

WPS QUALIFICATION TEST RECORD FOR ELECTROSLAG AND ELECTROGAS WELDING

PROCEDURE SPECIFICATION

Material specification _____
 Welding process _____
 Position of welding _____
 Filler metal specification _____
 Filler metal classification _____
 Filler metal _____
 Flux _____
 Shielding gas _____ Flow rate _____
 Gas dew point _____
 Thickness range this test qualifies _____
 Single or multiple pass _____
 Single or multiple arc _____
 Welding current _____
 Preheat temperature _____
 Postheat temperature _____
 Welder's name _____
 Guide tube flex _____
 Guide tube composition _____
 Guide tube diameter _____
 Vertical rise speed _____
 Traverse length _____
 Traverse speed _____
 Dwell _____
 Type of molding shoe _____

VISUAL INSPECTION (Table 6.1, Cyclically loaded limitations)

Appearance _____
 Undercut _____
 Piping porosity _____
 Test date _____
 Witnessed by _____

TEST RESULTS

Reduced-section tensile test

Tensile strength, psi
 1. _____
 2. _____

All-weld-metal tension test

Tensile strength, psi _____
 Yield point/strength, psi _____
 Elongation in 2 in, % _____

Side-bend tests

1. _____ 3. _____
 2. _____ 4. _____

Radiographic-ultrasonic examination

RT report no. _____
 UT report no. _____

Impact tests

Size of specimen _____ Test temp _____
 Ft-lb: 1. _____ 2. _____ 3. _____ 4. _____
 5. _____ 6. _____ Avg. _____
 High _____ Low _____
 Laboratory test no. _____

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Joint Detail
		Amperes	Volts	

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 4 of AWS D1.1/D1.1M, (_____) *Structural Welding Code—Steel*.
 (year)

Procedure no. _____

Manufacturer or Contractor _____

Revision no. _____

Authorized by _____

Form N-3

Date _____