

WELDING PROCEDURE SPECIFICATION (WPS) Yes
PREQUALIFIED----- QUALIFIED BY TESTING-----
or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

Company Name _____
 Welding Process(es) _____
 Supporting PQR No. (s) _____

Identification # _____
 Revision _____ Data _____ By _____
 Authorized by _____ Data _____
 Type _____ Manual _____ Semi-Automatic _____
 Machine _____ Automatic _____

JOINT DESIGNED USED
 Type: _____
 Single _____ Double weld _____
 Backing: Yes _____ No _____
 Backing Material: _____
 Root opening _____ Root Face Dimension _____
 Groove Angle : _____ Radius (J-U) _____
 Back Gouging : Yes _____ No _____ Method _____

POSITION
 Position of Groove: _____ Fillet: _____
 Vertical Progression: Up _____ Down _____

BASE METALS
 Material Spec. _____
 Type or Grade _____
 Thickness: Groove _____ Fillet _____
 Diameter (Pipe) _____

ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW) _____ Short-Circuiting _____
 Globular _____ Spray _____
 Current : AC _____ DCEP _____ DCEN _____ Pulsed _____
 Other _____
 Tungsten Electrode (GTAW)
 Size: _____
 Type: _____

FILLER METALS
 AWS Specification _____
 AWS Classification _____

TECHNIQUE
 Stringer or Weave bead : _____
 Multi-pass or Single Pass (per side) _____
 Number of Electrodes _____
 Electrode Spacing _____ Longitudinal _____
 Lateral _____
 Angle _____

SHIELDING
 Flux _____ Gas _____
 Composition _____
 Electrode-Flux (Class) _____ Flow Rate _____
 Gas Cup Size _____

Contact Tube to Work Distance _____
 Peening _____
 Interpass Cleaning _____

PREHAT
 Preheat Temp., Min _____
 Interpass Temp., Min _____ Max _____

POSTWELD HEAT TREATMEN
 Temp. _____
 Time _____

WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			