

**PREQUALIFIED WELDING PROCEDURE SPECIFICATION (WPS)**

Material specification \_\_\_\_\_  
 Welding process \_\_\_\_\_  
 Manual or machine \_\_\_\_\_  
 Position of welding \_\_\_\_\_  
 Filler metal specification \_\_\_\_\_  
 Filler metal classification \_\_\_\_\_  
 Flux \_\_\_\_\_  
 Weld metal grade\* \_\_\_\_\_  
 Shielding gas \_\_\_\_\_ Flow rate \_\_\_\_\_  
 Single or multiple pass \_\_\_\_\_  
 Single or multiple arc \_\_\_\_\_  
 Welding current \_\_\_\_\_  
 Polarity \_\_\_\_\_  
 Welding progression \_\_\_\_\_  
 Root treatment \_\_\_\_\_  
 Preheat and interpass temperature \_\_\_\_\_  
 Postweld Heat Treatment \_\_\_\_\_ None \_\_\_\_\_

\*Applicable only when filler metal has no AWS classification.

**WELDING PROCEDURE**

| Pass No. | Electrode Size | Electrical Characteristics |       | Travel Speed | Joint Detail |
|----------|----------------|----------------------------|-------|--------------|--------------|
|          |                | Amperes                    | Volts |              |              |
|          |                |                            |       |              |              |

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in AWS D15.1: ( \_\_\_\_\_ ), *Railroad Welding Specification for Cars and Locomotives*.  
 (year)

Procedure no. \_\_\_\_\_

Manufacturer or Contractor \_\_\_\_\_

Revision no. \_\_\_\_\_

Authorized by \_\_\_\_\_

Form D-1

Date \_\_\_\_\_