

SAMPLE WELDING PROCEDURE SPECIFICATION (WPS)
(SMAW, GMAW, GTAW, FCAW, OFW, PAW)

Company Name	WPS No.	Rev. No.	Date
Authorized by	Date	Supporting PQR(s)	FTT Report

BASE METALS					Thickness Range	
Specification	Type or Grade	M	Group		As-Welded	w/PWHT
Base Material				Groove Welds Groove w/FTT Partial Pen. Groove Welds Fillet Welds Pipe/Tube Diameter Range		
Welded To						
Backing Material						
Other						

FILLER METALS						Thickness Range	
Process	Spec.	Classification	F-no.	A-no.	Trade Name	As-Welded	w/PWHT
Process 1							
Process 2							
Process 3							
Cons. Insert						<input type="checkbox"/> Required <input type="checkbox"/> Optional <input type="checkbox"/> None	
Flux						<input type="checkbox"/> Required <input type="checkbox"/> Optional <input type="checkbox"/> None	
Sup. Filler						<input type="checkbox"/> Required <input type="checkbox"/> Optional <input type="checkbox"/> None	

JOINT DETAILS	
Groove Type	
Groove Angle	
Root Opening	
Root Face	
Backgouging	
Method	

JOINT DETAILS (Sketch)
<p>Sketches, production drawings, welding symbols, or written description should show the general arrangement of the parts to be welded. Where applicable, the root details of the weld groove may be specified.</p>

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE				
Weld Layer(s) / Pass(es)				
Process				
Type (<i>Manual., Mechanized, etc.</i>)				
Preheat Temperature				
Interpass Temperature				
Filler Metal Size				
Position				
Vertical Progression				
Shielding Gas Compos. (GTAW)				
Flow Rate (GTAW)				
Nozzle Size (GTAW)				
Electrical Characteristics	---	---	---	---
Electrode Diameter (GTAW)				
Current Type & Polarity				
Amps				
Volts				
Cold or Hot Wire Feed (GTAW)				
Travel Speed				
Maximum Heat Input				
Technique	---	---	---	---
Stringer or Weave				
Multi or Single Pass (per side)				
Oscillation (GTAW Mech./Auto.)				
Traverse Length				
Traverse Speed				
Dwell Time				
Peening				
Interpass Cleaning				
Other				

Figure G.1—Example of a Welding Procedure Specification