

Sample WPS Form (SAW) 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	SAW							
Type (<i>Semiautomatic, Mechanized, etc.</i>)								
Position								
Filler Metal (AWS Spec.)								
AWS Classification								
Electrode Diameter								
Electrode/Flux Classification								
Manufacturer/Trade Name								
Supplemental Filler Metal								
Preheat Temperature								
Interpass Temperature								
Electrical Characteristics	—	—	—	—	—	—	—	—
Current Type & Polarity								
Amps								
Volts								
Wire Feed Speed								
Travel Speed								
Maximum Heat Input								
Technique	—	—	—	—	—	—	—	—
Stringer or Weave								
Multi or Single Pass (per side)								
Number of Electrodes								
Longitudinal Spacing of Arcs								
Lateral Spacing of Arcs								
Angle of Parallel Electrodes								
Angle of Electrode (Mech./Auto.)								
Normal To Direction of Travel								
Oscillation (<i>Mechanized/Automatic</i>)								
Traverse Length								
Traverse Speed								
Dwell Time								
Peening								
Interpass Cleaning								
Other								