

### Blank Sample WPS Form (SAW) 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		
<b>DIAMETER</b>		

JOINT DETAILS	
Groove Type	
Groove Angle	
Root Opening	
Root Face	
<b>Backgouging</b>	
Method	

JOINT DETAILS (Sketch)

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE									
Weld Layer(s)									
Weld Pass(es)									
<b>Process</b>	<b>SAW</b>								
Type ( <i>Semiautomatic, Mechanized, etc.</i> )									
<b>Position</b>									
<b>Filler Metal (AWS Spec.)</b>									
AWS Classification									
Electrode Diameter									
Electrode/Flux Classification									
Manufacturer/Trade Name									
Supplemental Filler Metal									
<b>Preheat Temperature</b>									
Interpass Temperature									
<b>Electrical Characteristics</b>	—	—	—	—	—	—	—	—	—
Current Type & Polarity									
Amps									
Volts									
Wire Feed Speed									
Travel Speed									
Maximum Heat Input									
<b>Technique</b>	—	—	—	—	—	—	—	—	—
Stringer or Weave									
Multi or Single Pass (per side)									
Number of Electrodes									
Longitudinal Spacing of Arcs									
Lateral Spacing of Arcs									
Angle of Parallel Electrodes									
Angle of Electrode (Mech./Auto.)									
Normal To Direction of Travel									
Oscillation ( <i>Mechanized/Automatic</i> )									
Traverse Length									
Traverse Speed									
Dwell Time									
Peening									
Interpass Cleaning									
<b>Other</b>									