

Contents

1	Foreword	5
2	Scope	6
3	Welding Processes	7
3.1	Metal-arc Active Gas shielded (MAG) welding with solid wire (Process 135)	7
3.2	Metal-arc Active Gas shielded (MAG) welding with flux cored wire (Process 136)	8
3.3	Manual Metal Arc (MMA) welding (Process 111)	10
4	Developments in Power Source Technology	12
5	Welding High Strength Steels	13
6	Typical Welding Procedures	15
6.1	Introduction	15
6.2	Basis of the system	15
6.3	Qualification of Welding Procedure Specifications to BS EN ISO 15614-1	15
6.4	How to use this document for qualification of solid wire MAG welding	16
7	Preliminary Welding Procedure Specifications (pWPS)	17
7.1	pWPS sheets	17
8	Qualification of Welding Procedure Specifications	40
8.1	Introduction	40
8.2	Fillet welds	40
8.3	Butt welds	40
8.4	Examination and testing	41
9	Typical Welding Procedure Specifications	42
10	References	93
	Appendix A – Calculation of preheating requirements	94
	Appendix B – Typical Welding Procedure Qualification Record	95
	Record of Weld Test	96
	Test Results	97