

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 _____