



Welding Procedure Specification



WPS No: 269 R2	WPQR No: 269 R0	Date: 28/05/2026
Fabricator: SRG Global	Project: ALL	Job No: ALL

Essentials	Material Details
Standard: AS3992:2020 / ASME IX:2023	Material Group: P1-P1
Process: GTAW	Thickness Range (butt): 1.5mm - 17.12mm
Progression: Up	Thickness Range (fillet): All
Joint Type: Butt, Welded Single Side Butt, Welded Both Sides, Fillet Welds	Diameter Range: All

Consumable Details	Joint Parameters
Consumable Class: AWS ER70S-4	Root Gap(g): 1.5-3mm
Consumable Class: -	Root Face (f): 0-1.5mm
Shielding Gas Type: Argon 99.9 %*	Groove Angle (α): 60°-70°
Purging Gas Type: Argon 99.9 %*	

Welding Technique & Preparation	Joint Preparation
Preparation Method: Machined / Ground	
Interpass Cleaning: Grind/Wire Brush	
Max Bead Width: 8-11mm	
Stringer/Weave: Weave	
Arc Transfer: Not applicable	
Electrical Stick out: Not applicable	
Gas Lens/Nozzle Size: 13mm	
Tungsten: 2.4mm Thoriated	

Thermal Treatment	Welding Sequence
Preheat Minimum: See note 3 & 4	
Preheat Method: LPG / Air Torch	
Temperature Check: Crayon/Laser	
Interpass Maximum: 240°C	
Post Weld Treatment: Not applicable	

Pass No	Side	Position	Process	Polarity	Electrode/Wire		Gas/Flux		Amperage Range	Voltage Range	Travel Speed mm/min	Heat Input Kj/mm
					Class	Size mm	Type	L/min				
1	1	All	GTAW	DC-	ER70S-4	2.4	Argon*	≥15.5	98-118	11.3-12.7	24-31	3.02-3.78
2	1	All	GTAW	DC-	ER70S-4	2.4	Argon*	≥15.5	131-158	11.3-12.7	73-95	1.33-1.66
3	1	All	GTAW	DC-	ER70S-4	2.4	Argon*	≥15.5	140-169	12.7-14.3	78-101	1.50-1.88
4+	1	All	GTAW	DC-	ER70S-4	2.4	Argon*	≥15.5	119-143	12.2-13.8	65-85	1.03-1.82

Notes:

- This procedure was produced by Asset Reliability Inspections. The fabricator named above has approval for full usage of this procedure
- A2 to A2 material is acceptable as per AS3992 Table 5.2 Note 2 A.
- Preheat A1 Material COMBINED THICKNESS ≤12mm 0°; >12≤25mm 20°;
- Preheat A2 Material COMBINED THICKNESS ≤12mm 20°; >12≤25mm 50°;
- Number of welding runs will change depending on material thickness

Written/Approved By:	Fabricator:	Client/Third Party:
Francois Engelbrecht AS1796 Certificate 10 & 11 AS2214 Welding Supervisor IIW Welding Diploma (S)	Accepted By: Pau Berry Signature: Date: 28/05/26	Approved By: Signature: Date: