

Blank Sample WPS Form (GTAW & SMAW) WELDING PROCEDURE SPECIFICATION (WPS)

Company Name _____ WPS No. _____ Rev. No. _____ Date _____

Authorized by _____ Date _____ Supporting PQR(s) _____ CVN Report _____

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material			
Welded To			
Backing Material			
Other			

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds		
CJP Groove w/CVN		
PJP Groove Welds		
Fillet Welds		
DIAMETER		

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

JOINT DETAILS (Sketch)

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE								
Weld Layer(s)								
Weld Pass(es)								
Process								
Type (<i>Manual, Mechanized, etc.</i>)								
Position								
Vertical Progression								
Filler Metal (AWS Spec.)								
AWS Classification								
Diameter								
Manufacturer/Trade Name								
Shielding Gas Compos. (GTAW)								
Flow Rate (GTAW)								
Nozzle Size (GTAW)								
Preheat Temperature								
Interpass Temperature								
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								