

**Blank Sample WPS Form (GTAW & SMAW)**  
**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         |           |           |
| <b>DIAMETER</b>      |           |           |

| JOINT DETAILS       |  |
|---------------------|--|
| Groove Type         |  |
| Groove Angle        |  |
| Root Opening        |  |
| Root Face           |  |
| <b>Back Gouging</b> |  |
| Method              |  |

| JOINT DETAILS (Sketch) |
|------------------------|
|                        |

| POSTWELD HEAT TREATMENT |  |
|-------------------------|--|
| Temperature             |  |
| Time at Temperature     |  |
| Other                   |  |

| PROCEDURE                           |     |     |     |     |     |     |     |     |     |
|-------------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| Weld Layer(s)                       |     |     |     |     |     |     |     |     |     |
| Weld Pass(es)                       |     |     |     |     |     |     |     |     |     |
| <b>Process</b>                      |     |     |     |     |     |     |     |     |     |
| Type (Manual., Semi-Auto., etc.)    |     |     |     |     |     |     |     |     |     |
| <b>Position</b>                     |     |     |     |     |     |     |     |     |     |
| Vertical Progression                |     |     |     |     |     |     |     |     |     |
| <b>Filler Metal AWS Spec.</b>       |     |     |     |     |     |     |     |     |     |
| AWS Specification                   |     |     |     |     |     |     |     |     |     |
| AWS Classification                  |     |     |     |     |     |     |     |     |     |
| Diameter                            |     |     |     |     |     |     |     |     |     |
| Manufacture/Trade Name              |     |     |     |     |     |     |     |     |     |
| <b>Shielding Gas</b> Compos. (GTAW) |     |     |     |     |     |     |     |     |     |
| Flow Rate (GTAW)                    |     |     |     |     |     |     |     |     |     |
| Nozzle Size (GTAW)                  |     |     |     |     |     |     |     |     |     |
| <b>Preheat Temperature</b>          |     |     |     |     |     |     |     |     |     |
| Interpass Temperature               |     |     |     |     |     |     |     |     |     |
| <b>Electrical Characteristics</b>   | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Electrode Diameter (GTAW)           |     |     |     |     |     |     |     |     |     |
| Current Type & Polarity             |     |     |     |     |     |     |     |     |     |
| Power Source Type                   |     |     |     |     |     |     |     |     |     |
| Amps                                |     |     |     |     |     |     |     |     |     |
| Volts                               |     |     |     |     |     |     |     |     |     |
| Cold or Hot Wire Feed (GTAW)        |     |     |     |     |     |     |     |     |     |
| Travel Speed                        |     |     |     |     |     |     |     |     |     |
| Heat Input                          |     |     |     |     |     |     |     |     |     |
| <b>Technique</b>                    | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Stringer or Weave                   |     |     |     |     |     |     |     |     |     |
| Multi or Single Pass (per side)     |     |     |     |     |     |     |     |     |     |
| Oscillation (GTAW Mech./Auto.)      |     |     |     |     |     |     |     |     |     |
| Traverse Length                     |     |     |     |     |     |     |     |     |     |
| Traverse Speed                      |     |     |     |     |     |     |     |     |     |
| Dwell Time                          |     |     |     |     |     |     |     |     |     |
| Peening                             |     |     |     |     |     |     |     |     |     |
| Interpass Cleaning                  |     |     |     |     |     |     |     |     |     |
| Other                               |     |     |     |     |     |     |     |     |     |