

Technical Guidance Sheet ISO 14555 WPS for HD Products - 19mm

WPS02.2 'Through Deck' Welding Procedure Specification for **HD** coated products - 19mm studs

Ref No:	SMD WPS02.2
Manufacturer:	SMD Ltd
WPQR no:	Qualified on site in accordance with BS EN ISO 14555:2104 clause 10.3.2
Parent Material:	Structural Steel to BS EN 10025
Parent Metal Thickness (mm):	>7.6mm
Surface condition:	Unpainted– free of grease, debris, standing water, loose rust or any other coating, with metal decking installed on top (decking with ZM310 - 310g/m ² Magnelis® coating).
Power Source:	415v 3 phase (mains power, static generator or mobile stud welding rig)
Welding Set:	Nelson Nelweld 6000 series (mobile) or Atlas 2800 (static)
Stud-welding process:	Drawn arc with ceramic ferrule – thru' deck welding
Stud designation:	Type SD1 in accordance with BS EN ISO 13918
Stud diameter:	19mm
Stud Material:	In accordance with BS EN ISO 13918
Ceramic ferrule designation:	UF16 in accordance with BS EN ISO 13918 (to be stored in a clean and dry environment)
Welding Gun Head:	Nelson NS20 heavy duty drawn arc hand tool
Welding Position:	PA (flat) in accordance with BS EN ISO 6947
Polarity:	Negative gun/positive earth, 70 volts DC fixed
Number and position of earth:	Two earths opposite sides to each other
Use of damper:	Yes

WPS summary chart

Welding Current (Amps)	Welding Time (S)	Protrusion (mm)	Lift (mm)	Remarks
1500 -150 / +500	1.4 -0.0 / +0.6	6-10mm	4.0 – 6.0mm	None

Manufacturer/Examiner

Structural Metal Decks Ltd

Name Jamie Turner

Date 22nd March 2016

Signature

