

Universal WPS for stainless steel (6800007)

Stainless steel welding (process 111, 135, 136)

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)											
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 M1"	3...4,6	≥ 28,5	PA	sl, nb/mb		M12
WPS 135-BW-T8-2	135	T	BW	8.1		3...4,6	≥ 28,5	PC	sl, nb/mb		M12
WPS 135-BW-T8-3	135	T	BW	8.1		3...4,6	≥ 28,5	PH	sl, nb/mb		M12
WPS 135-BW-T8-4	135	T	BW	8.1		3...4,6	≥ 28,5	H-L045	sl, nb/mb		M12
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
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
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
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
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
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
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
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
WPS-135-FW-PB-1	135	P	FW	8.1		6...24		PA, PB, PC	sl		M12

111 Butt welds, tube, material group 8.1 (stainless steel)											
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		
WPS 111-BW-T8-2	111	T	BW	8.1		3...4,6	≥ 28,5	PC	sl, nb/mb		
WPS 111-BW-T8-3	111	T	BW	8.1		3...4,6	≥ 28,5	PH	sl, nb/mb		
WPS 111-BW-T8-4	111	T	BW	8.1		3...4,6	≥ 28,5	H-L945	sl, nb/mb		
WPS 111-BW-T8-5	111	T	BW	8.1		5...20	≥ 30	PA	ml, ss, nb/mb		
WPS 111-BW-T8-6	111	T	BW	8.1		5...20	≥ 30	PC	ml, ss, nb/mb		
WPS 111-BW-T8-7	111	T	BW	8.1		5...20	≥ 30	PH	ml, ss, nb/mb		
WPS 111-BW-T8-8	111	T	BW	8.1		5...20	≥ 30	H-L945	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.