



EN1090 Welding from selco

For fabricators of steel and other metal structures

english



THE WELDING LANGUAGE



EN 1090 CE marking

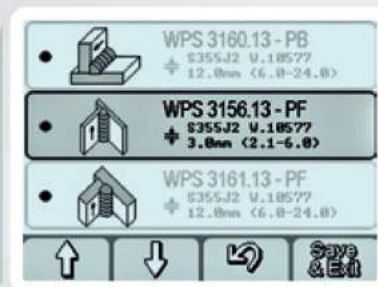
Starting in 2014, all fabricators of steel structures need to CE mark their products in compliance with EN standard 1090-2.

On the one hand, this new legislation will make the European market more competitive by introducing a uniform standard for all countries in the European Community. On the other hand, it will also require fabricators to adapt their working methods and procedures according to the new certification system.

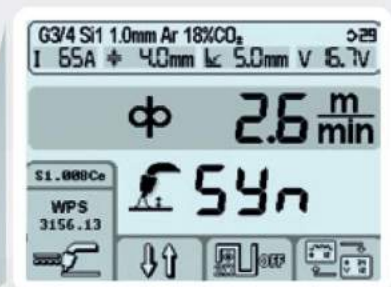
In order to simplify the certification process, Selco is offering a chance to purchase a special 1090 version of its Genesis Series MSE/PME/GSM MIG/MAG welding power sources with 54 welding procedures conforming to EN standard 1090-2 already incorporated. These procedures refer to the most common execution conditions (EN 1090-2, Table 12, Execution Class EXC2) and cover the needs of most normal welding in the field of structural fabrication.



go to the EN 1090 qualified procedures menu



select the procedure you want to use



start welding

Selco can lend a hand!



- Reduced certification costs
- Simplified certification process
- Wide range of welding procedure specifications (WPS) (standard and pulsed MIG/MAG)



Welding power sources with integrated certification

Genesis MSE 1090
MIG/MAG Standard
320 A / 400 A / 500 A

Genesis PME 1090
MIG/MAG Standard
MIG/MAG Pulsed
320 A / 400 A / 500 A

Genesis GSM 1090
MIG/MAG Standard
MIG/MAG Pulsed
TIG DC HF 320 A / 400 A / 500 A



MIG/MAG STANDARD



Steel

- ⊕ G3/4 Si1
- ∅ 0.8 / 1.0 / 1.2 mm
- 👤 82% Ar 18% CO₂
- ⚡ 2.1 - 10.0 mm

selco WELDING PROCEDURE SPECIFICATION **WPS # 3152.13**

Manufacturer / Company: selco sdn bhd
 Certification Body: selco sdn bhd
 Date Issued: 15/08/2013
 Standard Reference: AWS A5.18 ER70S-2
 WPS# Reference: selco WPS 3152.13
 Program Code: S1.007Ca
 Software used: selco WPS 3152.13
 Working process: MIG/MAG
 Joint type: PA
 Type of filler: G3/4 Si1

Grouping base material: Steel
 Shielding gas: Ar
 Base material thickness range: 3.0 - 10.0
 Root face: 0.0 - 0.5
 Root type: V-groove
 Method type of joint: PA
 Intermittent welding: No
 Back gouging: No
 Beveling: No

Diagram showing joint type PA and root face details.

AP OF Position	Welding Position	Welding Position	Welding Position	Welding Position	Welding Position	Welding Position	Welding Position	Welding Position	Welding Position
PA	PA	PA	PA	PA	PA	PA	PA	PA	PA

Code writing conventions: selco WPS 3152.13
 Date: 15/08/2013
 Author: selco WPS 3152.13
 Revision: selco WPS 3152.13
 Drawn: selco WPS 3152.13
 Checked: selco WPS 3152.13
 Approved: selco WPS 3152.13
 Date: 15/08/2013

CERTIFIED WELDING PROCEDURES

	Position	Joint	Base Material	Material Thickness (mm)	Validity Range	Consumable	Gas	∅ (mm)	Program Code	WPS Code
	PA	BW	Steel (≤S355J2)	3.0	2.1 - 3.9	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Ca S1.008Ca S1.009Cf	3152.13
	PC	BW	Steel (≤S355J2)	3.0	2.1 - 3.9	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Cb S1.008Cb S1.009Cg	3153.13
	PF	BW	Steel (≤S355J2)	3.0	2.1 - 3.9	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Cc S1.008Cc S1.009Ch	3154.13
	PB	FW	Steel (≤S355J2)	3.0	2.1 - 6.0	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Cd S1.008Cd S1.009Ci	3155.13
				5.0	3.0 - 10.0	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Ck S1.008Ck S1.009Ck	3170.15
	PF	FW	Steel (≤S355J2)	3.0	2.1 - 6.0	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	S1.007Ce S1.008Ce S1.009Cj	3156.13

MIG/MAG PULSED



Steel

- φ G3/4 Si1
- ∅ 0.8 / 1.0 / 1.2 mm
- 82% Ar 18% CO₂
- 2.1 - 10.0 mm

selco WELDING PROCEDURE SPECIFICATION
WPS # 3162.13

Manufacturer / Company	SELCO Sdn Bhd	Grouping base material	316L
Specification	WPS 316L	WPS 316L	316L
Classification body	SELCO Sdn Bhd	Procedure no reference	SELCO Sdn Bhd
File name	WPS_316L_316L	Working position	PC
Standard reference	EN ISO 12174	Base material thickness range	2.1 - 10.0
MIG/MAG reference	EN ISO 12174	Welding range (mm)	2.1 - 10.0
Program code	P1.007Ca	Shield type	CPMG
Software code	SELCO	Shielded type of joint	CPMG
Welding position	316L	Welding direction	316L
Joint type	316L	Shield geometry	316L
Type of transfer	Pulsed	Backing	316L

Butt Joint

Fillet Joint

WPS	POSITION	THICKNESS	WELDING POSITION	WELDING SPEED	WELDING CURRENT	WELDING VOLTAGE	CLASSIFICATION	WPS CODE
316L	316L	2.1 - 10.0	316L	1.0 - 1.2	1.0 - 1.2	1.0 - 1.2	316L	3162.13

Code welding responsibility: 316L
 Date: 316L
 Issue: 316L
 Quality assurance: 316L
 Date: 316L
 Issue: 316L
 Quality assurance: 316L
 Date: 316L
 Issue: 316L
 Quality assurance: 316L

SELCO Sdn Bhd

CERTIFIED WELDING PROCEDURES

	Position	Joint	Base Material	Material Thickness (mm)	Validity Range	Consumable	Gas	∅ (mm)	Program Code	WPS Code
	PA	BW	Steel (≤S355J2)	3.0	2.1 - 3.9	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	P1.007Ca P1.008Ca P1.009Cd	3162.13
	PC	BW	Steel (≤S355J2)	3.0	2.1 - 3.9	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	P1.007Cb P1.008Cb P1.009Ce	3163.13
	PB	FW	Steel (≤S355J2)	3.0	2.1 - 6.0	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	P1.007Cc P1.008Cc P1.009Cf	3164.13
	PB	FW	Steel (≤S355J2)	5.0	3.0 - 10.0	G3/4 Si1 ER70-S	82%Ar18%CO ₂ (M21)	0.8 1.0 1.2	P1.007Cg P1.008Cg P1.009Cg	3169.15



cod. 90.08.18601 rev/A

Our attention to "research & development" may lead to changes in the information given here.



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THE WELDING LANGUAGE

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