

# Universele lasprocedurespecificaties voor MIG/MAG-buislassen (6800005)

135 MAG-lassen met massieve draadelektrode | 136 MAG-lassen met elektrode met fluxkern

## MIG/MAG-buislassen (proces 135, 136, 135 WiseRoot+/136)

WPS-nummer	Proces	Lastype	Soort lasnaad	Materiaalgroep	Toevoegmateriaal	Materiaaldikte (mm)	Buitendiameter van de pijp (mm)	Laspositie	Lasdetails
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### 135 Stuiklassen, buis

WPS 135-BW-T-1	135	T	BW	1.1/1.2/1.4	NEN-EN ISO 14341-A G3Si1	3...4	≥ 44.45	PA	sl, ss, nb/mb
WPS 135-BW-T-2	135	T	BW	1.1/1.2/1.4		3...4	≥ 44.45	PC	sl, ss, nb/mb
WPS 135-BW-T-3	135	T	BW	1.1/1.2/1.4		3...4	≥ 44.45	PH	sl, ss, nb/mb
WPS 135-BW-T-4	135	T	BW	1.1/1.2/1.4		3...4	≥ 44.45	H-L045	sl, ss, nb/mb
WPS 135-BW-T-5	135	T	BW	1.1/1.2/1.4		5...8	≥ 44.45	PA	ml, ss/bs, nb/mb
WPS 135-BW-T-6	135	T	BW	1.1/1.2/1.4		5...8	≥ 44.45	PC	ml, ss/bs, nb/mb
WPS 135-BW-T-7	135	T	BW	1.1/1.2/1.4		5...8	≥ 44.45	PH	ml, ss/bs, nb/mb
WPS 135-BW-T-8	135	T	BW	1.1/1.2/1.4		5...8	≥ 44.45	H-L045	ml, ss/bs, nb/mb
WPS 135-BW-T-9	135	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PA	ml, ss/bs, nb/mb
WPS 135-BW-T-10	135	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PC	ml, ss/bs, nb/mb
WPS 135-BW-T-11	135	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PH	ml, ss/bs, nb/mb
WPS 135-BW-T-12	135	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	H-L045	ml, ss/bs, nb/mb

### 136 Stuiklassen, buis

WPS 136-BW-T-1	136	T	BW	1.1/1.2/1.4	NEN-EN ISO 17632-A T 42 2 P M 1 H5	5...8	≥ 44.45	PA	ml, ss, mb
WPS 136-BW-T-2	136	T	BW	1.1/1.2/1.4	NEN-EN ISO 17632-A T 46 2 P M 1 H5	5...8	≥ 44.45	PC	ml, ss, mb
WPS 136-BW-T-3	136	T	BW	1.1/1.2/1.4	NEN-EN ISO 17632-A T 46 4 P M 2 H10	5...8	≥ 44.45	PH	ml, ss, mb
WPS 136-BW-T-4	136	T	BW	1.1/1.2/1.4		5...8	≥ 44.45	H-L045	ml, ss, mb
WPS 136-BW-T-5	136	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PA	ml, ss, mb
WPS 136-BW-T-6	136	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PC	ml, ss, mb
WPS 136-BW-T-7	136	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	PH	ml, ss, mb
WPS 136-BW-T-8	136	T	BW	1.1/1.2/1.4		8...20	≥ 44.45	H-L045	ml, ss, mb

### 135 WiseRoot+ en 136 Stuiklassen, buis

WPS 135-136-BW-T-1	135 WiseRoot+/136	T	BW	1.1/1.2/1.4	NEN-EN ISO 14341-A G3Si1/NEN-EN ISO 17632-A T 42 2 P M 1 H5	8...10	≥ 44.45	PJ/PA	ml, ss, mb
WPS 135-136-BW-T-2		T	BW	1.1/1.2/1.4		NEN-EN ISO 14341-A G3Si1/NEN-EN ISO 17632-A T 46 2 P M 1 H5	8...10	≥ 44.45	PJ/PCC
WPS 135-136-BW-T-3		T	BW	1.1/1.2/1.4	NEN-EN ISO 14341-A G3Si1/NEN-EN ISO 17632-A T 46 4 P M 2 H10	8...10	≥ 44.45	PJ/PH	ml, ss, mb
WPS 135-136-BW-T-4		T	BW	1.1/1.2/1.4		8...10	≥ 44.45	L-L045/H-L045	ml, ss, mb
WPS 135-136-BW-T-5		T	BW	1.1/1.2/1.4		10...20	≥ 44.45	PJ/PA	ml, ss, mb
WPS 135-136-BW-T-6		T	BW	1.1/1.2/1.4		10...20	≥ 44.45	PJ/PCC	ml, ss, mb
WPS 135-136-BW-T-7		T	BW	1.1/1.2/1.4		10...20	≥ 44.45	PJ/PH	ml, ss, mb
WPS 135-136-BW-T-8		T	BW	1.1/1.2/1.4		10...20	≥ 44.45	L-L045/H-L045	ml, ss, mb

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