

Sample WPS Form (GTAW & SMAW) WELDING PROCEDURE SPECIFICATION (WPS)

Company Name _____	WPS No. _____	Rev. No. _____	Date _____
Authorized by _____	Date _____	Supporting PQR(s) _____	CVN Report _____

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material			
Welded To			
Backing Material			
Other			

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds		
CJP Groove w/CVN		
PJP Groove Welds		
Fillet Welds		
DIAMETER		

JOINT DETAILS	
Groove Type	
Groove Angle	
Root Opening	
Root Face	
Backgouging	
Method	

JOINT DETAILS (Sketch)

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE									
Weld Layer(s)									
Weld Pass(es)									
Process									
Type (<i>Manual, Mechanized, etc.</i>)									
Position									
Vertical Progression									
Filler Metal (AWS Spec.)									
AWS Classification									
Diameter									
Manufacturer/Trade Name									
Shielding Gas Compos. (GTAW)									
Flow Rate (GTAW)									
Nozzle Size (GTAW)									
Preheat Temperature									
Interpass Temperature									
Electrical Characteristics	—	—	—	—	—	—	—	—	—
Electrode Diameter (GTAW)									
Current Type & Polarity									
Amps									
Volts									
Cold or Hot Wire Feed (GTAW)									
Travel Speed									
Maximum Heat Input									
Technique	—	—	—	—	—	—	—	—	—
Stringer or Weave									
Multi or Single Pass (per side)									
Oscillation (GTAW Mech./Auto.)									
Traverse Length									
Traverse Speed									
Dwell Time									
Peening									
Interpass Cleaning									
Other									