WELDING PROCEDURE SPECIFICATION (WPS)

Welding Procedure
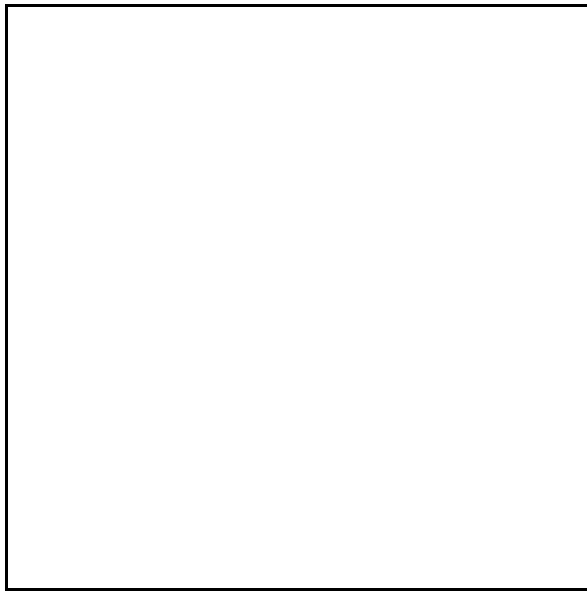Specification No. _____   Date _____   Approved _____

Revisions _____   Date _____   Approved _____

                  _____   _____   _____

                  _____   _____   _____

Supporting PQR Numbers _____   _____   _____   _____

                  _____   _____   _____   _____

_____

Joints

Groove Design Sketch

Filler Metal

F-No. _____   AWS No. _____
                                                       Class

Size of electrode _____

Type of electrode _____

Other _____

      _____

      _____

      _____

      _____

Shielding Gas

Shielding gas(es) _____

Percent composition_____

Flow rate_____

Other _____

      _____

      _____

      _____

Backing

Type _____

Permanent _____

Removed _____

Other _____

      _____

      _____

      _____

      _____

Position

Position of groove_____

Welding progression_____

Other _____

      _____

      _____

      _____

      _____

Base Metals

M No. _____   Thickness _____ to _____

Alloy and Temper _____

Preheat

Preheat temperature _____

Interpass temperature _____

Form F(a)

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Cleaning

Initial cleaning oxide_____

Initial cleaning oil and dirt_____

Interpass cleaning _____

_____

Postweld Heat Treatment

Original temper _____

Final temper _____

Temperature _____

Time _____

Quench _____

_____

Process(es)

Process _____   Type*_____

Process _____   Type*_____

Electrode (GTAW) _____

_____

Technique

Stringer or weave bead _____

Orifice or gas cup size _____

Oscillation _____

Contact tube to work distance _____
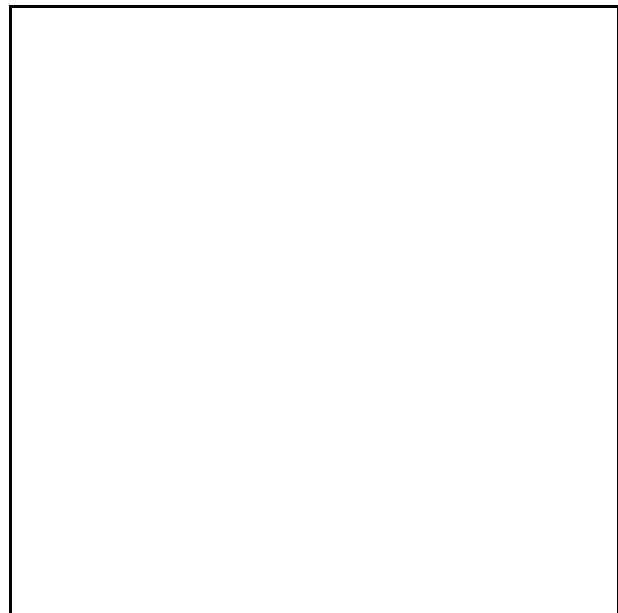
Single pass or multipass _____
per side

Tungsten extension _____

Method of backgouging _____

Other _____

_____

_____

_____

_____

*Manual, automatic, polarity, pulse, etc.

Pass No.	Welding Process	Amps	Volts	Travel Speed

Sketch of Welding Sequence

Form F(a) (Continued)

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