WELDING PROCEDURE SPECIFICATION (WPS)

Company Name

Welding process(es)

Supporting PQR No.(s)

Identification #

Revision _____ Date _____ By _____

Authorized By _____ Date _____

Type Manual ☐ Semi-Automatic ☐

Mechanized ☐ Automatic ☐

JOINT DESIGN

Type:

Single ☐ Double Weld ☐

Backing: Yes ☐ No ☐

Backing Material: N/A

Root Opening _____ Root Face Dimension _____

Groove Angle _____ Radius (J-U) _____

Back Gouging Yes ☐ No ☐ Method _____

Position _____

_____

ELECTRICAL CHARACTERISTICS

General Characteristics _____

_____

Current AC ☐ DCEP ☐①DCEN ☐①Pulsed ☐

Other _____

BASE METALS

Material Spec. _____

Type or Grade _____

Thickness: Groove _____ Fillet _____

Diameter _____

_____

Tungsten Electrode (GTAW/PAW)

Size: _____

Type: _____

_____

FILLER METALS

Specification _____

_____

_____

TECHNIQUE

Stringer or Weave Bead _____

Multi-pass or Single Pass (per side) _____

Number of Electrodes _____

Peening _____

Inter-pass Cleaning _____

Other _____

_____

_____

SHIELDING

Flux _____ Gas _____

Composition _____

Electro-Flux (Class) Flow Rate _____

_____ Gas Cup Size _____

PREHEAT

Preheat Temp., Min _____

Inter-pass Temp., Min _____ Max _____

POSTWELD HEAT

Temp

Time _____

WELDING PROCEDURE

Pass or		Filler Metals		Current				
Weld Layers	Process	Class	Diam	Type & Polarity	Amps or Wire Feed Speed*	Volts*	Travel Speed*	Joint Details
					*	*	*	

* N/A for manual process. These settings are not visible to the welder with the Hood Down

Figure 5.13—Welding Procedure Specification (WPS) Form