

WPS for Fabricated Pipes

Following 3 welding methods are used:

- » [Plasma Arc Welding, PAW](#)
- » [Tungsten Inert Gas Welding, TIG or GTAW](#)
- » [Submerged Arc Welding, SAW](#)

All welding is performed in automatic operations.

Welding procedures

Depending on type of grade, wall thickness and customer requirements a certain welding procedure (WPS) is used. We have a large library of WPS's and 4 main procedures can be identified:



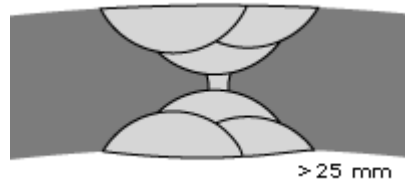
I-groove
Double PAW



I-groove
Double PAW + TIG inside



Y-groove
PAW+SAW+TIG inside



X-groove
PAW+SAW outside + SAW inside

Filler metal is used in most passes, except for thin wall and intermediate PAW. Inside means welding from the inside of the pipe. TIG welding is used primarily to smooth out the inside bead.