



Standard Welding Procedure Specification (SWPS)

WPS Package for partially mechanized Steel applications

qualified as per ISO 15612:2018

parent metal group 1.1, 1.2

Art. Nr.: 4,100,781

Page	Weld seam profile/Joint Type	Weld Details	Parent Metal thickness - t [mm]	Parent Metal-Outer-Ø [mm]	Welding Position	Particle transfer	Filler material-Ø [mm]
8	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB	D	1,0
9	Fillet weld; FW	sl	1,5 - 3,0	≥500	PC	D	1,0
10	Fillet weld; FW	sl	1,5 - 4,0	≥500	PG	D	0,8
11	Fillet weld; FW	sl	2,0 - 4,0	≥500	PC	D	1,0
12	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB, PC	D	1,0
13	Fillet weld; FW	sl	1,5 - 4,0	≥500	PG	D	1,0
14	Fillet weld; FW	sl	3,0 - 6,0	≥500	PA, PB, PC	P	1,0
15	Fillet weld; FW	sl	3,0 - 6,0	≥500	PG	P	1,0
16	Fillet weld; FW	sl	6,0 - 12,0	≥500	PA, PB, PC	P	1,0
17	Fillet weld; FW	sl	6,0 - 12,0	≥500	PG	P	1,0
18	Fillet weld; FW	ml	5,0 - 25,0	≥500	PA	P	1,0
19	Fillet weld; FW	ml	20,0 - 50,0	≥500	PA	P	1,0
20	Fillet weld; FW	ml	10,0 - 50,0	≥500	PA, PB, PC	P	1,0
21	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	D	1,0
22	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	P	1,0
23	Tube/Plate-Fillet weld	sl	3,0 - 8,0	≥24,15	PA, PB, PC	P	1,0
24	Tube/Plate-Fillet weld	ml	5,0 - 25,0	≥44,45	PA, PB, PC	P	1,0
25	Tube/Plate-Fillet weld	ml	20,0 - 50,0	≥44,45	PA, PB, PC	P	1,0
26	Corner joint; FW-CJ	sl	1,5 - 3,0	≥500	PA, PB, PC	D	1,0

Page	Weld seam profile/Joint Type	Weld Details	Parent Metal thickness - t [mm]	Parent Metal-Outer-Ø [mm]	Welding Position	Particle transfer	Filler material-Ø [mm]
27	Corner joint; FW-CJ	sl	1,5 - 3,0	≥500	PG	D	1,0
28	Corner joint; FW-CJ	sl	1,5 - 3,0	≥500	PA, PB, PC	D	1,0
29	Corner joint; FW-CJ	sl	1,5 - 3,0	≥500	PG	D	1,0
30	Corner joint; FW-CJ	sl	3,0 - 8,0	≥500	PA, PB, PC	P	1,0
31	Angle joint 60°; FW-AJ60	sl	1,5 - 3,0	≥500	PA, PB	D	1,0
32	Angle joint 60°; FW-AJ60	sl	1,5 - 3,0	≥500	PC	D	1,0
33	Angle joint 60°; FW-AJ60	sl	3,0 - 12,0	≥500	PA, PB, PC	P	1,0
34	Angle joint 60°; FW-AJ60	sl	3,0 - 12,0	≥500	PG	P	1,0
35	Angle joint 135°; FW-AJ35	sl	1,5 - 4,0	≥500	PA, PB	D	1,0
36	Angle joint 135°; FW-AJ35	sl	3,0 - 12,0	≥500	PA, PB	P	1,0
37	Angle joint 135°; FW-AJ35	sl	3,0 - 12,0	≥500	PG	P	1,0
38	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PA, PB, PC	D	1,0
39	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PG	D	1,0
40	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PA, PB, PC	D	1,0
41	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PG	D	1,0
42	lap joint; FW-LJ	sl	3,0 - 6,0	≥500	PA, PB, PC	P	1,0
43	lap joint; FW-LJ	sl	3,0 - 6,0	≥500	PG	P	1,0

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44	lap joint; FW-LJ	sl	6,0 - 12,0	≥500	PA, PB, PC	P	1,0
45	lap joint; FW-LJ	sl	6,0 - 12,0	≥500	PG	P	1,0
46	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 3,0	≥500	PG	D	1,0
47	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 2,0	≥500	PA, PC	D	1,0
48	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 2,0	≥500	PG	D	1,0
49	Butt joint, square butt weld; BW	sl; ss; nb	2,0 - 4,0	≥500	PA, PC	D	1,0
50	Butt joint, square butt weld; BW	sl; ss; nb	2,0 - 3,0	≥500	PG	D	1,0
51	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB	D	1,2
52	Fillet weld; FW	sl	1,5 - 4,0	≥500	PC	D	1,2
53	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB, PC	D	1,2
54	Fillet weld; FW	sl	1,5 - 4,0	≥500	PG	D	1,2
55	Fillet weld; FW	sl	3,0 - 6,0	≥500	PA, PB	P	1,2
56	Fillet weld; FW	sl	3,0 - 6,0	≥500	PG	P	1,2
57	Fillet weld; FW	sl	6,0 - 12,0	≥500	PA, PB, PC	P	1,2
58	Fillet weld; FW	sl	5,0 - 12,0	≥500	PG	P	1,2
59	Fillet weld; FW	ml	10,0 - 50,0	≥500	PA, PB, PC	P	1,2
60	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	D	1,2

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61	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	P	1,2
62	Tube/Plate-Fillet weld	sl	3,0 - 8,0	≥24,15	PA, PB, PC	P	1,2
63	Tube/Plate-Fillet weld	ml	5,0 - 25,0	≥44,45	PA, PB, PC	P	1,0
64	Tube/Plate-Fillet weld	ml	10,0 - 50,0	≥44,45	PA, PB, PC	P	1,2
65	Ecknaht; FW-CJ	sl	1,5 - 3,0	≥500	PA, PB, PC	D	1,2
66	Ecknaht; FW-CJ	sl	1,5 - 3,0	≥500	PG	D	1,2
67	Ecknaht; FW-CJ	sl	1,5 - 3,0	≥500	PA, PB, PC	D	1,2
68	Ecknaht; FW-CJ	sl	3,0 - 8,0	≥500	PA, PB, PC	P	1,2
69	Angle joint 60°; FW-AJ60	sl	1,5 - 3,0	≥500	PA, PB	D	1,2
70	Angle joint 60°; FW-AJ60	sl	1,5 - 3,0	≥500	PC	D	1,2
71	Angle joint 60°; FW-AJ60	sl	3,0 - 12,0	≥500	PA, PB	P	1,2
72	Angle joint 60°; FW-AJ60	sl	3,0 - 12,0	≥500	PC	P	1,2
73	Angle joint 60°; FW-AJ60	sl	3,0 - 12,0	≥500	PG	P	1,2
74	Angle joint 135°; FW-AJ35	sl	1,5 - 4,0	≥500	PA, PB, PC	D	1,2
75	Angle joint 135°; FW-AJ35	sl	3,0 - 12,0	≥500	PA, PB	P	1,2
76	Angle joint 135°; FW-AJ35	sl	3,0 - 12,0	≥500	PC	P	1,2

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77	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PA, PB, PC	D	1,2
78	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PA, PB	D	1,2
79	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PC	D	1,2
80	lap joint; FW-LJ	sl	1,5 - 5,7	≥500	PG	D	1,2
81	lap joint; FW-LJ	sl	3,0 - 6,0	≥500	PA, PB, PC	P	1,2
82	lap joint; FW-LJ	sl	3,0 - 6,0	≥500	PG	P	1,2
83	lap joint; FW-LJ	sl	6,0 - 12,0	≥500	PA, PB	P	1,2
84	lap joint; FW-LJ	sl	6,0 - 12,0	≥500	PC	P	1,2
85	lap joint; FW-LJ	sl	6,0 - 12,0	≥500	PG	P	1,2
86	Fillet weld; FW	sl	3,0 - 6,0	≥500	PC	P	1,2
87	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 2,0	≥500	PG	D	1,2
88	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 2,0	≥500	PA, PC	D	1,2
89	Butt joint, square butt weld; BW	sl; ss; nb	1,0 - 2,0	≥500	PG	D	1,2
90	Butt joint, square butt weld; BW	sl; ss; nb	2,0 - 4,0	≥500	PA, PC	D	1,2
91	Butt joint, square butt weld; BW	sl; ss; nb	2,0 - 3,0	≥500	PG	D	1,2
92	Fillet weld; FW	ml	5,0 - 25,0	≥500	PA	P	1,2
93	Fillet weld; FW	sl	5,0 - 12,0	≥500	PA, PB	P	1,2

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94	Angle joint 135°; FW-AJ35	sl	1,5 - 4,0	≥500	PC	D	1,0
95	Angle joint 135°; FW-AJ35	sl	3,0 - 12,0	≥500	PC	P	1,0