

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

WELDING PROCEDURE SPECIFICATION

WPS NO. : W006
REV. : 00

DATED : 19.09.2000

REF (TRICHY WPS NO: S.1H.02/01 DT 26/02/94)
(SUPPORTING PQR NO: 776)

WELDING PROCESS : SUB-MERGED ARC WELDING (HARD FACING)

TYPE : SEMI-AUTO

**APPLICATION : HARD FACING OF VALVE COMPONENTS/WEDGES
Cr/Cr- Ni Corrosion Resistant Over lay using E430 & E410 Wires.**

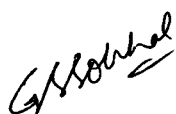
Base Metal : Carbon Steel (ASTM : A 216 WCB) WEDGES
Joint Design : As per Drawing /Production Requirement
Thickness of hard facing : 2mm + 2mm

Electrode/Wire : ER 430, as a buffer layer
ER 410 , as final layer
Specification No. (SFA) : 5.9

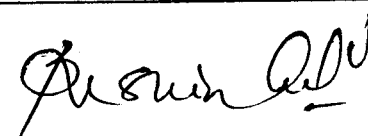
PRE-HEAT TEMP : 150 deg. C (Min.) (Use thermal chalk to check)
Inter-pass temp. : 400 deg. C (Max)
Post Weld Heat Treatment : Nil

CURRENT CHARACTERISTICS :

Weld layer	Process	Filler Wire	Current (amp)	Volts(V)
1 st layer	SAW	ER 430	300-340 (DCEP)	30-36
2 nd layer	SAW	ER410	300-340 (DCEP)	30-36


Engineer/ Quality
(Prepared By)

CONTROLLED COPY


Manager/Quality
(Approved By)
