

Example WPS Form (SAW)
WELDING PROCEDURE SPECIFICATION (WPS)

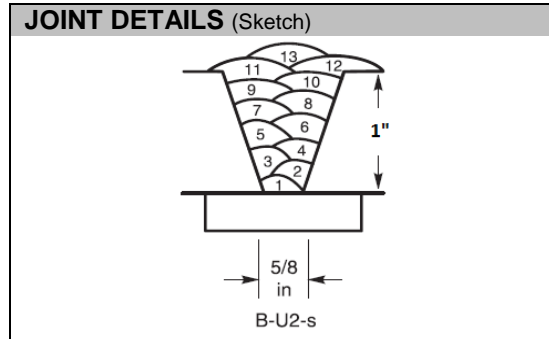
LECO
 Company Name
C. W. Hayes
 Authorized by
01/03/1989
 Date

W2081 Prequalified
 WPS No.
None
 Supporting PQR(s)
2 01/03/1989
 Rev. No. Date

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material	ASTM A36	-	II
Welded To	ASTM A36	-	II
Backing Material	ASTM A36	-	I or II
Other	-		

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds	1"	-
CJP Groove w/CVN	-	-
PJP Groove Welds	-	-
Fillet Welds	-	-
DIAMETER	-	-

JOINT DETAILS	
Groove Type	Single V Groove Butt
Groove Angle	20"
Root Opening	5/8"
Root Face	-
Back Gouging	None
Method	-



POSTWELD HEAT TREATMENT	
Temperature	N.A.
Time at Temperature	-
Other	-

PROCEDURE									
Weld Layer(s)	All								
Weld Pass(es)	1 - n								
Process	SAW								
Type (Semi-auto., Mechanized, etc.)	Mechanized								
Position	F								
Filler Metal AWS Spec.	5.17								
AWS Classification	EM12K								
Electrode Diameter	5/32"								
Electrode/Flux Classification	F7A2-EM12K								
Manufacture/Trade Name	(Flux 860)								
Supplemental Filler Metal	-								
Preheat Temperature	150°F min.								
Interpass Temperature	350°F max.								
Electrical Characteristics	---	---	---	---	---	---	---	---	---
Current Type & Polarity	DCEP								
Amps	550 ± 10%								
Volts	28 ± 7%								
Wire Feed Speed	45 ipm ± 10%								
Travel Speed	16 ipm ± 15%								
Heat Input	-								
Technique	---	---	---	---	---	---	---	---	---
Stringer or Weave	Stringer								
Multi or Single Pass (per side)	Multipass								
Number of Electrodes	1								
Longitudinal Spacing of Arcs	-								
Lateral Spacing of Arcs	-								
Angle of Parallel Electrodes	-								
Angle of Electrode (Mech./Auto.)	± 10% max.								
Normal To Direction of Travel	± 15% max.								
Oscillation (Mechanized/Automatic)	None								
Traverse Length	-								
Travers Speed	-								
Dwell Time	-								
Peening	None								
Interpass Cleaning	Slag Removed								
Other	-								