

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								

Blank Sample WPS Form (GMAW & FCAW) 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>Semiautomatic, Mechanized, etc.</i>)									
Position									
Vertical Progression									
Filler Metal (AWS Spec.)									
AWS Classification									
Diameter									
Manufacturer/Trade Name									
Shielding Gas (Composition)									
Flow Rate									
Nozzle Size									
Preheat Temperature									
Interpass Temperature									
Electrical Characteristics	—	—	—	—	—	—	—	—	—
Current Type & Polarity									
Transfer Mode									
Power Source Type (<i>cc, cv, etc.</i>)									
Amps									
Volts									
Wire Feed Speed									
Travel Speed									
Maximum Heat Input									
Technique	—	—	—	—	—	—	—	—	—
Stringer or Weave									
Multi or Single Pass (per side)									
Oscillation (<i>Mechanized/Automatic</i>)									
Traverse Length									
Traverse Speed									
Dwell Time									
Number of Electrodes									
Contact Tube to Work Distance									
Peening									
Interpass Cleaning									
Other									

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		
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	SAW								
Type (Semiautomatic, Mechanized, etc.)									
Position									
Filler Metal (AWS Spec.)									
AWS Classification									
Electrode Diameter									
Electrode/Flux Classification									
Manufacturer/Trade Name									
Supplemental Filler Metal									
Preheat Temperature									
Interpass Temperature									
Electrical Characteristics	—	—	—	—	—	—	—	—	—
Current Type & Polarity									
Amps									
Volts									
Wire Feed Speed									
Travel Speed									
Maximum Heat Input									
Technique	—	—	—	—	—	—	—	—	—
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 (Mechanized/Automatic)									
Traverse Length									
Traverse Speed									
Dwell Time									
Peening									
Interpass Cleaning									
Other									