

**WELDING PROCEDURE SPECIFICATION (WPS) Yes**   
**QUALIFIED BY TESTING \_\_\_\_\_**  
**or PROCEDURE QUALIFICATION RECORDS (PQR) Yes**

Company Name \_\_\_\_\_  
 Welding Processes \_\_\_\_\_  
 Supporting PQR No.(s) \_\_\_\_\_  
**TYPE OF WELDING**  
 Manual  Machine   
 Semiautomatic  Automatic   
**JOINT DESIGN USED**  
 Type \_\_\_\_\_  
 Single  Double Weld   
 Backing Yes  No   
 Type \_\_\_\_\_  
 Root Opening \_\_\_\_\_ Root Face Dimensions \_\_\_\_\_  
 Groove Angle \_\_\_\_\_ Radius (J or U) \_\_\_\_\_  
 Back Grinding Yes  No  Method \_\_\_\_\_  
 Dimensioned Test Assembly Sketch (see attached sketch)  
**BASE METALS**  
 Material Specification \_\_\_\_\_  
 Base Material Identity \_\_\_\_\_  
 Type or Grade \_\_\_\_\_  
 Thickness Groove \_\_\_\_\_ Fillet \_\_\_\_\_  
 Diameter (Pipe) \_\_\_\_\_  
**FILLER METALS**  
 AWS Specification \_\_\_\_\_  
 AWS Classification \_\_\_\_\_  
 Heat and Lot Number \_\_\_\_\_  
 Wire Diameter \_\_\_\_\_  
**SHIELDING**  
 Primary Torch Gas  
 Composition \_\_\_\_\_ Flow Rate \_\_\_\_\_  
 Cup Size (Orifice Size Plasma) \_\_\_\_\_  
 Secondary Torch Gas (Plasma)  
 Composition \_\_\_\_\_ Flow Rate \_\_\_\_\_ Cup Size \_\_\_\_\_  
 Trailing Gas  
 Composition \_\_\_\_\_ Flow Rate \_\_\_\_\_  
 Trail Shield Size \_\_\_\_\_  
 Back Purge Gas  
 Composition \_\_\_\_\_ Flow Rate \_\_\_\_\_

WPS/PQR Identification No. \_\_\_\_\_  
 Revision \_\_\_\_\_ Date \_\_\_\_\_ By \_\_\_\_\_  
 Authorized by \_\_\_\_\_ Date \_\_\_\_\_  
 Welding Code \_\_\_\_\_ Revision \_\_\_\_\_  
 Welder's Name \_\_\_\_\_  
 Welder Identification No. \_\_\_\_\_  
**PREHEAT**  
 Preheat Temp. \_\_\_\_\_  
 Interpass Temp., Min. \_\_\_\_\_  
 Interpass Temp., Max. \_\_\_\_\_  
**POSITION**  
 Position of Groove \_\_\_\_\_  
 Position of Fillet \_\_\_\_\_  
 Other \_\_\_\_\_  
 Vertical Progression Up  Down  N/A   
**ELECTRICAL CHARACTERISTICS**  
 Transfer Mode (GMAW)  
 Short-Circuiting  Globular  Spray  Pulse   
 Current AC  DCEP  DCEN  Pulsed   
 Other \_\_\_\_\_  
 Tungsten Electrode (GTAW)  
 Size \_\_\_\_\_  
 Type \_\_\_\_\_  
**TECHNIQUE**  
 Stringer or Weave Bead \_\_\_\_\_  
 Electrode/Torch Angle \_\_\_\_\_  
 Multipass or Single Pass (per side) \_\_\_\_\_  
 Number of Electrodes \_\_\_\_\_  
 Electrode Spacing  
 Longitudinal \_\_\_\_\_  
 Lateral \_\_\_\_\_  
 Transverse \_\_\_\_\_  
 Contact Tube to Work Distance (GMAW) \_\_\_\_\_  
 Interpass Cleaning \_\_\_\_\_  
 Postweld Heat Treatment  
 Temp. \_\_\_\_\_  
 Time \_\_\_\_\_

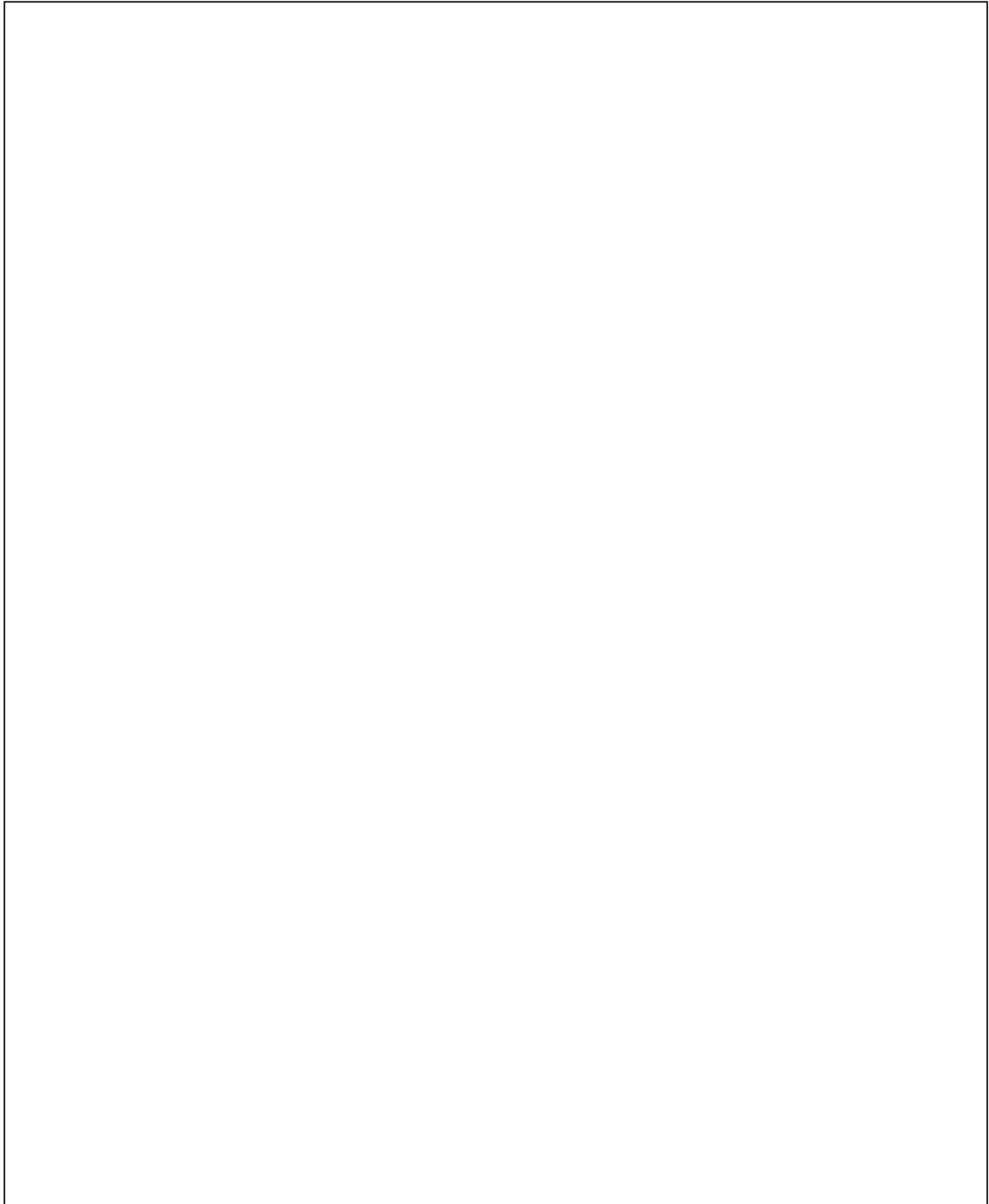
**WELDING VARIABLES**

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed
		Class	Diameter	Type and Polarity	Amps or Wire Feed Speed		

Other information \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

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DIMENSIONED TEST ASSEMBLY SKETCH



Form D-1 (Continued)