

## Universal WPS for stick (MMA) tube welding (6800008)

### Stick tube welding (process 111)

WPS number	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Pipe outside diameter (mm)	Welding position	Weld details	Throat thickness (mm)	Shielding gas
<b>111 Butt welds, tube, material group 1.1/1.2/1.4</b>											
WPS 111-BW-T-1	111	T	BW	1.1/1.2/1.4	EN ISO 2560-A E 42.5	3...4,6	≥ 29,5	PA	sl, nb/mb		
WPS 111-BW-T-2	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	PC	sl, nb/mb		
WPS 111-BW-T-3	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	PH	sl, nb/mb		
WPS 111-BW-T-4	111	T	BW	1.1/1.2/1.4		3...4,6	≥ 29,5	H-L045	sl, nb/mb		
WPS 111-BW-T-5	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PA	ml, ss, nb/mb		
WPS 111-BW-T-6	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PC	ml, ss, nb/mb		
WPS 111-BW-T-7	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	PH	ml, ss, nb/mb		
WPS 111-BW-T-8	111	T	BW	1.1/1.2/1.4		5...20	≥ 30	H-L045	ml, ss, nb/mb		

**111: Filler material that comply with the classification above can be used, such as Elga P 48M. We have carried out impact toughness tests.**