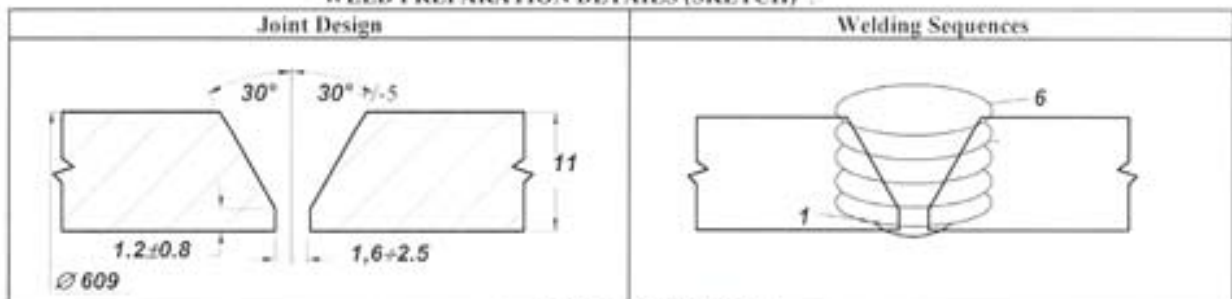


Manufacturer's welding procedure specification (WPS)

Location	: Mallot Israel	Examiner or test body	: TUV HELLAS (TUVNORD) S.A
WPS Reference No	: 398/09	Parent Material	: L450MB EN 10208-2
WPQR No	: 397/09	Material Thickness (mm)	: 11 mm.
Manufacturer	: MGT Israel Ltd	Outside Diameter (mm)	: 609 mm
Welder's Name	: Louise Dakur	Welding Position	: PA
Welderr Stamp	: 01		
Welding Process	: 141 (GTAW)+135(MAG)	Joint Type	: BW single V with out backing
Code Testing Std	: EN ISO 15614-1 :2004	Method of Preparation and Cleaning	: GRINDING, BRUSHING

WELD PREPARATION DETAILS (SKETCH)*:



WELDING DETAILS

Pass	Process	Size of Filler Metal (Φ mm.)	Current A	Voltage V	Type of current/ Polarity	Wire Feed Speed* (m/min.)	Travel Speed (mm/min)	Heat Input* (kJ/mm)	Metal Transfer *
1	141	2,4	110-130	11-13	DC(-)	%	40	1.452	%
2	141	2,4	110-130	11-13	DC(-)	%	40	1.452	%
3-6	135	1,6	230-260	28-32	DC(+)	%	80	3.864	%

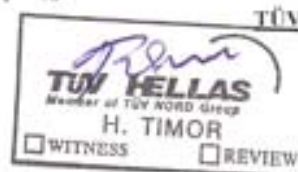
Filler Metal Classification and trade name : 141: ER 80S Ni2 (AWS 5.28)HILCO EN 1668 W2Ni2
135: E71T-1 (AWS 5.20)Lincoln EN 758 T46 2 P CM1 H5
: %

Gas Flux :	shielding	: 141-Argon 99,99 EN 439 (11)	Other information*	: %
	Backing	: NA	Torch angle	: %
Gas Flow Rate :	shielding	: 10-14 lt/min.	Pulse welding details	: %
	Backing	: NA	Stand off distance	: %
Tungsten Electrode Type/Size		: 2% Thorium – 2 mm	Plasma welding details	: %
Details of Back Gouging/Backing		: %	Oscillation : amplitude, frequency, dwell time	: %
Preheat Temperature		: %		
Interpass Temperature		: 250 ° C MAX. (check method: digital thermo or temperature sticks)		
Post-Weld heat treatment and/or Ageing		: %		
Time, Temperature, Method		: %		
Heating and Cooling Rates*		: %		

Manufacturer

Name, date and signature MGT Ltd

*If required



Name and signature

Timor Haim
25/06/2008



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