Sample (www.weldingandndt.com)	Welding Procedure Specification (WPS)	Sample (www.weldingandndt.com)

WPS No:	**Revision:**	**Date:**	**Client:**
PQR No:	**Revision:**	**Date:**	**Third Party Agency:**
Code:	**Welding Process(es):**		**Company Name:**
Page:	**Type(s):**		**Project:**

JOINTS (QW-402)

Joint Design:

Backing: □ Yes □ No

Backing Material (Type):

□ Base Metal □Nonfusing Metal

□ Nonmetallic □Weld Metal

Root Openning: Root Face :

Groove Angle: Radius (J-U):

Back Gouging:

BASE METAL: (QW-403)

P No: (Table QW/QB-422) Group No: P No: Group No: (Table QW/QB-422)

Specification Type & Grade Specification Type & Grade

(Table QW/QB-422) TO (Table QW/QB-422)

Chemical Analysis & Mech. Prop: Chemical Analysis & Mech. Prop:

(ASME SEC IIA) (ASME SEC IIA)

Thickness Range :

Base Metal : (QW-451.1) Groove: Fillet :

Pipe Dia. Range :

FILLER METAL: (QW-404)

Spec.No.(SFA): (ASME SEC IIC) AWS NO.(Class): (ASME SEC IIC)

F-No: (Table QW-432) A-No: (Table QW-442)

Size of Filler Metals: Weld Metals: Deposited Thickness

Electrode-Flux(Class): Groove: (Table QW-451.1)

Brand Name: Fillet:

Consumable Insert:

Other:

POSITIONS: (QW-405)

Position of Groove:

Welding Progressions: □ Up Hill □ Down Hill

Position(S) of Fillet:

PREHEAT (QW-406)

Preheat Temp.min:
(ASME BPVC SEC VIII DIV 1-Nonmandatory Appendix R)

Inter Pass Temp.max:

Preheat Maintenace:

POST WELD HEAT TREATMENT (QW-407)

Holding Temperature Range: (ASME BPVC SEC VIII DIV 1-Nonmandatory Appendix R)

Holding Time :

Heating Rate:

Cooling Rate:

PWHT Chart:

GAS: (QW-408) (ASME SEC IIC SFA-5.32)

	Percent Composition:		
	Gas(es):	Mixture:	flow rate:
Shielding			
Trailing:			
Backing:			

ELECTRICAL CHARACTERISTICS: (QW-409)

Current AC or DC: Polarity:

Amps .(Range):

Volt .(Range):

Tungsten Electrode Size and Type: (ASME SEC IIC SFA-5.12)

Mode of Metal Transfer for GMAW: (ASME SEC IIC SFA-5.18)

Electrode Wire Feed Speed Range:

Heat input Allowance:

WELDING TECHNIQUE: (QW-410)

Stringer/Weave Bead:

Orifice or Gas Cup Size:

Initial & Interpass cleaning :

Metode of Back Gouging:

Oscillation:

Contact Tube to Word Distance:

Multiple or Singel Pass(per side):

Multiple or Singel Electrodes:

Travel Speed (Range):

Peening:

Other:

WELDING PROCEDURE:

Pass	Process	Filler Metal		Current (ASME SEC IIC)			Heat Input (kj/mm)	Travel Speed (mm/min)	Joint Details
		Class	Dia	Polarity	Volt	AMP			

RUN SEQUENCE

1.Fit Up 2.Welding*/Cleaning 3.Visual Inspection 4.NDT(RT,UT,PT,MT)**

*:Distortion Control Shall be Consider. ** As Per Quality specs and Documents (QCP)

Prepared By:	Approved By:	Inspector:	Client:
Date: Sign:	Date: Sign:	Date: Sign:	Date: Sign: