

### WELDING PROCEDURE SPECIFICATION (WPS)

Welding Procedure

Specification No. \_\_\_\_\_ Date \_\_\_\_\_ Approved \_\_\_\_\_

Revisions \_\_\_\_\_ Date \_\_\_\_\_ Approved \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

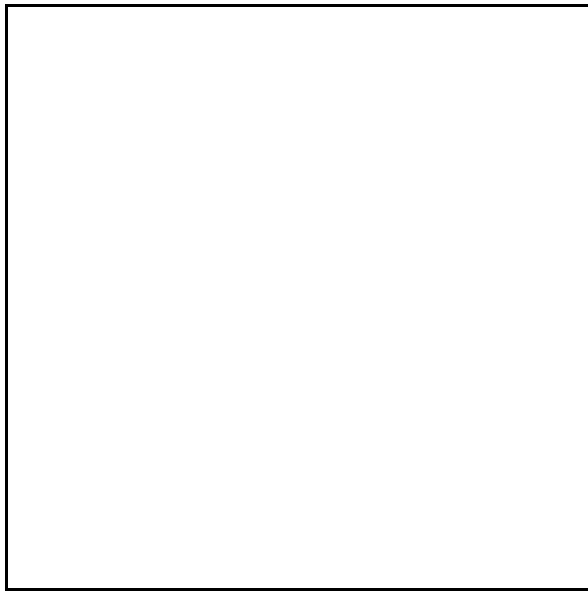
\_\_\_\_\_

Supporting PQR Numbers \_\_\_\_\_

\_\_\_\_\_

#### Joins

##### Groove Design Sketch



#### Filler Metal

F-No. \_\_\_\_\_ AWS No. \_\_\_\_\_ Class \_\_\_\_\_

Size of electrode \_\_\_\_\_

Type of electrode \_\_\_\_\_

Other \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

#### Shielding Gas

Shielding gas(es) \_\_\_\_\_

Percent composition \_\_\_\_\_

Flow rate \_\_\_\_\_

Other \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

#### Backing

Type \_\_\_\_\_

Permanent \_\_\_\_\_

Removed \_\_\_\_\_

Other \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

#### Base Metals

M No. \_\_\_\_\_ Thickness \_\_\_\_\_ to \_\_\_\_\_

Alloy and Temper \_\_\_\_\_

#### Position

Position of groove \_\_\_\_\_

Welding progression \_\_\_\_\_

Other \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

#### Preheat

Preheat temperature \_\_\_\_\_

Interpass temperature \_\_\_\_\_

**WELDING PROCEDURE SPECIFICATION (WPS)**

**Cleaning**

Initial cleaning oxide \_\_\_\_\_

Initial cleaning oil and dirt \_\_\_\_\_

Interpass cleaning \_\_\_\_\_

\_\_\_\_\_

**Postweld Heat Treatment**

Original temper \_\_\_\_\_

Final temper \_\_\_\_\_

Temperature \_\_\_\_\_

Time \_\_\_\_\_

Quench \_\_\_\_\_

\_\_\_\_\_

**Process(es)**

Process \_\_\_\_\_ Type\* \_\_\_\_\_

Process \_\_\_\_\_ Type\* \_\_\_\_\_

Electrode (GTAW) \_\_\_\_\_

\_\_\_\_\_

**Technique**

Stringer or weave bead \_\_\_\_\_

Orifice or gas cup size \_\_\_\_\_

Oscillation \_\_\_\_\_

Contact tube to work distance \_\_\_\_\_

Single pass or multipass \_\_\_\_\_  
per side

Tungsten extension \_\_\_\_\_

Method of backgouging \_\_\_\_\_

Other \_\_\_\_\_

\_\_\_\_\_

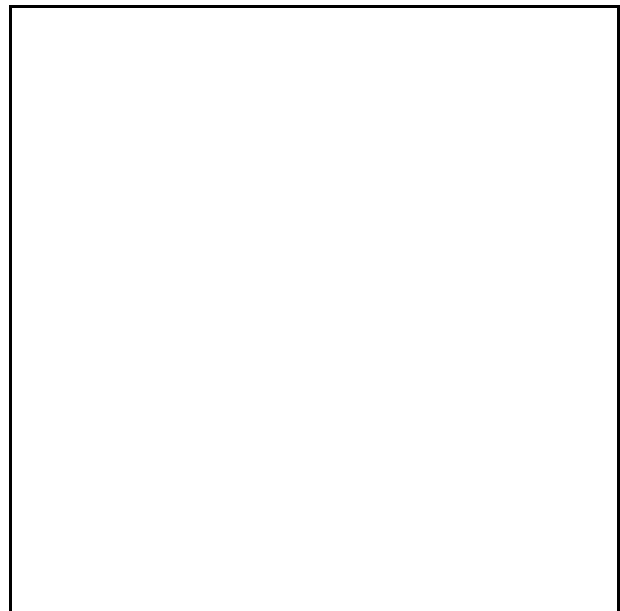
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\_\_\_\_\_

\_\_\_\_\_

\*Manual, automatic, polarity, pulse, etc.

Pass No.	Welding Process	Amps	Volts	Travel Speed



**Sketch of Welding Sequence**