

## Sample Welding Procedure Specification (WPS) Form

**Welding Procedure Specification (WPS) No.** \_\_\_\_\_

Contractor \_\_\_\_\_

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

Revision No. \_\_\_\_\_

Supporting PQR Identification \_\_\_\_\_

Test Date \_\_\_\_\_

**WELDING PROCESS:**    FCAW-S    FCAW-G    GMAW    SMAW

**WELD TYPE:**    Groove    Fillet

**JOINT TYPE:**    Direct Butt    Indirect Butt    T-Joint

Joint(s) Qualified (see Table 6.3) \_\_\_\_\_

Position \_\_\_\_\_   Groove Type \_\_\_\_\_

Root Opening \_\_\_\_\_   Root Face \_\_\_\_\_   Groove Angle \_\_\_\_\_

Backing:    Yes    No   Backing Type \_\_\_\_\_

Backgouging:    Yes    No   Backgouging Method \_\_\_\_\_

**TECHNIQUE:**    Stringers    Weave

**ELECTRICAL CHARACTERISTICS**

Current:    AC    DCEP    DCEN

Transfer Mode (GMAW):    Short-circuiting    Globular    Spray

**BASE METAL**

Material Specification \_\_\_\_\_   Grade \_\_\_\_\_

Welded to:   Material Specification \_\_\_\_\_   Grade \_\_\_\_\_

Maximum Carbon Equivalent \_\_\_\_\_   Bar size \_\_\_\_\_   Plate Thickness \_\_\_\_\_

Coated Bar:    Yes    No   Type of Coating \_\_\_\_\_

**FILLER METAL**

AWS Specification \_\_\_\_\_   AWS Classification \_\_\_\_\_

Describe filler metal (if not covered by AWS specifications) \_\_\_\_\_

**SHIELDING**

Gas:    Single    Mixture   Composition \_\_\_\_\_   Flow rate \_\_\_\_\_

**PREHEAT/INTERPASS**

Preheat/Interpass Temperature (Min) \_\_\_\_\_   Interpass Temperature (Max) \_\_\_\_\_

**WELDING PARAMETERS**

Pass Number(s)	Electrode Diameter	Current				Travel Speed ipm [mm/min.]	Joint Detail
		Type	Amperage Range	Volts Range	Electrical Stickout		

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

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

Date \_\_\_\_\_