

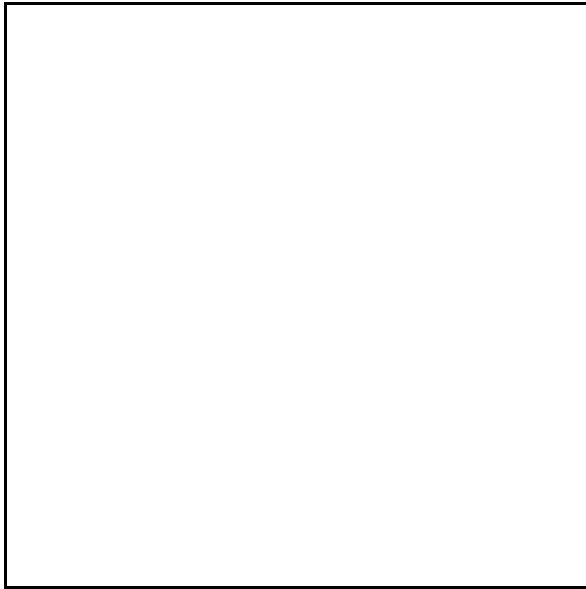
WELDING PROCEDURE SPECIFICATION (WPS)

Welding Procedure

Specification No. _____ Date _____ Approved _____

Revisions _____ Date _____ Approved _____

Supporting PQR Numbers _____

Joints**Groove Design Sketch****Backing**

Type _____

Permanent _____

Removed _____

Other _____

Base Metals

M No. _____ Thickness _____ to _____

Alloy and Temper _____

Filler Metal

F-No. _____ AWS No. _____ Class _____

Size of electrode _____

Type of electrode _____

Other _____

Shielding Gas

Shielding gas(es) _____

Percent composition _____

Flow rate _____

Other _____

Position

Position of groove _____

Welding progression _____

Other _____

Preheat

Preheat temperature _____

Interpass temperature _____

WELDING PROCEDURE SPECIFICATION (WPS)**Cleaning**

Initial cleaning oxide _____

Initial cleaning oil and dirt _____

Interpass cleaning _____

Postweld Heat Treatment

Original temper _____

Final temper _____

Temperature _____

Time _____

Quench _____

Process(es)

Process _____ Type* _____

Process _____ Type* _____

Electrode (GTAW) _____

Technique

Stringer or weave bead _____

Orifice or gas cup size _____

Oscillation _____

Contact tube to work distance _____

Single pass or multipass _____

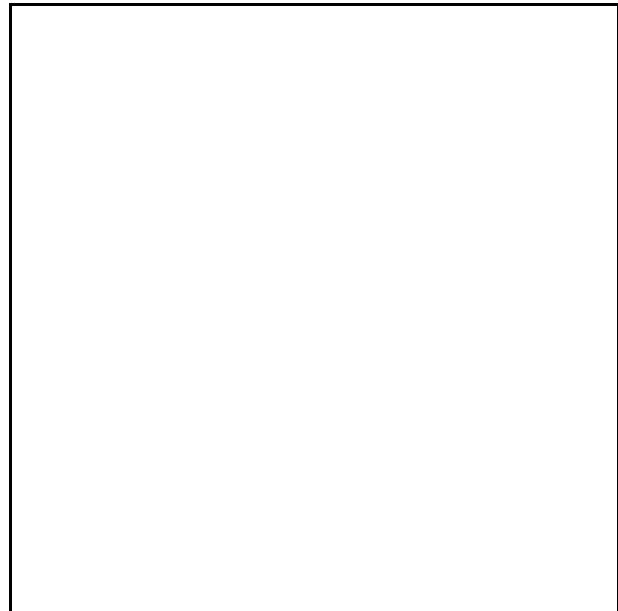
Tungsten extension _____ per side

Method of backgouging _____

Other _____

*Manual, automatic, polarity, pulse, etc.

Pass No.	Welding Process	Amps	Volts	Travel Speed



Form F(a) (Continued)

Sketch of Welding Sequence