

**BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL VALVES PLANT, GOINDWAL**

WELDING PROCEDURE SPECIFICATION

WPS NO. : W002 DATED : 19/09/2000
Rev. no. : 00

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REF (TRICHY WPS NO: A.1.1.19/02 DT 22/02/91)
(SUPPORTING PQR NO: 517)

WELDING PROCESS : SMAW ,

TYPE : MANUAL

APPLICATION : Weld repairs on carbon steel valve castings.

Base metal : Carbon Steel.
Fillet Cavity Design : As per sketch or production requirement.
String or weaving bead : String or weave (3 dia max)
Initial and inter-pass cleaning : Brushing/chipping/grinding.
Electrode class : AWS NO. : E 7018
Current polarity : AC or DC Reverse Polarity

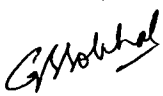
Current characteristics :

Filler dia : 3.15 mm : 100- 140 amp
Filler dia 4.00 mm : 150 - 180 amp
Filler Dia 5.00 mm : 200 - 250 amp

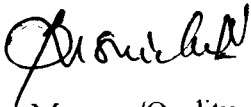
Weld progression : Vertical up

PRE-HEAT

Pre-heat temperature : 100 - 150 deg. Centi.
Intrr-pass temperature : 300 deg. Centi.
Post weld heat treatment : Stress Relieving at 600 deg. C
Time range @ Hr/25mm Section thickness.


Engineer/ Quality
(Prepared By)

CONTROLLED COPY


Manager/Quality
(Approved By)