

ESW-NG WELDING PROCEDURE SPECIFICATION	Document No.: _____	
	Issue Date: _____ Rev. _____	
	Page No.: _____	
	Prepared by: _____	
	Approved: _____	

Date:	WPS No.:		
Specification/Code:	Material Specification:		
Specification Process: ESW-NG	Welding/Machine: MECHANIZED—AUTOMATIC		
Material Thickness:	Weld Thickness (for Transition Joints):		
Filler Metal Specification:	Filler Metal Classification:		
Filler Metal Manufacturer:	Trade Name:		
Shielding Gas: N/A	Flow Rate: N/A	Dew Point: N/A	

Single/Multiple Pass: SINGLE	Preheat Temperature: NO PREHEAT REQUIREMENT		
Welding Current:	Postheat Requirements: NONE		
Polarity:	Interpass Temperature: N/A		
Root Treatment:			

Preweld Flux Dump:	Flux Type:		
Initial Flux Feed:	Current:		
In-Weld Flux Feed:	Voltage:		
Vertical Rate of Rise (in weld):	Wire Feed Rate:		
Electrode Diameter:	Number of Electrodes:		
Sealing Material for Slag Run-Out:			

Form N-10

Form N-10—ESW-NG Welding Procedure Specification

COOLING SHOES			WELD JOINT DETAIL		CONSUMABLE GUIDE	
Shoe Material:			Welding Position: VERTICAL		Guide Material:	
A:	B:	C:	Progression: UPWARD		A:	B:

Authorized by:	Approval:
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Form N-10

Form N-10 (Continued)—ESW-NG Welding Procedure Specification