

Kemppi Standard WPS Packages

Contents – MMA Welding

WPS CODE	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Welding position	Weld details	Throat thickness (mm)
Fillet welds									
WPS 111-FW-1	111	P/T	FW	1.1/1.2	EN ISO 2560-A E 42 4 B 42 H5	3...7	PA, PB	sl	3...5
WPS 111-FW-2	111	P/T	FW	1.1/1.2		3...7	PC	sl	3...5
WPS 111-FW-3	111	P/T	FW	1.1/1.2		3...7	PD	sl	3...5
WPS 111-FW-4	111	P/T	FW	1.1/1.2		3...7	PF	sl	3...5
WPS 111-FW-5	111	P/T	FW	1.1/1.2		8...12	PA, PB	sl	3...5
WPS 111-FW-6	111	P/T	FW	1.1/1.2		8...12	PC	sl	3...5
WPS 111-FW-7	111	P/T	FW	1.1/1.2		8...12	PD	sl	3...5
WPS 111-FW-8	111	P/T	FW	1.1/1.2		8...12	PF	sl	3...5
WPS 111-FW-9	111	P/T	FW	1.1/1.2		6...10	PA,PB	ml	no restriction
WPS 111-FW-10	111	P/T	FW	1.1/1.2		6...10	PC	ml	no restriction
WPS 111-FW-11	111	P/T	FW	1.1/1.2		6...10	PD	ml	no restriction
WPS 111-FW-12	111	P/T	FW	1.1/1.2		6...10	PF	ml	no restriction
WPS 111-FW-13	111	P/T	FW	1.1/1.2		11...16	PA, PB	ml	no restriction
WPS 111-FW-14	111	P/T	FW	1.1/1.2		11...16	PC	ml	no restriction
WPS 111-FW-15	111	P/T	FW	1.1/1.2		11...16	PD	ml	no restriction
WPS 111-FW-16	111	P/T	FW	1.1/1.2		11...16	PF	ml	no restriction
Butt welds									
WPS 111-BW-1	111	P/T	BW	1.1/1.2	EN ISO 2560-A E 42 4 B 42 H5	3...5	PA	sl	
WPS 111-BW-2	111	P/T	BW	1.1/1.2		3...5	PC	sl	
WPS 111-BW-3	111	P/T	BW	1.1/1.2		3...5	PE	sl	
WPS 111-BW-4	111	P/T	BW	1.1/1.2		3...5	PF	sl	
WPS 111-BW-5	111	P/T	BW	1.1/1.2		5...8	PA	ml	
WPS 111-BW-6	111	P/T	BW	1.1/1.2		5...8	PC	ml	
WPS 111-BW-7	111	P/T	BW	1.1/1.2		5...8	PE	ml	
WPS 111-BW-8	111	P/T	BW	1.1/1.2		5...8	PF	ml	
WPS 111-BW-9	111	P/T	BW	1.1/1.2		6...16	PA	ml	
WPS 111-BW-10	111	P/T	BW	1.1/1.2		6...16	PC	ml	
WPS 111-BW-11	111	P/T	BW	1.1/1.2		6...16	PE	ml	
WPS 111-BW-12	111	P/T	BW	1.1/1.2		6...16	PF	ml	