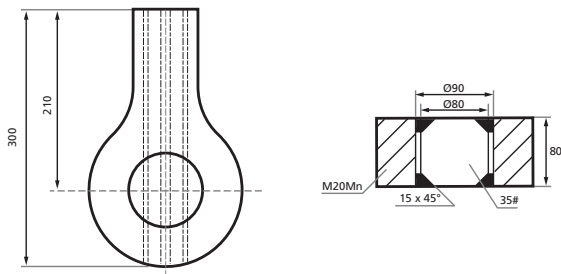


WELDING PROCEDURE

FOR CROWN SHACKLE

WPS No.:	Date of welding:	Test joint details of weld preparation
Place of test / location:		
Range of approval: P.P (Particle Penetration)		
Welding Machine: Kemppi	Single pass/Multi pass: Multi pass	
Welding Process: SMAW	Parent Material: M20Mn and 35#	
Edge Prepared: Grinding	Range of casting thickness: ≤100 mm	
Heat treatment: Normalizing / Annealing	Filler Metal Type/ designation: J507	
Type of welding current: DC+	Gas / Flux: N/A	
Welding and filler information: Use Ø3.2 mm electrode for the first, and find welding sequence Ø4.0 mm.		Bead sequence detail. (Sketch to include weld metal Tk and back gouging where applicable.)
Parent metal: M20Mn and 35#	Test piece position: See drawing.	
Welding Position: P.E, P.A, P.C	Joint Type: P.P	
Filler Material: J507	Shielding gas / flux flow rate: N/A	
Maker/Type/Diameter of electrode:	Gas composition: N/A	
	Flux Type: N/A	
Other information:		
Pre-heat and inter pass temperature: 125 °C – 200 °C		
Post weld heat treatment temperature: N/A		

The location of specimen taking:



Note: The measurements in tables may vary between different models. Sotra Anchor & Chain AS can not be hold responsible for any deviate between tables and delivered equipment.

WELDING PROCEDURE

FOR CROWN SHACKLE

Welding Record

Welding process: SMAW

WPS No.:

Joint type: Double V

Joint angle: 40°

Standard: ABS

Parent Material: M20Mn and 35#

Welding position: Down Hand

Maker of electrode:

Electrode Type:

Welding Machine Type:

Electric current type: DC+

Pre-heat temperature: 130 °C

Heat treatment, temperature:

Time and date:

Welding Process

Run number	Process	Electrode		Electric Current		Voltage (V)	Joint	Temp.
		Grade	Dia(mm)	Polarity	A			
1	SMAW	3Y	Ø3.2	DC+	180	32	Double V	135 °C
2			Ø4.0		180	32		130 °C
3			Ø4.0		200	30		134 °C
4			Ø4.0		200	30		123 °C

Note: The measurements in tables may vary between different models. Sotra Anchor & Chain AS can not be hold responsible for any deviate between tables and delivered equipment.