

descriptif d'un mode opératoire de soudage (DMOS) Musterbau GmbH											SchoolM ID-51 Rev.-Date: 13/12/2019 Rev.: 01.0 Page: 5
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Interne n°	ID	processus	Statut	WPQR	P/T	Matériau group	t ₁ / t ₂	D	Position	Exécution de la soudure	Dénomination selon norme	Nom commercial
WPS/WPQR-001-01	000001	111/00	WPS-	WPQR-001	P FW	1.1/1.1	3.0/3.0	0.0	PB	ss sl	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-002-01	000002	111/00	WPS-	WPQR-002	P FW	1.1/1.1	5.0/5.0	0.0	PB	ss sl	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-003-01	000003	111/00	WPS-	WPQR-003	P BW	1.2/1.2	3.0/3.0	0.0	PA	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-004-01	000004	111/00	WPS-	WPQR-004	P BW	1.2/1.2	5.0/5.0	0.0	PA	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-005-01	000005	311/00	WPS-	WPQR-005	T BW	1.1/1.1	3.2/3.2	48.0	PH-L045	ss nb rw	EN 12536-O III	Union Rot N
WPS/WPQR-006-01	000006	311/00	WPS-	WPQR-006	T BW	1.1/1.1	3.2/3.2	48.0	PC	ss nb lw	EN 12536-O III	Union Rot N
WPS/WPQR-007-01	000007	135/00	WPS-	WPQR-007	P FW	1.1/1.1	5.0/5.0	0.0	PB	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-008-01	000008	135/00	WPS-	WPQR-000 8-01	P FW	1.2/1.2	12.0/12.0	0.0	PD	ss ml	ISO 14341-A: G 42 4 M G3Si1	CastoMag 45202
WPS/WPQR-009-01	000009	135/00	WPS-	2023-01-0 6	T FW	1.1/1.1	3.0/2.6	48.3	PB	ss sl	ISO 14341-A-G3Si1	Carbofil 1
WPS/WPQR-010-01	000010	135/00	WPS-	WPQR-001 0-01	P BW	1.1/1.1	5.0/5.0	0.0	PF	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
WPS/WPQR-011-01	000011	135/00	WPS-	WPQR-001 1-01	T BW	1.1/1.1	2.6/2.6	48.2	PH	ss nb	ISO 14341-A-G4Si1	DT-SG 3
WPS/WPQR-012-01	000012	111/00	WPS-		T BW	1.3/1.3	0.0/0.0	16.0	PA	bs nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-013-01	000013	111/00	WPS-		T BW	1.3/1.3	0.0/0.0	8.0	PA	ss nb	ISO 2560-A E 42 4 B 4 2 H5	OK 48.00
WPS/WPQR-014-01	000014	111/00	WPS-		T FW	1.3/1.3	10.0/0.0	28.0	PA	ss ml	ISO 2560-A-E 42 6 B 32	Castolin 6666
WPS/WPQR-015-01	000015	141/00	WPS-		T BW	8.1/8.1	3.2/3.2	80.0	PC	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
WPS/WPQR-016-01	000016	141/00	WPS-		T BW	8.1/8.1	3.2/3.2	80.0	PH-L045	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
WPS/WPQR-017-01	000017	135/00	pWPS		P FW	1.1/1.1	3.0/3.0	0.0	PA	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-018-01	000018	135/00	WPS-		P FW	1.1/1.1	5.0/5.0	0.0	PA	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-019-01	000019	135/00	WPS-		P FW	1.1/1.1	10.0/10.0	0.0	PA	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-020-01	000020	135/00	WPS-		P FW	1.1/1.1	12.0/12.0	0.0	PA	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-021-01	000021	135/00	WPS-		P FW	1.2/1.2	3.0/3.0	0.0	PA	ss sl	ISO 14341-A: G 42 4 M G3Si1	CastoMag 45202
WPS/WPQR-022-01	000022	135/00	WPS-		P FW	1.2/1.2	5.0/5.0	0.0	PA	ss sl	ISO 14341-A: G 42 4 M G3Si1	CastoMag 45202
WPS/WPQR-023-01	000023	135/00	WPS-		P FW	1.2/1.2	10.0/10.0	0.0	PA	ss ml	ISO 14341-A: G 42 4 M G3Si1	CastoMag 45202
WPS/WP3R-024-01-01	000024	135/00	WPS-		P FW	1.2/1.2	12.0/12.0	0.0	PA	ss ml	ISO 14341-A: G 42 4 M G3Si1	CastoMag 45202
WPS/WPQR-025-01	000025	135/00	WPS-	WPQR-025 -1	P FW	1.1/1.1	5.0/5.0	0.0	PB	bs sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202

WPS/WPQR-026-01	000026	135/00	WPS-		P FW	1.1/1.1	10.0/10.0	0.0	PB	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000027	135/00	pWPS		P FW	1.1/1.1	12.0/12.0	0.0	PB	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000028	135/00	pWPS		P FW	1.1/1.1	8.0/8.0	0.0	PD	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000029	135/00	pWPS		P FW	1.1/1.1	10.0/10.0	0.0	PD	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000030	135/00	pWPS		P FW	1.1/1.1	12.0/12.0	0.0	PD	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000031	135/00	pWPS		P FW	1.1/1.1	5.0/5.0	0.0	PF	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000032	135/00	pWPS		P FW	1.1/1.1	8.0/8.0	0.0	PF	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000033	135/00	pWPS		P FW	1.1/1.1	10.0/10.0	0.0	PF	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000034	135/00	pWPS		P FW	1.1/1.1	12.0/12.0	0.0	PF	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000035	135/00	pWPS		P FW	1.1/1.1	3.0/3.0	0.0	PG	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000036	135/00	pWPS		P FW	1.1/1.1	5.0/5.0	0.0	PG	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000037	135/00	pWPS		P FW	1.1/1.1	8.0/8.0	0.0	PG	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
	000038	135/00	pWPS		P BW	1.1/1.1	3.0/3.0	0.0	PA	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000039	135/00	pWPS		P BW	1.1/1.1	5.0/5.0	0.0	PA	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000040	135/00	pWPS		P BW	1.1/1.1	10.0/10.0	0.0	PA	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000041	135/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PA	ss nb	ISO 14341-A-G3Si1	Carbofil 1
WPS/WPQR-42-01	000042	135/00	pWPS		P BW	1.1/1.1	3.0/3.0	0.0	PC	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000043	135/00	pWPS		P BW	1.1/1.1	5.0/5.0	0.0	PC	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000044	135/00	pWPS		P BW	1.1/1.1	10.0/10.0	0.0	PC	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000045	135/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PC	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000046	135/00	pWPS		P BW	1.1/1.1	3.0/3.0	0.0	PE	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000047	135/00	pWPS		P BW	1.1/1.1	5.0/5.0	0.0	PE	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000048	135/00	pWPS		P BW	1.1/1.1	10.0/10.0	0.0	PE	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000049	135/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PE	ss nb	ISO 14341-A-G3Si1	Carbofil 1
	000050	135/00	pWPS		P BW	1.1/1.1	10.0/10.0	0.0	PF	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000051	135/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PF	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000052	135/00	pWPS		T FW	1.2/1.2	5.0/3.6	88.9	PB	ss sl	ISO 14341-A-G 46 4 M G4Si1	Automag 3
	000053	135/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PB	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000054	135/00	pWPS		T FW	1.1/1.1	3.0/2.6	48.3	PD	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000055	135/00	pWPS		T FW	1.2/1.2	5.0/3.6	88.9	PD	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000056	135/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PD	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000057	135/00	pWPS		T FW	1.1/1.1	3.0/2.6	48.3	PH	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000058	135/00	pWPS		T FW	1.2/1.2	5.0/3.6	88.9	PH	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000059	135/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PH	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000060	135/00	pWPS		T BW	1.1/1.1	3.6/3.6	88.9	PH	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000061	135/00	pWPS		T BW	1.1/1.1	10.0/10.0	159.0	PH	ss nb	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
	000062	111/00	pWPS		P FW	1.1/1.1	10.0/10.0	0.0	PB	ss ml	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000063	111/00	WPS-	WPQR 0063	P FW	1.1/1.1	12.0/12.0	0.0	PB	ss ml	ISO 2560-A-E 42 6 B 32	Castolin 6666

	000064	111/00	WPS-	WPQR-006 4-01	T FW	1.1/1.1	2.6/3.0	48.3	PB	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
WPS/WPQR-065-01	000065	111/00	WPS-	WPQR-006 5-01	T FW	1.1/1.1	3.6/5.0	108.0	PB	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000066	111/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PB	ss ml	ISO 2560-A-E 38 2 RB 12	CITOREX
	000067	111/00	WPS-	WPQR-067 -01	T FW	1.1/1.1	2.5/3.6	83.0	PB	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000068	111/00	WPS-	WPQR-006 8-01	T FW	1.1/1.1	2.6/3.0	48.3	PD	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000069	111/00	WPS-	WPQR-006 9-01	T FW	1.1/1.1	3.6/5.0	88.9	PD	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000070	111/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PD	ss ml	ISO 2560-A-E 38 2 RB 12	CITOREX
	000071	111/00	WPS-	WPQR-007 1-01	T FW	1.1/1.1	3.6/5.0	88.9	PH	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000072	111/00	WPS-	WPQR-007 2-01	T FW	1.1/1.1	5.0/3.6	88.9	PH	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000073	111/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PH	ss ml	ISO 2560-A-E 38 2 RB 12	CITOREX
	000074	111/00	WPS-	WPQR-007 4-01	T FW	1.1/1.1	3.6/5.0	88.9	PJ	ss sl	ISO 2560-A-E 38 0 RC 11	OVERCORD
	000075	111/00	WPS-	WPQR-007 5-01	T FW	1.1/1.1	5.0/3.6	88.9	PJ	ss sl	ISO 2560-A-E 38 0 RC 11	OVERCORD
	000076	111/00	pWPS		T FW	1.1/1.1	10.0/10.0	159.0	PJ	ss ml	ISO 2560-A-E 38 0 RC 11	OVERCORD
	000077	111/00	pWPS		P BW	1.2/1.2	10.0/10.0	0.0	PA	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000078	111/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PA	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000079	111/00	pWPS		P BW	1.2/1.2	3.0/3.0	0.0	PC	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000080	111/00	pWPS		P BW	1.2/1.2	5.0/5.0	0.0	PC	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000081	111/00	pWPS		P BW	1.2/1.2	10.0/10.0	0.0	PC	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000082	111/00	pWPS		P BW	1.2/1.2	3.0/3.0	0.0	PE	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000083	111/00	pWPS		P BW	1.2/1.2	5.0/5.0	0.0	PE	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000084	111/00	pWPS		P BW	1.2/1.2	10.0/10.0	0.0	PE	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000085	111/00	pWPS		P BW	1.2/1.2	5.0/5.0	0.0	PF	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000086	111/00	pWPS		P BW	1.2/1.2	10.0/10.0	0.0	PF	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000087	111/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PF	ss nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000088	111/00	pWPS		P BW	1.2/1.2	3.0/3.0	0.0	PG	ss nb	ISO 2560-A-E 42 2 C 25	Phoenix CEL 70
	000089	111/00	pWPS		P BW	1.2/1.2	5.0/5.0	0.0	PG	ss nb	ISO 2560-A-E 42 2 C 25	Phoenix CEL 70
	000090	111/00	pWPS		P BW	1.2/1.2	10.0/10.0	0.0	PG	ss nb	ISO 2560-A-E 42 2 C 25	Phoenix CEL 70
	000091	141/00	pWPS		T BW	8.1/8.1	2.0/2.0	21.3	PA	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000092	141/00	pWPS		T BW	8.1/8.1	2.0/2.0	21.3	PA	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS

	000093	141/00	pWPS		T BW	8.1/8.1	2.0/2.0	21.3	PH	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
WPS/WPQR-94-01	000094	141/00	pWPS		T BW	8.1/8.1	2.0/2.0	21.3	PH-L045	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000095	141/00	pWPS		T BW	8.1/8.1	5.0/5.0	106.0	PA	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000096	141/00	pWPS		T BW	8.1/8.1	5.0/5.0	106.0	PC	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000097	141/00	pWPS		T BW	8.1/8.1	5.0/5.0	106.0	PH	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
WPS/WPQR-098-01	000098	141/00	WPS-		T BW	8.1/8.1	5.0/5.0	106.0	PH-L045	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000099	141/00	pWPS		P FW	22.3/22.3	5.0/5.0	0.0	PB	ss sl	ISO 18273-S Al 5356A (AlMg5Cr(A))	berAlweld M5356
	000100	141/00	pWPS		P FW	22.3/22.3	5.0/5.0	0.0	PD	ss sl	ISO 18273-S Al 5356A (AlMg5Cr(A))	berAlweld M5356
	000101	141/00	pWPS		P FW	22.3/22.3	5.0/5.0	0.0	PE	ss sl	ISO 18273-S Al 5356A (AlMg5Cr(A))	berAlweld M5356
WPS/WPQR-102-01	000102	141/00	WPS-	WPQR-010 2-01	P FW	22.3/22.3	5.0/5.0	0.0	PF	ss sl	ISO 18273-S Al 5356A (AlMg5Cr(A))	berAlweld M5356
	000103	111/00	pWPS		T BW	1.3/1.3	0.0/0.0	16.0	PC	bs nb	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000104	111/00	pWPS		T FW	1.3/1.3	10.0/0.0	16.0	PB	bs sl	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000105	111/00	pWPS		T FW	1.3/1.3	10.0/0.0	28.0	PD	ss ml	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000106	912/00	pWPS		P TJ	300/300	2.0/2.0	0.0	PB	FF ma Q	ISO 17672: CuP 281	
	000107	912/00	pWPS		T LJ	100/100	2.0/2.0	30.0	PB	FF ma F	ISO 17672: Ag 130	AH 30030 U
	000108	912/00	pWPS		T LJ	300/300	2.0/2.0	30.0	PB	FF ma Q	ISO 17672: CU 733	FONTARGEN A 101
	000109	912/00	pWPS		P LJ	300/300	2.0/2.0	0.0	PB	FF ma Q	ISO 17672: CuP 281	
	000110	912/00	pWPS		T LJ	300/300	2.0/2.0	30.0	PD	FF ma S	ISO 17672: CuP 281	
WPS/WPQR-111-01	000111	135/00	WPS-	WPQR-111	P FW	1.1/1.1	8.0/8.0	0.0	PB	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-112-01	000112	135/00	WPS-		T FW	1.1/1.1	10.0/10.0	159.0	PH	ss ml	ISO 14341-A-G 42 4 M21 3Si1	CARBOFIL 1
WPS/WPQR-113-01	000113	135/00	WPS-		P FW	1.1/1.1	3.0/3.0	0.0	PB	ss sl	ISO 14341-A-G 42 4 M21 3Si1	CASTOMAG 45202
WPS/WPQR-114-01	000114	135/00	WPS-		P BW	1.1/1.1	12.0/12.0	0.0	PE	ss nb	ISO 14341-A-G4Si1	OK Autrod 12.64
WPS/WPQR-115-01	000115	111/00	WPS-	WPQR-115	T FW	1.1/1.1	2.6/3.0	48.3	PB	ss sl	ISO 2560-A-E 38 2 RB 12	CITOREX
	000116	111/00	pWPS		P BW	1.1/1.1	12.0/12.0	0.0	PA	bs nb kl	ISO 2560-A-E 42 6 B 32	Castolin 6666
	000117	912/00	pWPS		P BJ	300/300	3.0/3.0	0.0	PA	FF ma F	ISO 17672: CuP 279	
	000118	141/00	pWPS		T BW	23.1/23.1	8.0/8.0	159.0	PC	ss nb	ISO 18273-S Al 4043 (AlSi5)	CastoWig 45803 W
	000119	111/00	pWPS		T BW	1.1/1.1	5.0/5.0	88.9	PH	ss nb	ISO 2560-A-E 38 2 RB 12	CITOREX
	000120	111/00	pWPS		T BW	1.1/1.1	10.0/10.0	159.0	PH	ss nb	ISO 2560-A-E 38 2 RB 12	CITOREX
	000121	141/111	pWPS		T BW	8.1/8.1	8.0/8.0	108.0	PH-L045	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS

	000122	141/00	pWPS		P BW	8.1/8.1	2.0/2.0	0.0	PC	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000123	141/00	pWPS		P BW	8.1/8.1	5.0/5.0	0.0	PC	ss mb gb	ISO 14343-A-W 19 12 3 Nb	CastoWig 45553 WS
	000124	131/00	WPS-		P BW	23.1/23.1	8.0/8.0	0.0	PF	ss nb	ISO 18273-S Al 4043 (AlSi5(A))	CastoMag 45803