

Standard Welding Procedure Specification (SWPS)

Gas Tungsten Arc Welding with Consumable Insert Root followed by Shielded Metal Arc Welding of Austenitic Stainless Steel (M-8/P-8/S-8, Group 1), 1/8 through 1-1/2 inch Thick, IN3XX, ER3XX, and E3XX-XX, As-Welded Condition, Primarily Pipe Applications

Welding Research Council—Supporting PQR Numbers: 001027, 001031, 001032, 003049, 007018, 007019, 103023, 103024, 107018, 200005, 200159, 200160, 200161, 200162, 200163, 200164, 200165, 200166, 200167, 200168, 200169, 200170, 200172, 200175, 200199, 200200, 200201, 200204, 200524, 200525, 200623, 200720, 200721, 200724, 200749, 200750, 200751, 500095, 500096, 500097, 500098, 500099, 500100, 500223, 500224, 500225, 500226, 500227, 500228, 500229, 500230, 500231, 500253, 500254, 500255, 500256, 500257, 500258, 500263, 500264, 500265, 500266

Requirements for Application of SWPSs

Scope. The data to support this Standard Welding Procedure Specification (SWPS) have been derived from the above listed Procedure Qualification Records (PQRs) which were reviewed and validated under the auspices of the Welding Research Council. This SWPS is not valid using conditions and variables outside the ranges listed. The American Welding Society considers that this SWPS presents information for producing an acceptable weld using the conditions and variables listed. The user needs a significant knowledge of welding and accepts full responsibility for the performance of the weld and for providing the engineering capability, qualified personnel, and proper equipment to implement this SWPS.

Application. This SWPS is to be used only as permitted by the applicable fabrication document(s) [such as code, specification, or contract document(s)]. The fabrication document(s) should specify the engineering requirements such as design, need for heat treatment, fabricating tolerances, quality control, and examination and tests applicable to the end product.

User's Responsibility. A SWPS does not replace or substitute for fabrication codes, specifications, contract requirements, or capability and judgment on the part of the user. A SWPS is to be used only as permitted by the

applicable fabrication code, specification, or contract document.

The ability to produce production welds having properties suitable for the application depends upon supplementing the SWPS with appropriate performance qualification tests and sound engineering judgment. The user is responsible for the quality and performance of the final product in accordance with the provisions of the fabrication document(s).

Supplementary Instructions. To adapt this SWPS to a specific application, a user may issue supplementary instructions. Such instructions may consist of tighter fit-up tolerances, higher minimum preheat temperature or any other instructions necessary to produce a weldment that meets the requirements of the fabrication document(s). These instructions shall not be less restrictive than provided in the SWPS.

Safety. Safety precautions shall conform to the latest edition of ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society.

This specification may involve hazardous materials, operations, and equipment. The specification does not purport to address all of the safety problems associated with its use. It is the responsibility of the user to establish appropriate safety and health practices. The user should determine the applicability of any regulatory limitations prior to use.