



LISTE - PROCÉDURES DE SOUDAGE QUALIFIÉES
QUALIFIED WELDING PROCEDURES (ASME SECT. IX)

# Procédure	# DMS (WPS) (anciens #)	# engr. Reg. #	Procédé Process	Matériel (Essai) (QW-403) Material	Gamme épais. Qual. V Qualified tk. Range	Métal d'apport (Essai) (QW-404) Filler metal	# SFA SFA #	# F F #	# A A #	Gas de protection % Shielding gas	Soutien Backing	Autres PWHT (QW407) Others
SM1.1-1	LFL-1551-2 R0	6771,6	SMAW	P1-P1	.625" - .308"	E7018	5,1	4	1	N/A	----	2-3/8"
SM1.1h-1	W-20913 R0	6008,6	SMAW	P1-P1	1/2" (3/16" to 1")	E7018	5,5	4	1	N/A	Gougeage	PWHT
SM1.1h-2	4-1551-2 R0	8373,6	SMAW	P1-P1	1/16" - 3/4"	E7018	5,1	4	1	N/A	----	PWHT
SM1.8h-1	4-1551-1 R0	8372,6	SMAW	P1-P8	1/16" - 3/4"	E309+E309-Mo	5,4	5	8	N/A	----	PWHT
SM1.8-1	LFL-1551-1 R0	6772,6	SMAW	P1-P8	1875 - .864	E309+E309-Mo	5,4	5	8	N/A	----	6-5/8"
SM 8.8-1	L0081/0081.11 RC1	FA-1101-6	SMAW	P8-P8	1/16" - 8"	E308-16	5,4	5	8	N/A	Gouger/meuler	
SM10.10-1	na	FA1379.6	SMAW	P10H-P10H	1/16"-3/4"	E-2209-17	5,4	5	8	N/A	soudure,E309L equiv.	
GM1.1h-1	11-44-100A R0	8703,6	GMAW	P1-P1	1/4" - 2"	ER70S6	5,18	6	1	92Ar+8CO2	Gougeage	PWHT
GM1.1SM1	L-98-07-01	FA-1253-6	GMAW-SMAW	P1-P1	1/16"-.33"	ER70S6+E7018	5.18+5.1	6+4	1	75AR+25CO2-gma	----	
GM8.8-1	88-44-100B R0	FA231.6	GMAW	P8-P8	1/8" - 3/4"	ER316-L	5,9	6		98AR+2O2	Si requis	
GM31.31-1	31-31-4-4 1 R0	9479,6	GMAW	P31-P31	4mm - 40mm	ERCU (Solid)	5,7	31		99.9AR	Si requis	
GM43.43-1	111-111-4-4 1 R0	9512,6	GMAW	P43-P43	4mm - 25mm	ER-NICR3 (Solid)	5,14	43		75AR+25HE	Si requis	
FC1.1-1	L0012/0012.23 R0	FA-1099-6	GMAW(FCAW)	P1-P1	3/16" - 8"	E70C-6M	5,18	6	1	92AR+8CO2	Si requis	
FC1.1-2	LMC-CC-2 R0	FA-1098-6	GMAW(FCAW)	P1-P1	3/16" - 8"	E70C-6M	5,18	6	1	75AR+25CO2	Si requis	Metalcore
FC1.1-3	93-001 R0	FA126.6	FCAW	P1-P1	3/16" - 1-1/2"	E71 T-1	5,20	6	1	75AR+25CO2	Gougeage, etc	
FC1.1h-1	93-002 R0	FA-227.6	FCAW	P1-P1	3/16" - 1-1/2"	E71-T1	5,20	6	1	75AR+25CO2	Gougeage, etc	PWHT
FC44w.44w-1	44W-44W-04-04 R0	FA-251.6	FCAW	CSA-G40.21-44W-44W	1/16" - 3/4"	E70T-1+E71T-1	5,20	6	1	75AR+25CO2	Gougeage, etc	
FC44w.8-1	44W-08-04-04 R0	FA-250-6	FCAW	CSA-G40.21-44W-P8	1/16" - 3/4"	E309L T-1	5,22	6	8	75AR+25CO2	Gougeage, etc	
FC1.8-1	01-08-04-04 R0	FA-248-6	FCAW	P1-P8	1/16" - 3/4"	E309L T-1	5,22	6	8	75AR+25CO2	Gougeage, etc	
FC1.8-2	L0012/0081.22 RB1	FA-1100-6	FCAW	P1-P8	4mm - 200mm	E309L T-1	5,22	6	8	75AR+25CO2	Si requis	
FC1.8h-1	01-08-3-3-1 R0	9498,6	FCAW	P1-P8	P1:3/16-8" P10H:1/16	E309LT3	5,22	6	8	75AR+25CO2	Si requis	PWHT
FC1.10-1	na	FA1378.6	FCAW	P1-P10H	116"-3/4"-8"	E309LT-1	5,22	6	8	75AR+25CO2	goug meul P1,soudure	
FC8.8-1	08-08-04-04 R0	FA-249-6	FCAW	P8-P8	1/16" - 3/4"	E308L T-1	5,22	6	8	75AR+25CO2	Gougeage, etc	
FC8.8-2	L0081/0081.22 RB2	FA-1102-6	FCAW	P8-P8 gr1,2,3,4	4mm - 200mm	E308L T-1+E316L T-1	5,22	6	8	75AR+25CO2	Si requis	
FC8.8h-1	08-08-05-05T R0	FA-363-6	FCAW	P8-P8	3/16" - 1-1/2"	E308L-T1+E316L-T1	5,22	6	8	75AR+25CO2	Gougeage, etc	PWHT
GT1.1SM h-1	11-12-100A R1	8386.6	GTAW-SMAW	P1-P1	3/16" - 1.240"	ER70S2+E7018	5.18+5.1	6+4	1	99.9AR (GTAW)	Argon	PWHT
GT1.1SM-1	11-12-100B R0	8486.6	GTAW-SMAW	P1-P1	1/16" - 3/4"	ER70S2+E7018	5.18+5.1	6+4	1+1	99.9AR (GTAW)	Argon	
GT1.8620 SM-1	97-007 R3	FA-1063.6	GTAW-SMAW	P1-AISI 8620	3/16" - 1-1/2"	ER70S2+E7018	5.18/5.1	6+4	1	99AR (GTAW)	99.9AR	PipeForg
GT1.8 SM h-1	18-12-100A R0	8485.6	GTAW-SMAW	P1-P8	1/16" - 3/4"	ER309	5,9	6	8	99.9AR (GTAW)	99.9AR	PWHT
						E309+E309Cb or	5,4	5	8			
						E309Mo	5,4	5	8			
GT1.8 SM h-2	88-12-100A R0	8484.6	GTAW-SMAW	PI-P8	1/16" - 3/4"	ER308+ER308L+	5,9	6	8	99.9AR (GTAW)	99.9AR	PWHT
						ER316 or ER316L+	5,9	6	8			
						E308+E308L+	5,4	6	8			
						E316 or E316L	5,4	5	8			
GT1.8SM h-3	01-08-01-02T R0	FA-364-6	GTAW-SMAW	P1-P8	3/16" - 1-1/2"	ER309L+E309L	5.9+5.4	6+5	8	100AR	Argon	PWHT
GT8.8SM -1	LEF01 R0	5686.6	GTAW-SMAW	P8-P8	1/16" - 3/4"	ER308+E308-16	5.9+5.4	6+5	8	99.9AR	99.9AR	
OÙ ? Existe?	89-12-100A		GTAW-SMAW	P8-P8								PWHT
BR107.107-1	S.B.1 R0	6042.6	BRASAGE	P107-P107	.036 - .144	BCUP5	5,8	103		N/A	----	Lap joint
SA1.1-1	01-01-04-04T R0	FA-311.6	SAW	P1-P1	3/16" - 1-1/2"	EM 12K	5,17	6	1	N/A	----	PWHT
SA8.8-1			SAW	P8-P8	3/16"-2"	ER308L, ER316L	5,9	6	8	N/A	si requis	