

### WPS QUALIFICATION TEST RECORD FOR ELECTROSLAG AND ELECTROGAS WELDING

**PROCEDURE SPECIFICATION**

Material specification \_\_\_\_\_  
 Welding process \_\_\_\_\_  
 Position of welding \_\_\_\_\_  
 Filler metal specification \_\_\_\_\_  
 Filler metal classification \_\_\_\_\_  
 Filler metal \_\_\_\_\_  
 Flux \_\_\_\_\_  
 Shielding gas \_\_\_\_\_ Flow rate \_\_\_\_\_  
 Gas dew point \_\_\_\_\_  
 Thickness range this test qualifies \_\_\_\_\_  
 Single or multiple pass \_\_\_\_\_  
 Single or multiple arc \_\_\_\_\_  
 Welding current \_\_\_\_\_  
 Preheat temperature \_\_\_\_\_  
 Postheat temperature \_\_\_\_\_  
 Welder's name \_\_\_\_\_  
 Guide tube flex \_\_\_\_\_  
 Guide tube composition \_\_\_\_\_  
 Guide tube diameter \_\_\_\_\_  
 Vertical rise speed \_\_\_\_\_  
 Traverse length \_\_\_\_\_  
 Traverse speed \_\_\_\_\_  
 Dwell \_\_\_\_\_  
 Type of molding shoe \_\_\_\_\_

**VISUAL INSPECTION (Table 8.1, Cyclically loaded limitations)**

Appearance \_\_\_\_\_  
 Undercut \_\_\_\_\_  
 Piping porosity \_\_\_\_\_  
 Test date \_\_\_\_\_  
 Witnessed by \_\_\_\_\_

**TEST RESULTS**

**Reduced-section tensile test**

Tensile strength, psi  
 1. \_\_\_\_\_  
 2. \_\_\_\_\_

**All-weld-metal tension test**

Tensile strength, psi \_\_\_\_\_  
 Yield point/strength, psi \_\_\_\_\_  
 Elongation in 2 in, % \_\_\_\_\_

**Side-bend tests**

1. \_\_\_\_\_ 3. \_\_\_\_\_  
 2. \_\_\_\_\_ 4. \_\_\_\_\_

**Radiographic-ultrasonic examination**

RT report no. \_\_\_\_\_  
 UT report no. \_\_\_\_\_

**Impact tests**

Size of specimen \_\_\_\_\_ Test temp \_\_\_\_\_  
 ft-lbf: 1. \_\_\_\_\_ 2. \_\_\_\_\_ 3. \_\_\_\_\_ 4. \_\_\_\_\_  
 5. \_\_\_\_\_ 6. \_\_\_\_\_ Avg. \_\_\_\_\_  
 High \_\_\_\_\_ Low \_\_\_\_\_  
 Laboratory test no. \_\_\_\_\_

**WELDING PROCEDURE**

Pass No.	Electrode Size	Welding Current		Joint Detail
		Amperes	Volts	

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 6 of AWS D1.1/D1.1M, (\_\_\_\_\_) *Structural Welding Code—Steel*.  
 (year)

Procedure no. \_\_\_\_\_

Manufacturer or Contractor \_\_\_\_\_

Revision no. \_\_\_\_\_

Authorized by \_\_\_\_\_

Form J-3

Date \_\_\_\_\_

(See <http://go.aws.org/D1forms>)