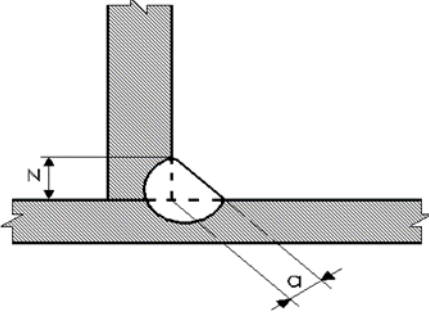
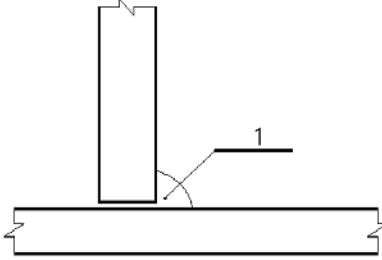
	Welding procedure specification - WPS (EN ISO 15609-1)		WPS Number: 02/2018
			Number WPQR -
Place: SOŠ a SOU technické, Třemošnice	Filler: wire TIG welding to 1.6 x 1000 mm OK308LSi	More information: observe safety	
Manufacturer: Svářečská škola SOŠ a SOU technické Třemošnice	Drying of electrodes:		
Welding method (ISO 4063): 141	shielding gas AR 60 N		
Type of weld: FW	The type and diameter of the tungsten electrode: ISO 6848: WLA 20 / diameter 2.4	Method of cleaning the weld surfaces: brushing and degreasing	
Process for the preparation of the weld surfaces (ISO 9692-1):	Protecting root / underlay -		
Specification of basic material: 1.4301 (8.1)	Preheating -	Basting: stitch the sides	
Welding thickness t (mm): 2	The temperature between layers: -	Method of temperature measurement: -	
Outer diameter D (mm):	Heat / time range: -		
Location welding (ISO 6947): PB	The rate of heating / cooling -	Gas flow 8-10 L	

<p>Joint preparation</p>  <p>a 3 mm z 4 mm thickness 2 mm</p>	<p>Welding procedure</p> 
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welding parameters							
Weld bead:	1	2	3	4	5	6	Note:
Welding method:	141						
Diameter adj. Material (mm):	1.6						
Current (A):	40-90						
Voltage (V):	18-19						
Current / polarity:	DC (-)						
Speed administration:							
Feed speed:							
Thermal power:							

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