ASME WELDING PROCEDURE SPECIFICATION LIST

Apr 02 '15, Rev-1

NO.	Process	WPS NO.	Base Metal				Base Metal Type	Base Metal Thickness (mm)	Weld Metal Thickness (mm)				PWHT (℃)	Impact test Temp. (℃)	AWS Class	Preheat Temp (℃)	Interpass Temp (℃)	Brand Name	Remarks
			P No.	Gr. No.	P No.	Gr. No.			GTAW	FCAW	SMAW	SAW							
1	GTAW	DH-GT-1.1-001	1	1,2	1	1,2	Carbon Steel	1.5 ~ 20	20	-	-	-	No	No	ER70S-6	16	250	ST-50.6, Hyundai	"U"
2	GTAW	DH-GT-10H.10H-001 (I)	10H	1	10H	1	SuperDuplex	8 ~ 16	16	-	-	-	No	-50	ER2594	16	100	25.10.4.L, Sandvik	No "U"
3	GTAW	DH-GT-8.8-001 (I)	8	1	8	1	Stainless Steel	10 ~ 20	20	-	-	-	No	-20	ER308	16	150	ANY	"U"
4	GTAW	DH-GT-8.8-002	8	1	8	1	Stainless Steel	1.5 ~ 20	20	-	-	-	No	No	ER316	16	150	ANY	"U"
5	GTAW	DH-GT-8.8-003	8	1	8	1	Stainless Steel	1.5 ~ 20	20	-	-	-	No	No	ER316L	16	150	ANY	"U"

DAEHAN INSTRUMENT CO., LTD.
DATE: Apr 02 '15
WITNESS REVIEW
QM DEPT