

Quick Welding Procedure

Base Material:	API 5L Gr. X46 to: API 5L Gr. X56
Preheat Temperature:	10 C (50 F) for t < 25 mm (1 in.) and 79 C (175 F) for t ≥ 25 mm (1 in.) or minimum tensile strength of material greater than 489 Mpa (71 ksi)
Filler Wire (GTAW):	ER70S-3
Interpass temperature:	316 C (600 F) max. Not mentioned in ASME B31.3, taken from API 582
Electrode (SMAW):	E6010 (root) / E7018
Postweld Heat Treatment:	593 - 649 C (1100 - 1200 F) for t > 20 mm (3/4 in.). Apply heat treatment for 1hr/25 mm (1 in.). Minimum holding time is 1 hr.
General Comments:	