## QW-482 SUGGESTED FORMAT FOR WELDING PROCEDURE SPECIFICATION (WPS) (See QW-201.1, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name		Ву:			
Welding Procedure Specification	No. Da	te:	Supporting P	QR No.(s)	
Revision No.		· ·		_	
		_			
		Type (3)	(/	Automatic, Manual, Machine	or Semi-Automatic)
JOINTS (QW-402) Joint Design Root Spacing Backing (Yes) Backing Material (Type)	(No) (refer to both backing and retains			Details	
	Nonfusing Metal Other	FIG A (	BUTT JOINT)	FIG B (CORNER JOIN	T) FIG C (EDGE JOINT)
Sketches, Production Drawings, Weld Symbols or Written Description should show the general arrangement of the parts to be welded. Where applicable, the root spacing and the details of weld groove may be specified.  [At the option of the manufacturer, sketches may be attached to illustrate joint design, weld layers and bead sequence (e.g., for notch toughness procedures, for multiple process procedures etc.)]  FIG D (LAP JOINT)					
☐ Other (Describe)					
☐ Figure A ☐ Figure B ☐ Figure D ☐ Figure E					
*BASE METALS (QW-403) P-No. OR Specification type/grade or III	-	to P-No.		Group No.	
Specification type/grade or UNS number to Specification type/grade or UNS number					
OR					
Chem. Analysis and Mech. Prop. to Chem. Analysis and Mech. Prop.					
Thickness Range:  Base Metal: Groove Fillet Other					
Maximum Pass Thickness <=1/2 inch (13 mm) (Yes) ☐ (No) ☐					
*FILLER METALS (QW-404)					
Spec. No. (SFA)					
AWS No. (Class)					
F-No.					
A-No. Size of Filler Metals					
Filler Metal Product Form					
Supplemental Filler Metal					
Weld Metal					
Thickness Range:					
Groove					
Fillet					
Electrode-Flux (Class)					
Flux Trade Name					
Consumable Insert					
Other					

<sup>\*</sup>Each base metal-filler metal combination should be recorded individually.

## QW-482 (Back)

WPS No.

Rev

**POSITIONS (QW-405) POST WELD HEAT TREATMENT (QW-407)** Position(s) of Groove Temperature Range Up Welding Progression: Down Time Range Position(s) of Fillet Other Other GAS (QW-408) PREHEAT (QW-406) Percent Composition Preheat Temperature, Minimum Gas(es) (Mixture) Flow Rate Shielding Interpass Temperature Maximum Preheat Maintenance Trailing (Continuous or special heating where applicable should be recorded) Backing Other **ELECTRICAL CHARACTERISTICS (QW-409)** Other (e.g., Remarks, Com-Weld Travel Type and Amperage Voltage ments, Hot Wire Layer(s) or Process Classification Diameter. Speed Polarity Range Range Addition, Technique, Pass (es) Range Torch Angle, Etc.) (Amperage and voltage range should be recorded for each electrode size, position, and thickness, etc **Pulsing Current** Heat Input (max) Tungsten Electrode Size and Type (Pure Tungsten, 2% Thoriated, etc.) Mode of Metal Transfer for GMAW (Spray arc, short circuiting arc, etc.) Electrode Wire feed speed range Other **TECHNIQUE (QW-410)** String or Weave Bead Orifice or Gas Cup Size Initial and Interpass Cleaning (Brushing, Grinding, etc.) Method of Back Gouging Oscillation Contact Tube to Work Distance Multiple or Single Pass (per side) Multiple or Single Electrodes **Electrode Spacing** Peening Other