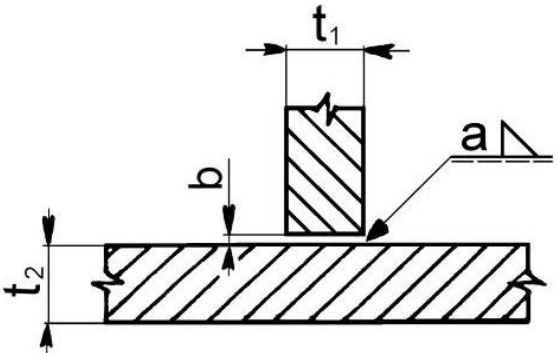
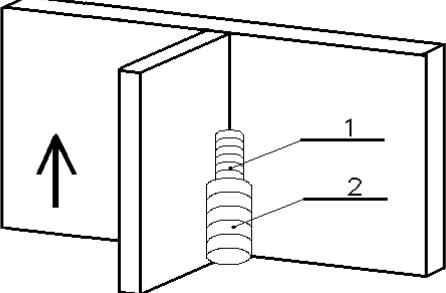
	Welding procedure specification - WPS (EN ISO 15609-1)		WPS Number: 03/2018
			Number WPQR -
Place: SOŠ a SOU technické, Třemošnice	Additional material: EN ISO154341: G3Si1 (ESAB: OK AUTROD 12.51)	More information: observe safety	
Manufacturer: Svářečská škola SOŠ a SOU technické Třemošnice	Drying of electrodes:		
Welding method (ISO 4063): 135	Shielding gas: CO2 3.0 MESSER EC 204-696-9 C1		
Type of weld: FW	The type and diameter of the tungsten electrode -	Method of cleaning the weld surfaces: brushing and degreasing	
Process for the preparation of the weld surfaces (ISO 9692-1):	Protecting root / underlay -		
Basic material specifications: 1.2	Preheating -	Basting: stitch the sides	
Welding thickness t (mm): 10	The temperature between layers: -	Method of temperature measurement: -	
Outer diameter D (mm):	Heat / time range: -		
Location welding (ISO 6947): PF	The rate of heating / cooling -	Max. width caterpillars: -	

<p style="text-align: center;">Joint preparation</p>  <p>a 6 mm b 0-0.5 mm t₁ 10 mm t₂ 10 mm</p>	<p style="text-align: center;">Welding procedure</p> 
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welding parameters							
Weld bead:	1	2	3	4	5	6	Note:
Welding method:	135	135					
Diameter adj. Material (mm):	1.0	1.0					
Current (A):	120-130	120-140					
Voltage (V):	18-19	18-19					
Current / polarity:	DC (+)	DC (+)					
Speed administration:	4-4.5	4-4.5					

Feed speed:							
Thermal power:							

	Prepared	Approved by
Name:	Mgr. Francis Melechovský IWT	RNDr. Jana Sýkorová
Date:	19. 11. 2018	19. 11. 2018
Signature:		