

## Univeral WPS for pipe to plate fillet welding (6800009)

### Pipe to plate fillet welding (process 135)

WPS number	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Pipe outside diameter (mm)	Welding position	Weld types	Throat thickness (mm)	Shielding gas
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#### 135 Butt and fillet welds, plate and plate/tube, material group 1.1/1.2/1.4

WPS 135-FW-PT-1	135	P/T	FW	1.1/1.2/1.4	EN ISO 14175 G3 Si1	P: $\geq 5$ /T: 3,2...12,6	$\geq 30,2$	PA, PB	sl	3...5	M21
WPS 135-FW-PT-2	135	P/T	FW	1.1/1.2/1.4		P: $\geq 5$ /T: 3,2...12,6	$\geq 30,2$	PD	sl	3...5	M21
WPS 135-FW-PT-4	135	P/T	FW	1.1/1.2/1.4		P: $\geq 5$ /T: 3,2...12,6	$\geq 30,2$	PA, PB	ml	ei rajoitusta	M21
WPS 135-FW-PT-5	135	P/T	FW	1.1/1.2/1.4		P: $\geq 5$ /T: 3,2...12,6	$\geq 30,2$	PD	ml	ei rajoitusta	M21
WPS 135-FW-PT30-1	135	P/T	FW	1.1/1.2/1.4		P:3...12/T: 3,2...12,6	$\geq 30,2$	PA, PB, PC	sl	3...5	M21
WPS 135-FW-PT30-2	135	P/T	FW	1.1/1.2/1.4		P:3...12/T: 3,2...12,6	$\geq 30,2$	PD	sl	3...5	M21

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