

**WELDING PROCEDURE SPECIFICATION (WPS)
FOR STUD WELDING APPLICATIONS**

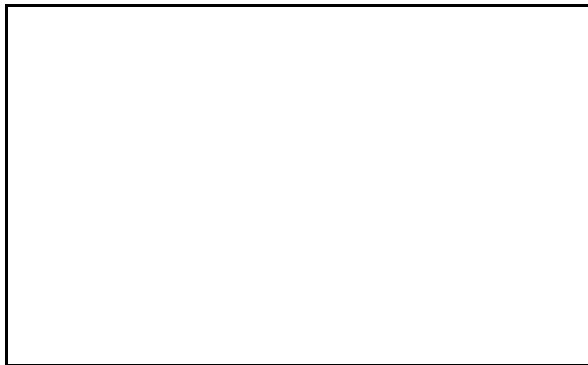
Specification No. _____ Date _____ Approved _____

Revisions _____ Date _____ Approved _____

Supporting PQR Numbers _____

Joints

Stud Base Sketch



Welding Process

Arc Stud Welding _____

Capacitor Discharge _____

Contact Method _____

Gap Method _____

Drawn Arc Method _____

Cleaning

Initial Oxide Cleaning _____

Initial Oil & Dirt Cleaning _____

Machine Settings

Power Supply Make _____

Stud Gun Model _____

Current/Polarity _____

Amperage Range Setting _____

Stud-to-work Distance _____

Lift Setting _____

Cable Size _____ Length _____

Form E(d)

Base Metals

M-No. _____ Specification _____

Thickness _____ to _____

Alloy and Temper _____

Pipe or Tube Diameter _____

Alloy and Temper _____

Stud Materials

F-No. _____ Specification _____

Stud Diameter _____

Other _____

Shielding Gas

Shielding Gas(es) _____

Percent Composition _____

Flow Rate _____

Other _____

Ferrules

Ferrule Material _____

Ferrule Specification _____

Ferrule Description _____

Model No. _____

Timer Range Setting _____

Capacitance or Power Tap Setting _____

Other _____
