

QUALITY ASSURANCE AND QUALITY CONTROL
WPS/PQR QUALIFICATION LIST for AUTO-WELDING

S.No	Materials			Material Verification	Weld Process	WPS / PQR No.	Electrode / Wire							
	Base Mat.	Grade	Size (mm)				Manufacturer	Brand	Dia. (mm)	AWS Class	F.No			
1 - 1	CS	APL 5L X52	6" SCH160 (18.26mm)	Verified	GTAW + SAW	GT/SAW-P002-01 / PP-GTSA-PNO01-002	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6			
1 - 2							OERLIKON	OE-SD3 / OP121 TT	2.4	F7A8-EH12K	6			
					1 - 3	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6				
1 - 4						OERLIKON	OE-SD3 / OP121 TT	2.4	F7A8-EH12K	6				
					2 - 1	SS	ASTM A312 TP 316L	Verified	GTAW	GTAW-P053-01 / PP-GTGT-PNO08-053	REVOLLOY	Revofil 316L	1.2	ER316L
2 - 2											GTAW + SAW	GT/SAW-P001-01 / PP-GTSA-PNO08-001	REVOLLOY	Revofil 316L
					OERLIKON				OE-316L / OP-F500	2.4			ER316L	6
2 - 3					GMAW (RMD) + SAW				GM/SAW-P002-01 / PP-GMSA-PNO08-002	REVOLLOY	Revofil 316L	1.2	ER316L	8
	OERLIKON	OE-316L / OP-F500	2.4	ER316L						6				
3 - 1	DSS	ASTM A790 S 31803	6" (14.27mm)	Verified	GTAW				GTAW-P054-01 / PP-GTGT-PNO10H-054	SANDVIK	W22.8.3.L	1.2	ER2209	6
3 - 2						GTAW + SAW	GT/SAW-P003-01 / PP-GTSA-PNO10H-003	SANDVIK		W22.8.3.L	1.2	ER2209	6	
					SANDVIK			W22.8.3.L / 15W	2.4	ER2209	6			
4 - 1	Alloy Steel	ASTM A519 Gr 4130	6" SCH XXS (21.95mm)	Verified	GTAW + SAW	GT/SAW-P004-01 / PP-GTSA-PNO01-004	REVOLLOY	Revofil 1NiMo SR	1.2	ER 100S-G	6			
4 - 2							GTAW + GMAW	GT/GMAW-P003-01 / PP-GTGM-PNO01-003	OERLIKON	OE-SD2 1NiCrMo / OP120TT	2.4	F10P4-EG-G	6	
					REVOLLOY	Revofil 1NiMo SR			1.2	ER 100S-G	6			
4 - 3					REVOLLOY	Revofil 1NiMo SR	1.2	ER 100S-G	6					
4 - 4	Alloy Steel	ASTM A519 Gr 4130	6" SCH XXS (21.95mm)	Verified	GMAW (RMD) + SAW	GM/SAW-P003-01 / PP-GMSA-PNO01-003	OERLIKON	OE-SD2 1NiCrMo / OP120TT	2.4	F10P4-EG-G	6			
4 - 3							REVOLLOY	Revofil 1NiMo SR	1.2	ER 100S-G	6			
5 - 1	CuNi	ASTM B466 (C70600)	12" (5.5mm)	Verified	GTAW	GTAW-P055-01 / PP-GTGT-PNO34-055	TECHALLOY	Techalloy 413	1.2	ERCuNi	34			
5 - 2							GTAW + GMAW	GT/GMAW-P004-01 / PP-GTGM-PNO34-004	TECHALLOY	NA	1.2	ERCuNi	34	
					TECHALLOY	NA			1.2	ERCuNi	34			
6 - 1	CrMo	A335 P11		Pending QC Size Input	GTAW + SAW	GT/SAW-P005-01 / PP-GTSA-PNO04-005	REVOLLOY	Revofil 80S-B2	1.2	ER80S-B2	6			
6 - 2							OERLIKON	OE-S2CrMo1 / OP 121 TT	2.4	F8P2-EB2-B2	6			
					6 - 3	GTAW + GMAW	GT/GMAW-P005-01 / PP-GTGM-PNO04-005	REVOLLOY	Revofil 80S-B2	1.2	ER80S-B2	6		
REVOLLOY								Revofil 80S-B2	1.2	ER80S-B2	6			
6 - 4					GMAW (RMD) + SAW	GM/SAW-P004-01 / PP-GMSA-PNO04-004	REVOLLOY	Revofil 80S-B2	1.2	ER80S-B2	6			
							OERLIKON	OE-S2CrMo1 / OP 121 TT	2.4	F8P2-EB2-B2	6			
6 - 4					GMAW (RMD)	GMAW-P003-01 /	REVOLLOY	Revofil 80S-B2	1.2	ER80S-B2	6			

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	Base Mat.	Grade	Size (mm)				Manufacturer	Brand	Dia. (mm)		AWS Class		
					+ GMAW	PP-GMGM-PNO04-003	REVOLLOY	Revofil 80S-B2	1.2	ER80S-B2	6		
7 - 1	CS	A333 Gr 6		Pending QC Size Input	GTAW + SAW	GT/SAW-P006-01 / PP-GTSA-PNO01-006	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
						OERLIKON	OE-SD3 / OP121 TT	2.4	F7A8-EH12K	6			
7 - 2							GTAW + GMAW	GT/GMAW-P006-01 / PP-GTGM-PNO01-006	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6
							REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
7 - 3					GMAW (RMD) + SAW	GM/SAW-P005-01 / PP-GMSA-PNO01-005	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
							OERLIKON	OE-SD3 / OP121 TT	2.4	F7A8-EH12K	6		
7 - 4	CS	A333 Gr 6		Pending QC Size Input	GMAW (RMD) + GMAW	GMAW-P004-01 / PP-GMGM-PNO01-004	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
							REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
8 - 1	CS	APL 5L X65		Pending QC Size Input	GTAW + SAW	GT/SAW-P007-01 / PP-GTSA-SNO01-007	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
						OERLIKON	OE-SD31 Ni 1/4 Mol / OP121 TT	2.4	F7A8-EH12K	6			
8 - 2							GTAW + GMAW	GT/GMAW-P007-01 / PP-GTGM-SNO01-007	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6
							REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
8 - 3					GMAW (RMD) + SAW	GM/SAW-P006-01 / PP-GMSA-SNO01-006	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
							OERLIKON	OE-SD3 / OP121 TT	2.4	F7A8-EH12K	6		
8 - 4					GMAW (RMD) + GMAW	GMAW-P005-01 / PP-GMGM-SNO01-005	REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
							REVOLLOY	Revofil 70S6HT	1.2	ER70S-6	6		
9 - 1	SDSS			Pending QC Size Input	GTAW	GTAW-P056-01 / PP-GTGT-PNO10H-056	SANDVIK	W25.10.4.L	1.2	ER2594	6		
9 - 2							GTAW + SAW	GT/SAW-P008-01 / PP-GTSA-PNO10H-008	SANDVIK	W25.10.4.L	1.2	ER2594	6
							SANDVIK	W25.10.4.L / 15W	2.4	ER2594	6		