Welding documents (WD)

WD-10 Welding WPS Overview Summary

Latest saved: 11-2-2026

All 100 WPSes are FW (sl &ml)
All 200 WPSes are BW Carbon steel to Carbon steel(V-joint(200), X-joint (201)1/2 V-joint(202), K-joint (203), U-Joint (204)
All 200A= Duplex to stainless steel
All 200B= carbon steel to stainless steel
All 200C=stainless steel to stainless steel
All 200D= S690QT
All 200E= Duplex

NR	WPS Number	Welding process ISO 4063	Joint Type	Welding positions ISO 6947	Range	Supporting PQR	Base material 1	Base material 2	Plate Pipe	Consumable(s) 1 Root / Fill / Cap	Consumable(s) 2 Fill / Cap	Remarks
	Select	Select	Select	Select	Select	Select	Select	Select	Select	Select	Select	Select
1	Tackweld 111	111	All	PA,PB,PF,PD	3-40mm	R.O. PQR 001 & 003	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Phoenix 120K		
2	Tackweld 111A	111	All	All (except vertical down)	3-26,98mm	R.O. PQR 018, 019 & 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57,15	Böhler Fox CN 23/12 Mo-A		
3	Tackweld 111B	111	All	All (except vertical down)	3-26,98mm	R.O. PQR 020, 021 & 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57,15	Böhler Fox CN 23/12 Mo-A		Below 6,75mm = Ø >500
4	Tackweld 136	136	All	All (except vertical down)	3-50mm	R.O. PQR 039	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union RV 71		
5	Tackweld 138	138	All	PA, PB	3-50mm	R.O. PQR 007	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70		
6	Tackweld 141	141	All	All	6.35-25.4mm	R.O. PQR 017	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 30.15	Böhler EML 5		
7	Tackweld 141C	141	All	All	3.0 -14.2 mm	R.O. PQR 028	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 84.15	Lincoln 316 Lsi		
8	Tackweld 131	131	All	PA,PB	3-16mm	R.O. PQR 005 , 011	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
9	WPS 111-100	111	FW sl / ml	PA, PB,PF, PD	3-40mm	R.O. PQR 001 , 002, 003 & 004	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Phoenix 120K		
10	WPS 111-100A	111	FW ml	PA, PB,PF, PD	3-24mm	R.O. PQR 018 & 019	Duplex (10)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX CN 23/12 Mo-A		
11	WPS 111-100B	111	FW ml	PA, PB,PF, PD	3-24mm	R.O. PQR 020 & 021	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX CN 23/12 Mo-A		
12	WPS 111-100C	111	FW ml	PA, PB,PF, PD	≥ 5mm	R.O. PQR 031 & 032	316, 304 (8.1)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX EAS 4M-A		WPS covered by butt weld, incase the dominant form in the construction is fillet weld requalification is necessary
13	WPS 136-100	136	FW sl / ml	PA, PB,PF, PD	3-50mm	R.O. PQR 0112 & 039	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union RV 71		
13A	WPS 136-100C	136	FW sl / ml	PA, PB,PF, PD	3-44mm / ≥5mm	R.O. PQR 054	316, 304 (8.1)	316, 304 (8.1)	plate / pipe ≥ 109,55mm	Foxcore 316L-T1		
13B	WPS 136-100-01	136	FW sl / ml	PB, PF	3-24mm	R.O. PQR 48,49,50,51	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union RV 71		
13C	WPS 136-100-02	136	FW ml	PB,PF	≥ 5mm	R.O. PQR 052 & 053	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union RV 71		
13D	WPS 136-100-03	136	FW ml	PA, PB,PF, PD	3-24mm	R.O. PQR 063 & 064	1.4462 (10.1)	1.4462 (10.1)	plate / Pipe > 500mm	FOXcore 2209-T1		

ROTTERDAMOFFSHORE GROUP

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All 200 WPSes are BW Carbon steel to Carbon steel(V-joint(200), X-joint (201)1/2 V-joint(202), K-joint (203), U-Joint (204)
All 200A= Duplex to stainless steel
All 200B= carbon steel to stainless steel
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All 200D= S690QT
All 200E= Duplex

NR	WPS Number	Welding process ISO 4063	Joint Type	Welding positions ISO 6947	Range	Supporting PQR	Base material 1	Base material 2	Plate Pipe	Consumable(s) 1 Root / Fill / Cap	Consumable(s) 2 Fill / Cap	Remarks
14	WPS 138-100	138	FW sl / ml	PB	3-50mm	R.O. PQR 007 & 008	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70		
15	WPS 131-100	131	FW ml	PB	3-16mm	R.O. PQR 005	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
15A	WPS 131-100A	131	FW ml	PB	≥ 20mm	R.O. PQR 067	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
16	WPS 111-200	111	V-joint (BW & PP)	All	9.13-68mm	R.O. PQR 014 & 016	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 84.15	Lincoln Conarc 49C		preheat temperature depends on material grade
17	WPS 111-201	111	1/2 V-joint (BW & PP)	All	9.13-68mm	R.O. PQR 014 & 016	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 84.15	Lincoln Conarc 49C		
18	WPS 111-202	111	X-joint (BW & PP)	All	9.13-68mm	R.O. PQR 014 & 016	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 84.15	Lincoln Conarc 49C		
19	WPS 111-203	111	K-joint (BW & PP)	All	9.13-68mm	R.O. PQR 014 & 016	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 84.15	Lincoln Conarc 49C		
20	WPS 111-200A	111	V-joint (BW & PP)	All	6.75-26.98	R.O. PQR 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
21	WPS 111-201A	111	1/2 V-joint (BW & PP)	All	6.75-26.98	R.O. PQR 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
22	WPS 111-202A	111	X-joint (BW & PP)	All	6.75-26.98	R.O. PQR 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
23	WPS 111-203A	111	K-joint (BW & PP)	All	6.75-26.98	R.O. PQR 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
24	WPS 111-200B	111	V-joint (BW & PP)	All	6.75-26.98	R.O. PQR 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
25	WPS 111-201B	111	1/2 V-joint (BW & PP)	All	6.75-26.98	R.O. PQR 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
26	WPS 111-202B	111	X-joint (BW & PP)	All	6.75-26.98	R.O. PQR 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
27	WPS 111-203B	111	K-joint (BW & PP)	All	6.75-26.98	R.O. PQR 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
28	WPS 111-200C	111	V-joint (BW & PP)	All	15-60mm	R.O. PQR 031 & 032	316, 304 (8.1)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX EAS 4M-A		
29	WPS 111-201C	111	1/2 V-joint (BW & PP)	All	15-60mm	R.O. PQR 031 & 032	316, 304 (8.1)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX EAS 4M-A		
30	WPS 111-202C	111	X-joint (BW & PP)	All	15-60mm	R.O. PQR 031 & 032	316, 304 (8.1)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX EAS 4M-A		
31	WPS 111-203C	111	K-joint (BW & PP)	All	15-60mm	R.O. PQR 031 & 032	316, 304 (8.1)	316, 304 (8.1)	plate / Pipe > 500mm	Böhler FOX EAS 4M-A		
32	138/136-200	138/136	V-joint (BW & PP)	All	12.5-50mm	R.O. PQR 026 & 027	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
32A	138/136-200-01	138/136	V-joint (BW & PP)	All	3-24mm	R.O. PQR 034 & 035	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
32B	138/136-200-02	138/136	V-joint (BW & PP)	All	25-100mm	R.O. PQR 058 &059	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
32C	138/136-200-03	138/136	V-joint (BW & PP)	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
33	138/136-201	138/136	1/2 V-joint (BW & PP)	All	12.5-50mm	R.O. PQR 026 & 027	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
33A	138/136-201-01	138/136	1/2 V-joint (BW & PP)	All	3-24mm	R.O. PQR 034 & 035	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
33B	138/136-201-02	138/136	1/2 V-joint (BW & PP)	All	25-100mm	R.O. PQR 058 &059	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
33C	138/136-201-03	138/136	1/2 V-joint (BW & PP)	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
34	138/136-202	138/136	X-joint (BW & PP)	All	12.5-50mm	R.O. PQR 026 & 027	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
34A	138/136-202-01	138/136	X-joint (BW & PP)	All	3-24mm	R.O. PQR 034 & 035	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	

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NR	WPS Number	Welding process ISO 4063	Joint Type	Welding positions ISO 6947	Range	Supporting PQR	Base material 1	Base material 2	Plate Pipe	Consumable(s) 1 Root / Fill / Cap	Consumable(s) 2 Fill / Cap	Remarks
34B	138/136-202-02	138/136	X-joint (BW & PP)	All	25-100mm	R.O. PQR 058 &059	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
34C	138/136-202-03	138/136	X-joint (BW & PP)	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
35	138/136-203	138/136	K-joint (BW & PP)	All	12.5-50mm	R.O. PQR 026 & 027	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
35A	138/136-203-01	138/136	K-joint (BW & PP)	All	3-24mm	R.O. PQR 034 & 035	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Pipe > 500mm	Böhler Union MV 70	Böhler Union RV 71	
35B	138/136-203-02	138/136	K-joint (BW & PP)	All	25-100mm	R.O. PQR 058 &059	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Pipe > 500mm	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
35C	138/136-203-03	138/136	K-joint (BW & PP)	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
35D	136-204	138/136	U-Joint (BW & PP)	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
36	138/136-200D	138/136	V-joint (BW & PP)	All	12.5-50mm	R.O. PQR 033	S690 (3.1)	S690 (3.1)	plate / Ø ≥ 84.15	Megafil 742M	Megafil 690R	
37	138/136-201D	138/136	1/2 V-joint (BW & PP)	All	12.5-50mm	R.O. PQR 033	S690 (3.1)	S690 (3.1)	plate / Ø ≥ 84.15	Megafil 742M	Megafil 690R	
38	138/136-202D	138/136	X-joint (BW & PP)	All	12.5-50mm	R.O. PQR 033	S690 (3.1)	S690 (3.1)	plate / Ø ≥ 84.15	Megafil 742M	Megafil 690R	
39	138/136-203D	138/136	K-joint (BW & PP)	All	12.5-50mm	R.O. PQR 033	S690 (3.1)	S690 (3.1)	plate / Ø ≥ 84.15	Megafil 742M	Megafil 690R	
40	141-200	141	V-joint (BW & PP)	All	6.35-25.4mm	R.O. PQR 017	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 30.15	Böhler EML 5		
41	141-200-1	141	V-joint (BW & PP)	All	3 - 14.2mm	R.O. PQR057	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Ø ≥ 24.15	Böhler Union I52		IF PED choose R.O. PQR-057(PED)
42	141-201	141	1/2 V-joint (BW & PP)	All	6.35-25.4mm	R.O. PQR 017	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 30.15	Böhler EML 5		
43	141-201-1	141	1/2 V-joint (BW & PP)	All	3 - 14.2mm	R.O. PQR057	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Ø ≥ 24.15	Böhler Union I52		IF PED choose R.O. PQR-057(PED)
44	141-200C	141	V-joint (BW & PP)	All	3.0 -14.2 mm	R.O. PQR 028	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 84.15	Lincoln 316 Lsi		
45	141-201C	141	1/2 V-joint (BW & PP)	All	3.0 -14.2 mm	R.O. PQR 028	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 84.15	Lincoln 316 Lsi		
46	131-200	131	V-joint (BW & PP)	PA	3-16mm	R.O. PQR 005	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
47	131-201	131	1/2 V-joint (BW & PP)	PA	3-16mm	R.O. PQR 005	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
48	131-202	131	X-joint (BW & PP)	PA	3-16mm	R.O. PQR 005	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
49	131-203	131	K-joint (BW & PP)	PA	3-16mm	R.O. PQR 005	Alu (22, 23.1)	Alu (22, 23.1)	plate / Pipe > 500mm	Böhler Union AlMg5		
50	131-100B	131	Fillet weld	All	3 -40mm	R.O. PQR 047A	Alu (22, 23.1)	Alu (22, 23.1)	Plate	Böhler Union AlMg5		
51	135/136-200C	135/136	V-joint (BW & PP)	All	3-44.4mm	R.O. PQR 055 & 056	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 109,55	ER 316LSi	Foxcore 316L-T1	
52	135/136-201C	135/136	1/2 V-joint (BW & PP)	All	3-44.4mm	R.O. PQR 055 & 056	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 109,55	ER 316LSi	Foxcore 316L-T1	
53	135/136-202C	135/136	X-joint (BW & PP)	All	3-44.4mm	R.O. PQR 055 & 056	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 109,55	ER 316LSi	Foxcore 316L-T1	
54	135/136-203C	135/136	K-joint (BW & PP)	All	3-44.4mm	R.O. PQR 055 & 056	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 109,55	ER 316LSi	Foxcore 316L-T1	

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55	136-200E	136	V-joint (BW & PP)	All	3-24mm	R.O. PQR 061 & 062	1.4462 (10.1)	1.4462 (10.1)	plate / Pipe > 500mm	FOXcore 2209-T1		
56	136-201E	136	1/2 V-joint (BW & PP)	All	3-24mm	R.O. PQR 061 & 062	1.4462 (10.1)	1.4462 (10.1)	plate / Pipe > 500mm	FOXcore 2209-T1		
57	136-202E	136	X-joint (BW & PP)	All	3-24mm	R.O. PQR 061 & 062	1.4462 (10.1)	1.4462 (10.1)	plate / Pipe > 500mm	FOXcore 2209-T1		
58	136-203E	136	K-joint (BW & PP)	all	3-24mm	R.O. PQR 061 & 062	1.4462 (10.1)	1.4462 (10.1)	plate / Pipe > 500mm	FOXcore 2209-T1		
59	141-100	141	FW ml	All	3 - 14.2mm	R.O. PQR 057	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	plate / Ø ≥ 24.15	Böhler Union I52		IF PED choose R.O. PQR-057(PED)
60	WPS 111-100-1	111	FW ml	All	6.75-26.98	R.O. PQR 022	Duplex (10)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
61	WPS 111-100-2	111	FW ml	All	6.75-26.98	R.O. PQR 023	S235, S355 (1.1, 1.2)	316, 304 (8.1)	plate / Ø ≥ 57.15	Böhler FOX CN 23/12 Mo-A		
62	WPS 111-100-3	111	FW ml	All	9.13-68mm	R.O. PQR 014 & 016	S235, S355, S460 (1.1, 1.2, 1.3)	S235, S355, S460 (1.1, 1.2, 1.3)	plate / Ø ≥ 84.15	Lincoln Conarc 49C		preheat temperature depends on material grade
63	138/136-100	138/136	FW ml	All	3 - 20 mm	R.O. PQR 65	S235, S355 (1.1, 1.2)	S235, S355 (1.1, 1.2)	Plate / Ø 30,15 mm Branch ≥ 60°	Böhler Diamondspark 54MC	Böhler Diamondsparc 52RC	
64	135/136-100	135/136	FW ml	All	3-44.4mm	R.O. PQR 055 & 056	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 109,55	ER 316LSi	Foxcore 316L-T1	
65	141-100-1	141	FW ml	All	3.0 -14.2 mm	R.O. PQR 028	316, 304 (8.1)	316, 304 (8.1)	plate / Ø ≥ 84.15	Lincoln 316 Lsi		
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