

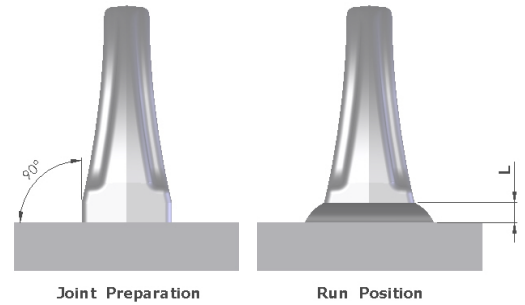
DPLP Weld on Lifting Points

Welding Instructions

Important: Welding Operator to be qualified to AS1554.1: 2014 SP

Preparation

- Prepare material by thermal cutting and grinding.
- Remove scale from weld area by grinding.
- Align joint and tack components.
- Tack welds to be a minimum length of 6 mm.
- Tack ends and then incorporate in the main weld.
- Start main run directly beneath eye opening



Minimum Fillet Weld Leg Length (FWL)

Code:	AS 1554.1 (2014) SP, "Welding of Steel Structures"
Material:	AS 3678 Grade 350, Steel Type 4
Joint Type:	8mm. minimum Fillet Weld (Single / multi run)
Welding Position:	Horizontal 2F

Part No.	WLL (t)	FWL (L mm)
DPLP160	1.6	6
DPLP250	2.5	6
DPLP400	4.0	8
DPLP670	6.7	10
DPLP1000	10.0	12

F.C.A.W – Typical Settings

Consumable:	AS 2203.1 ETP-GC/Mp-W503A.CM1 H10 or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Shielding Gas:	Argon + 16 - 18% CO2	Consumable Size:	1.2mm
Gas Flow Rate:	15 to 18.7 l/Min	Current Type:	DC Electrode +
Electrical Stick-out:	15 mm	Preheat:	50°C. minimum
Preheat Method:	Oxy-acetylene	Preheat Measurement:	Contact Thermometer
Amperage:	280 – 325	Volts:	29 - 31

G.M.A.W – Typical Settings

Consumable:	AS 2717.1 ES6-GC/MW503AH or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Shielding Gas:	Argon + 16 - 18% CO2	Consumable Size:	1.2mm
Gas Flow Rate:	15 - 18 l/Min.	Current Type:	DC Electrode +
Electrical Stick-out:	15 mm	Preheat:	50°C. minimum
Preheat Method:	Oxy-acetylene	Preheat Measurement:	Contact Thermometer
Amperage:	280 – 325	Volts:	29 - 31

M.M.A.W – Typical Settings

Consumable:	AS 4855 B E4916 or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Consumable Size:	3.2 mm / 4.0mm	Current Type:	AC / DC Electrode +
Preheat:	50°C. minimum	Preheat Measurement:	Contact Thermometer
Amperage:	3.2mm = 165 – 300	Amperage:	4.0mm = 160 - 180

Destructive Examination: Non Destructive Examination:	For welding operator qualification: One Macro to AS1554.1 SP requirements. <ul style="list-style-type: none"> • 100% visual scanning and examination. • N.D.T. method and percentage, as agreed with client.
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