## Contents

1. Introduction ......................................................... 4
2. Advantages and disadvantages of high strength steels .................. 4
3. Manufacturing process routes ...................................... 6
4. Specifications, available grades and product types .................. 8
5. Welding Metallurgy ................................................... 9
6. Consumable standards, storage, handling and selection: ............ 13
7. Fabrication / welding procedures (thermal cutting, heat treatment, etc.) .................. 15
8. Considerations prior to welding .................................... 16
9. Development & qualification of welding procedures .................. 17
10. Future developments ............................................... 18

Appendix A: Understanding the Metallurgy of Iron and iron-carbon alloys ........... 19
Appendix B: Welding Processes ........................................ 22
Appendix C: Typical Welding Procedure Specifications for Grade S460K2W Steel ........ 26
Appendix D: Typical Welding Procedure Specifications for Grade S460 QST Steel .......... 29
Appendix E: Typical Welding Procedure Specifications for Grade S460N Steel ............ 31

References: ..................................................................... 32