

<p><b>ESW-NG WELDING PROCEDURE SPECIFICATION</b></p>	<p>Document No.: _____</p> <p>Issue Date: _____ Rev. _____</p> <p>Page No.: _____</p> <p>Prepared by: _____</p> <p>Approved: _____</p>
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Date:	WPS No.:	
Specification/Code:	Material Specification:	
Specification Process:            ESW-NG	Welding/Machine:	MECHANIZED—AUTOMATIC
Material Thickness:	Weld Thickness (for Transition Joints):	
Filler Metal Specification:	Filler Metal Classification:	
Filler Metal Manufacturer:	Trade Name:	
Shielding Gas:                        N/A	Flow Rate:                        N/A	Dew Point:                        N/A

Single/Multiple Pass:            SINGLE	Preheat Temperature: NO PREHEAT REQUIREMENT
Welding Current:	Postheat Requirements:            NONE
Polarity:	Interpass Temperature:            N/A
Root Treatment:	

Preweld Flux Dump:	Flux Type:
Initial Flux Feed:	Current:
In-Weld Flux Feed:	Voltage:
Vertical Rate of Rise (in weld):	Wire Feed Rate:
Electrode Diameter:	Number of Electrodes:
Sealing Material for Slag Run-Out:	

Form N-9

**Form N-9—ESW-NG Welding Procedure Specification**

COOLING SHOES			WELD JOINT DETAIL		CONSUMABLE GUIDE	
Shoe Material:			Welding Position: VERTICAL		Guide Material:	
A:	B:	C:	Progression: UPWARD		A:	B:

Authorized by:	Approval:
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Form N-9

**Form N-9 (Continued)—ESW-NG Welding Procedure Specification**