

Beijing Railway Tunnel ZJX – 2 Project

NORDSEETAUCHER GMBH

Hyperbaric Tunnel Construction and Diving®



WELDING PROCEDURE SPECIFICATION

WPS No. 004/2011

Beijing Railway Tunnel ZJX – 2 Project

Job No.: 1-1410

Joint Description:

Qualified Professional Hyperbaric Cutterhead Welding
accor. EN ISO 15618-1 / EN 287-1 / AWS 3.6D



111/ Rev.: Shielded Metal Arc-Welding Joint No.: 01/Fillet Weld a 25mm
02/2011 Retzlaff Rev.: PA, PB, PC, PD, PE, PF

W01

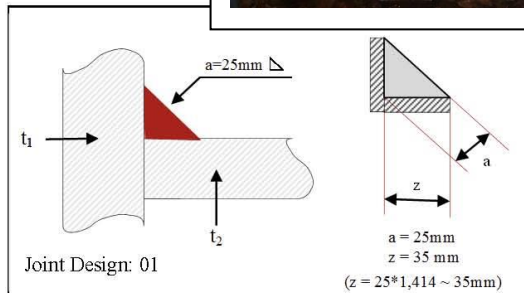
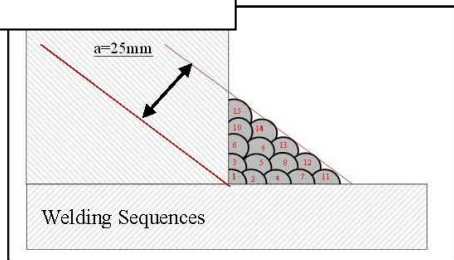
2.8 bar
30-40° C Compressed Air

amrau date of birth: 1969.02.09
Frank Jans date of birth: 1959.10.14

approved by: date:
Project Mgr. Claus Mayer (NST) 2011.04.08
QC Supv. Martin Wenning (GL) 2009.11.06
Client* CRTG
China Railway Tunnel Group
ANI*

*if required

Specification of Base Material : S355J2+N
Welding Method : Compressed Air -Shielded Metal Arc-Welding (SMAW)
Form of Welded Joint : multi –run fillet weld
 : DIN EN 287-1 / PD, PB, PF
 : DIN EN ISO 5817:C
 : Fillet Joint
 : 1) t1=60mm / =30mm
 : 2) t2=60mm / =35mm
 : NFM / Nordseetaucher GmbH
 : CREC
 : GL DIN 18800-7, Class C/D



Name of Filler Material: ESAB OK 53.16 special
Filler Metal: E 38 2 B 3 2 H10 (EN ISO 2560-A)
Details for Welding

Preheating Temperature: 50 – 80°C
Interpass Temperature: max. 200°C

Bead of weld	Process	Size of er metal	Current Intens. A	Voltage V	Kind of polarity	Wire Feed	Travelspeed cm / min
.50 Ø			ca.80		= -	/	/
.25 Ø			ca.130		= +	/	/
.00 Ø			ca.180		= +	/	/
.00 Ø			ca.180		= +	/	/

