



# Standard Welding Procedure Specification (SWPS)

SWPS Package for automated stainless steel applications

qualified as per ISO 15612:2018

Parent metal group 8.1

*Art. Nr.: 4,101,505*

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]
4	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB	D	1,0
5	Fillet weld; FW	sl	1,5 - 4,0	≥500	PC	D	1,0
6	Fillet weld; FW	sl	1,5 - 4,0	≥500	PG	D	1,0
7	Fillet weld; FW	sl	3,0 - 12,0	≥500	PA, PB	P	1,0
8	Fillet weld; FW	sl	3,0 - 12,0	≥500	PC	P	1,0
9	Fillet weld; FW	sl	3,0 - 12,0	≥500	PG	P	1,0
10	Fillet weld; FW	sl	3,0 - 12,0	≥500	PA, PB, PC	P	1,0
11	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	D	1,0
12	Corner joint; FW-CJ	sl; ss; gb	1,5 - 4,0	≥500	PA, PB, PC	D	1,0
13	Corner joint; FW-CJ	sl; ss; gb	1,5 - 3,0	≥500	PG	D	1,0
14	Butt joint, square butt weld; BW	sl; ss; gb	1,0 - 4,0	≥500	PA	D	1,0
15	Butt joint, square butt weld; BW	sl; ss; gb	1,0 - 3,0	≥500	PC	D	1,0
16	Butt joint, square butt weld; BW	sl; ss; gb	1,0 - 2,0	≥500	PG	D	1,0
17	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PA, PB	D	1,0
18	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PC	D	1,0
19	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PG	P	1,0
20	lap joint; FW-LJ	sl	3,0 - 5,0	≥500	PA, PB, PC	D	1,0
21	lap joint; FW-LJ	sl	3,0 - 5,0	≥500	PG	P	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]
22	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PA, PB, PC	D	1,0
23	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PG	P	1,0
24	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PA, PB, PC	P	1,0
25	lap joint; FW-LJ	sl	1,5 - 2,0	≥500	PC	D	1,0
26	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB	D	1,2
27	Fillet weld; FW	sl	1,5 - 4,0	≥500	PA, PB	D	1,2
28	Fillet weld; FW	sl	1,5 - 4,0	≥500	PC	D	1,2
29	Fillet weld; FW	sl	1,5 - 4,0	≥500	PC	D	1,2
30	Fillet weld; FW	sl	1,5 - 4,0	≥500	PG	D	1,2
31	Fillet weld; FW	sl	3,0 - 12,0	≥500	PA, PB	P	1,2
32	Fillet weld; FW	sl	3,0 - 12,0	≥500	PA, PB	P	1,2
33	Fillet weld; FW	sl	3,0 - 12,0	≥500	PC	P	1,2
34	Fillet weld; FW	sl	3,0 - 12,0	≥500	PC	P	1,2
35	Fillet weld; FW	sl	3,0 - 12,0	≥500	PG	P	1,2
36	Tube/Plate-Fillet weld	sl	2,0 - 5,7	≥24,15	PA, PB, PC	D	1,2
37	Corner joint; FW-CJ	sl; ss; gb	1,5 - 4,0	≥500	PA, PB, PC	D	1,2
38	Corner joint; FW-CJ	sl; ss; gb	1,5 - 4,0	≥500	PG	D	1,2
39	Butt joint, square butt weld; BW	sl; ss; gb	1,0 - 4,0	≥500	PA	D	1,2

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40	Butt joint, square butt weld; BW	sl; ss; gb	1,0 - 4,0	≥500	PC	D	1,2
41	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PA, PB	D	1,2
42	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PC	D	1,2
43	lap joint; FW-LJ	sl	1,5 - 4,0	≥500	PC	P	1,2
44	lap joint; FW-LJ	sl	3,0 - 5,0	≥500	PA, PB, PC	D	1,2
45	lap joint; FW-LJ	sl	3,0 - 5,0	≥500	PG	P	1,2
46	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PA, PB	D	1,2
47	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PA, PB	P	1,2
48	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PC	D	1,2
49	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PC	P	1,2
50	lap joint; FW-LJ	sl	3,0 - 12,0	≥500	PG	P	1,2