SAMPLE FORM FOR WELDING PROCEDURE SPECIFICATION (WPS)

Procedure No. _____ Applicable Code _____

Processes(es) _____ Types: ☐ Manual ☐ Semi Auto ☐ Automatic

Joint Type _____ Backing Material _____

Joint Sketch

Typical Pass & Layer Sequence

Base Metals

Material Spec. _____

Type, Grade, Class _____

M-No. _____ to M-No. _____

Thickness _____

Preheat & PWHT

Preheat Temp. (min.) _____

Interpass Temp. (max.) _____

PWHT Temp. _____

PWHT Time _____

Filler Materials

Filler Metal

F-No. _____

A-No. _____

AWS Spec./Class _____

Diameter _____

Trade Name _____

Flux – Electrode – Class _____

Flux Trade Name) _____

Gas

Shielding Gas or Mixture _____

Flow Rate _____

Backing Gas _____

Trailing Gas _____

Positions

Position(s) _____

Welding Progression (vertical) _____

Form D-13A

SAMPLE FORM FOR WELDING PROCEDURE SPECIFICATION (WPS) (Continued)

Technique

Stringer or Weave Bead _____ Gas Cup or Nozzle Size_____

Initial & Interpass Cleaning_____

Method of Backgouging _____

Oscillation _____ Tip to Work Distance _____

Single or Multiple Passes (per side) _____ Single or Multiple Electrodes _____

Distance Between Electrodes_____ Mode of Metal Transfer_____

Pass #	Polarity	Current	Voltage	Filler Metal		Travel Speed	W.F.S.	Heat Input	Other
		Amps	Volts	Class	Dia.	IPM	IPM	kJ/in	

Supplementary Comments

_____

_____

_____

_____

_____

Summary

Approved by _____ Department _____

Supporting PQR #_____ Date _____

Form D-13B