

WELDING PROCEDURE SPECIFICATION (WPS)

Company Name _____
Welding process(es) _____
Supporting PQR No.(s) _____

JOINT DESIGN

Type: _____
 Single Double Weld
 Backing: Yes No
 Backing Material: N/A _____
 Root Opening _____ Root Face Dimension _____
 Groove Angle _____ Radius (J-U) _____
 Back Gouging Yes No Method _____

BASE METALS

Material Spec. _____
 Type or Grade _____
 Thickness: Groove _____ Fillet _____
 Diameter _____

FILLER METALS

Specification _____

SHIELDING

Flux _____ Gas _____
 Composition _____
 Electro-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

PREHEAT

Preheat Temp., Min _____
 Inter-pass Temp., Min _____ Max _____

Identification #

Revision _____ Date _____ By _____
 Authorized By _____ Date _____
 Type Manual Semi-Automatic
 Mechanized Automatic

Position _____

ELECTRICAL CHARACTERISTICS

General Characteristics _____
 Current AC DCEP DCEN Pulsed
 Other _____

Tungsten Electrode (GTAW/PAW)

Size: _____
 Type: _____

TECHNIQUE

Stringer or Weave Bead _____
 Multi-pass or Single Pass (per side) _____
 Number of Electrodes _____
 Peening _____
 Inter-pass Cleaning _____
 Other _____

POSTWELD HEAT

Temp _____
 Time _____

WELDING PROCEDURE

Pass or Weld Layers	Process	Filler Metals		Current			Travel Speed*	Joint Details
		Class	Diam	Type & Polarity	Amps or Wire Feed Speed*	Volts*		
					*	*	*	

* N/A for manual process. These settings are not visible to the welder with the Hood Down

Figure 5.13—Welding Procedure Specification (WPS) Form