

WELDING PROCEDURE SPECIFICATION (WPS) Yes
PREQUALIFIED _____ QUALIFIED BY TESTING _____
or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

Company Name _____
 Welding Process(es) _____
 Supporting PQR No.(s) _____

Identification # _____
 Revision _____ Date _____ By _____
 Authorized by _____ Date _____
 Type—Manual Semi-Automatic
 Machine Automatic

JOINT DESIGN USED

Type:
 Single Double Weld
 Backing: Yes No
 Backing Material: _____
 Root Opening _____ Root Face Dimension _____
 Groove Angle: _____ Radius (J-U) _____
 Back Gouging: Yes No Method _____

BASE METALS

Material Spec. _____
 Type or Grade _____
 Thickness: Groove _____ Fillet _____
 Diameter (Pipe) _____

FILLER METALS

AWS Specification _____
 AWS Classification _____

SHIELDING

Flux _____ Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

PREHEAT

Preheat Temp., Min _____
 Interpass Temp., Min _____ Max _____

POSITION

Position of Groove: _____ Fillet: _____
 Vertical Progression: Up Down

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW) Short-Circuiting
 Globular Spray
 Current: AC DCEP DCEN Pulsed
 Other _____
 Tungsten Electrode (GTAW)
 Size: _____
 Type: _____

TECHNIQUE

Stringer or Weave Bead: _____
 Multi-pass or Single Pass (per side) _____
 Number of Electrodes _____
 Electrode Spacing Longitudinal _____
 Lateral _____
 Angle _____
 Contact Tube to Work Distance _____
 Peening _____
 Interpass Cleaning: _____

POSTWELD HEAT TREATMENT

Temp. _____
 Time _____

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			

Figure A.1—Sample Form E1, Front

