

SAMPLE FORM FOR WELDING PROCEDURE SPECIFICATION (WPS)

Company Name _____
 WPS No. _____ Rev. _____ Date _____
 Supporting Procedure Qualification Record No. _____
 Welding Process(es) _____ Type _____ Transfer Mode (GMAW) _____
 (Automatic, Manual, etc.) _____

JOINT (Table 6.1)

Type of Joint _____
 Type of Weld _____
 Backing Yes No
 Backing Material Type _____
 Butt Welded From:
 One Side Both Sides

GAS or GAS Mixture (1.6.6.2)

Composition _____
 Flow Rate _____

FLUX (1.6.5.2)

Specification _____
 Classification _____

POSITION (Table 1.3)

Position _____
 Progression (vertical position)
 Up Down

PREHEAT (1.1, 7.4, Annex A)

Preheat Temperature Min. _____
 Preheat Temperature Max. _____

POST WELD HEAT TREATMENT

Temperature _____
 Time _____

BASE METAL (1.4)

| | | |
|-----------------|-------------|------------------|
| | Sheet Steel | Supporting Steel |
| Specification | _____ | _____ |
| Grade | _____ | _____ |
| Thickness Range | _____ | _____ |
| Preparation | _____ | _____ |

SKETCH OF JOINT DETAILS

COATING(S) [Table 6.2(12)]

| | | |
|-------------------|-------|-------|
| Coating Type | _____ | _____ |
| Coating Thickness | _____ | _____ |

FILLER METAL (Table 1.2)

Specification _____
 Classification _____

GTAW ELECTRODE _____

| TECHNIQUE-Welding Characteristics | | | | | | | | |
|-----------------------------------|---------|----------------|-------------------------|----------|---------|-----------------|--------------|--------------------------------------|
| Pass No. | Process | Electrode Size | Current Type & Polarity | Amperage | Voltage | Wire Feed Speed | Melting Rate | Travel Speed/ Weld Time (Spot Welds) |
| | | | | | | | | |
| | | | | | | | | |
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Authorized by _____ Name/Title _____ Date _____