

MMA Welding (process 111)

WPS number	Process	Weld type	Joint type	Material group	Filler material	Material thickness (mm)	Welding position	Weld details	Throat thickness (mm)
Filled 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	

Kemppi WPSs for MMA welding can be used for thicknesses under 12 mm with consumables of class EN ISO 2560-A E 42 4 B 42 H5. Even if the thickness is greater than 12 mm, they can be used with filler materials Esab OK 48.00, Böhler FOX EV 50, and Elga P48 S. We have carried out impact toughness tests for those electrodes.

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