Sample Form (GMAW & FCAW)

WELDING PROCEDURE SPECIFICATION (WPS)

Company Name _____ WPS No. _____ Rev. No. ____ Date ____

Authorized by _____ Date ____ Supporting PQR(s) _____

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	
Back Gouging	
Method	

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

JOINT DETAILS (Sketch)

PROCEDURE								
Weld Layer(s)								
Weld Pass(es)								
Process								
Type (Semi-Automatic, Mech., etc.)								
Position								
Vertical Progression								
Filler Metal AWS Spec.								
AWS Classification								
Diameter								
Manufacture/Trade Name								
Shielding Gas (Composition)								
Flow Rate								
Nozzle Size								
Preheat Temperature								
Interpass Temperature								
Electrical Characteristics	---	---	---	---	---	---	---	---
Current Type & Polarity								
Transfer Mode								
Power Source Type								
Amps								
Volts								
Wire Feed Speed								
Travel Speed								
Heat Input								
Technique	---	---	---	---	---	---	---	---
Stringer or Weave								
Multi or Single Pass (per side)								
Oscillation (Mechanized/Automatic)								
Traverse length								
Traverse speed								
Dwell time								
Number of Electrodes								
Peening								
Interpass Cleaning								
Other								