

13 Appendix

13.1 Selection of coupons, weld process and position

Coupon	Root pass	Fill and capping	Position
Pipe			
1	TIG/GTAW (141)	MMA/SMAW (111)	H-LO45/6G
2	TIG/GTAW (141)	MAG/GMAW (135)	PH/5G
3	TIG/GTAW (141)	FCAW -G (136)	PC/2G
4	MMAW/SMAW (111)	MMAW/SMAW (111)	H-LO45/6G
10 mm Plate			
5	MMAW/SMAW (111)	MMAW/SMAW (111)	PE/4G
6	MMAW/SMAW (111)	MMAW/SMAW (111)	PC/2G
7	MAG/GMAW (135)	MAG/GMAW (135)	PC/2G
8	MAG/GMAW (135)	MAG/GMAW (135)	PF/3G
16 mm Plate			
9	MAG/GMAW (135)	FCAW-G (136)	PA/1G
10	MAG/GMAW (135)	FCAW-G (136)	PC/2G
11	MAG/GMAW (135)	FCAW-G (136)	PF/3G
12	MAG/GMAW (135)	FCAW-G (136)	PE/4G
Fillet Weld			
13	MAG/GMAW (135)		PF/3F
14	MAG/GMAW (135)		PB/2F
15	FCAW-G (136)		PB/2F
16	FCAW-G (136)		PF/3F
17	FCAW-G (136)		PD/4F
18	MMAW/SMAW (111)		PB/2F