

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 _____
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WELDING PROCEDURE

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

* 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