

Product code	WPS number	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Pipe outside diameter (mm)	Welding position	Weld details	Throat thickness (mm)	Shielding gas
135/135 Butt welds, tube and plate, material group 8.1 (stainless steel)												
99904357	WPS 135-BW-T8-1	135	T	BW	8.1	135: EN ISO 14343 G 19 12 3 Lsi 136: ISO 17633-A T19 12 3 L P M 1	3...4,6	≥ 28,5	PA	sl, nb/mb		M12
99904358	WPS 135-BW-T8-2	135	T	BW	8.1		3...4,6	≥ 28,5	PC	sl, nb/mb		M12
99904359	WPS 135-BW-T8-3	135	T	BW	8.1		3...4,6	≥ 28,5	PH	sl, nb/mb		M12
99904360	WPS 135-BW-T8-4	135	T	BW	8.1		3...4,6	≥ 28,5	H-L045	sl, nb/mb		M12
99904361	WPS 135-136-BW-T8-1	135/136	T	BW	8.1		nb 5...8 / mb 3...5	≥ 31	PA	ml nb/sl mb		M12/M21
99904362	WPS 135-136-BW-T8-2	135/136	T	BW	8.1		nb 5...8 / mb 3...5	≥ 31	PC	ml nb/sl mb		M12/M21
99904363	WPS 135-136-BW-T8-3	135/136	T	BW	8.1		nb 5...8 / mb 3...5	≥ 31	PH	ml nb/sl mb		M12/M21
99904364	WPS 135-136-BW-T8-4	135/136	T	BW	8.1		nb 5...8 / mb 3...5	≥ 31	H-L045	ml nb/sl mb		M12/M21
99904365	WPS 135-136-BW-T8-5	135/136	T	BW	8.1		nb 5...20 / mb 5...14	≥ 30	PA	ml, ss/bs, nb		M12/M21
99904366	WPS 135-136-BW-T8-6	135/136	T	BW	8.1		nb 5...20 / mb 5...14	≥ 30	PC	ml, ss/bs, nb		M12/M21
99904367	WPS 135-136-BW-T8-7	135/136	T	BW	8.1		nb 5...20 / mb 5...14	≥ 30	PH	ml, ss/bs, nb		M12/M21
99904368	WPS 135-136-BW-T8-8	135/136	T	BW	8.1		nb 5...20 / mb 5...14	≥ 30	H-L045	ml, ss/bs, nb		M12/M21
99904417	WPS 135-FW-P8-1	135	P	FW	8.1		6...24		PA, PB, PC	sl		M12

135: Filler material that comply with the classification above can be used, such as Elga Cromamig 316LSi.

136: Filler material that comply with the classification above can be used, such as Elga Cromacore DW 316LP. We have carried out impact toughness tests.

111 Butt welds, tube, material group 1.1/1.2/1.4												
99904369	WPS 111-BW-T-1	111	T	BW	1.1/1.2/1.4	EN ISO 2560-A E 42 5	3...4,6	≥ 29,5	PA	sl, nb/mb		
99904370	WPS 111-BW-T-2	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	PC	sl, nb/mb		
99904371	WPS 111-BW-T-3	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	PH	sl, nb/mb		
99904372	WPS 111-BW-T-4	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	H-L045	sl, nb/mb		
99904373	WPS 111-BW-T-5	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PA	ml, ss, nb/mb		
99904374	WPS 111-BW-T-6	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PC	ml, ss, nb/mb		
99904375	WPS 111-BW-T-7	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PH	ml, ss, nb/mb		
99904376	WPS 111-BW-T-8	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	H-L045	ml, ss, nb/mb		

111: Filler material that comply with the classification above can be used, such as Elga P 48M. We have carried out impact toughness tests.

111 Butt welds, tube, material group 8.1 (stainless steel)												
99904377	WPS 111-BW-T8-1	111	T	BW	8.1	EN 1600 E 19 12 3 L R 11	3...4,6	≥ 28,5	PA	sl, nb/mb		
99904378	WPS 111-BW-T8-2	111	T	BW	8.1		3...4,6	≥ 28,5	PC	sl, nb/mb		
99904379	WPS 111-BW-T8-3	111	T	BW	8.1		3...4,6	≥ 28,5	PH	sl, nb/mb		
99904380	WPS 111-BW-T8-4	111	T	BW	8.1		3...4,6	≥ 28,5	H-L045	sl, nb/mb		
99904381	WPS 111-BW-T8-5	111	T	BW	8.1		5...20	≥ 30	PA	ml, ss, nb/mb		
99904382	WPS 111-BW-T8-6	111	T	BW	8.1		5...20	≥ 30	PC	ml, ss, nb/mb		
99904383	WPS 111-BW-T8-7	111	T	BW	8.1		5...20	≥ 30	PH	ml, ss, nb/mb		
99904384	WPS 111-BW-T8-8	111	T	BW	8.1		5...20	≥ 30	H-L045	ml, ss, nb/mb		

111: Filler material that comply with the classification above can be used, such as Elga Cromacore 316LP. We have carried out impact toughness tests.

Kempfi reserves the right to change the specification of the product described at any time without prior notice.

Product code	WPS number	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Pipe outside diameter (mm)	Welding position	Weld details	Throat thickness (mm)	Shielding gas
135 Butt and fillet welds, plate and plate/tube, material group 1.1/1.2/1.4												
99904385	WPS 135-FW-13	135	P	FW	1.1/1.2/1.4	EN ISO 14175 G 3 Si1	3...12		PA, PB, PC	sl	3...5	M21
99904386	WPS 135-FW-14	135	P	FW	1.1/1.2/1.4		3...12		PD	sl	3...5	M21
99904387	WPS 135-FW-15	135	P	FW	1.1/1.2/1.4		3...12		PF	sl	3...5	M21
99904388	WPS 135-FW-16	135	P	FW	1.1/1.2/1.4		6...24		PA, PB, PC	ml	no restriction	M21
99904389	WPS 135-FW-17	135	P	FW	1.1/1.2/1.4		6...24		PD	ml	no restriction	M21
99904390	WPS 135-FW-18	135	P	FW	1.1/1.2/1.4		6...24		PF	ml	no restriction	M21
99904391	WPS 135-FW-PG-1	135	P	FW	1.1/1.2/1.4		2,1...6		PG	sl	2,2...4,5	M21
99904392	WPS 135-FW-UK-2	135	P	FW	1.1/1.2/1.4		3...12		PA, PB, PC	sl	3...6	M26
99904393	WPS 135-BW-UK-2	135	P	BW	1.1/1.2/1.4		2,1...3,9		PA	sl nb/mb		M26
99904394	WPS 135-FW-PT-1	135	P/T	FW	1.1/1.2/1.4		P: ≥ 5/T: 3,2...12,6	≥ 30,2	PA, PB	sl	3...5	M21
99904395	WPS 135-FW-PT-2	135	P/T	FW	1.1/1.2/1.4		P: ≥ 5/T: 3,2...12,6	≥ 30,2	PD	sl	3...5	M21
99904396	WPS 135-FW-PT-4	135	P/T	FW	1.1/1.2/1.4		P: ≥ 5/T: 3,2...12,6	≥ 30,2	PA, PB	ml	no restriction	M21
99904397	WPS 135-FW-PT-5	135	P/T	FW	1.1/1.2/1.4		P: ≥ 5/T: 3,2...12,6	≥ 30,2	PD	ml	no restriction	M21
99904415	WPS 135-FW-PT30-1	135	P/T	FW	1.1/1.2/1.4		P:3...12/T: 3,2...12,6	≥ 30,2	PA, PB, PC	sl	3...5	M21
99904416	WPS 135-FW-PT30-2	135	P/T	FW	1.1/1.2/1.4		P:3...12/T: 3,2...12,6	≥ 30,2	PD	sl	3...5	M21

135: Filler material that comply with the classification above can be used (G3Si1).