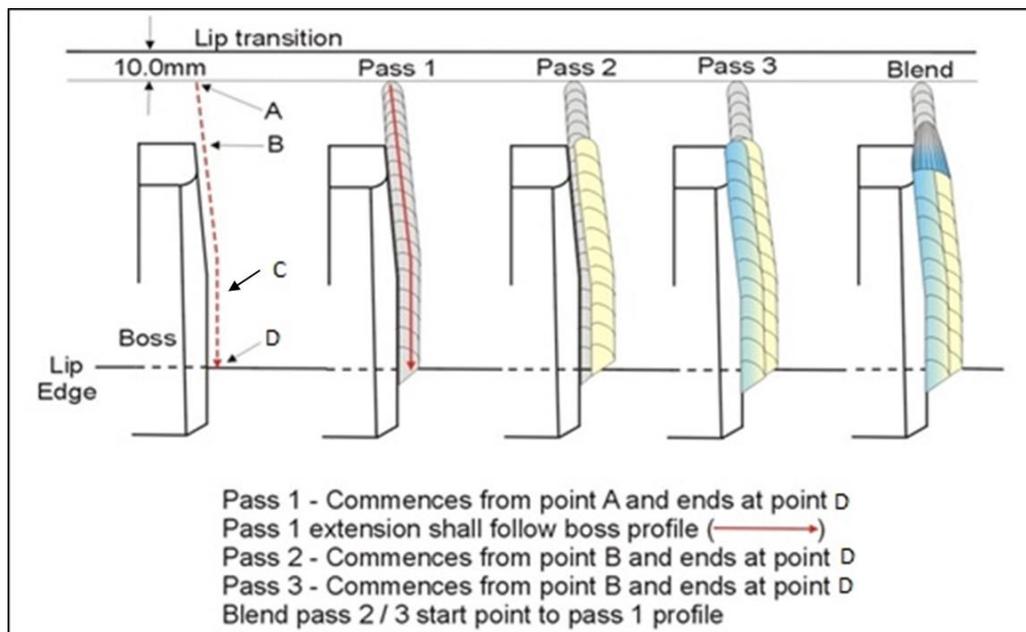
: SANDVIK WELD Procedures # PWP001 & PWP0021

SECTION 1.0 WELD DETAILS

**Joint details : Compound 8mm x 45° Bevel Butt and 12mm Partial Penetration Butt Weld on one side of Boss onto 50mm Lip Plate.
: Compound 12mm Fillet Weld on two sides of Boss onto 50mm Lip Plate.**



Weld position dimensions. Refer BU00037748 Refer to



and to MAKO Boss. BC00003429

Weld Procedure Specification(WPS)

Mako Boss to suit 50mm plate lip

WELD PROCEDURE. REFER TO PWP001

CLEANING	: Wire brush or grind to achieve clean metal surface
PREHEAT:	: 150°C (302°F) measured at least 75mm (3") either side of the weld joint or the area being gouged.
INTER PASS TEMPERATURE:	: 150-250°C (302-482°F) maintained at least 75mm (3") either side of the weld joint or the area being gouged.
TORCH SETUP:	: Face of contact tip must not be recessed within gas nozzle more than 5mm.
APPROACH	: 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.

WELD EQUIPMENT. REFER TO PWP001

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% CO ₂	(nozzle)	ER70S-6	HARDOX		50	
						400 / 450		
Weld Size	Pass No.	Pos		Amps	Volts	Polarity	Travel Speed mm/min	Heat Input kJ/mm
8 x 45°	1	2G		220-240	26-28	DC+	300 -320	1.07 – 1.34
12mm	1	2G						
12mm	1 - 3	2F						

<u>SECTION 2.0</u>	<u>WELDING SUPERVISION DATA</u>	<u>TESTING</u>
CONSUMABLE TREATMENT	Packaged spools in dry storage Spools on wire feeders to be dry and free of dirt/dust Rusted wire to be discarded.	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
POST-WELD REATMENT:	Remove weld spatter, silicate patches and wire brush surface.	

<u>SECTION 3.0</u>	<u>PROJECT SPECIFIC DATA</u>
	CLIENT NAME: SANDVIK SHARK (G.E.T.)

<u>APPROVALS</u>		
FABRICATOR:	NAME:	DATE:
CLIENT: SANDVIK SHARK (G.E.T.)	NAME:	DATE:
THIRD PARTY:	NAME:	DATE: