AWS PREQUALIFIED WELDING PROCEDURE

WPS: _____ **Revision No.:** _____ **Date:** _____ **Welding Process:** _____

BASE MATERIALS: **Spec:** _____ **Grade:** _____ **to** **Spec:** _____ **Grade:** _____

Qualified Thickness Range

FILLER METALS: **Spec:** _____ **&** _____ **Class:** _____ **&** _____

WELD JOINT:
Joints welded with this procedure shall conform with details as specified by joint designation in GWS 1-09, Weld Joint Design:

Acceptable Joint Designation _____ **Positions:** _____ | _____ | _____

Root Treatment: _____ **Backing:** _____

Progression: _____ **PWHT:** _____ **Preparation:** _____

SHIELDING **Gas:** _____

Composition: _____ % _____ % _____ % _____ %

Flow Rate: **CFH** _____ **to** _____

PREHEAT: **Minimum Temp º F** _____

INTERPASS: **Maximum Temp º F** _____

WELDING CHARACTERISTICS: **Current and Polarity:** _____ **and** _____

Transfer Mode: _____ **Pulsing Cycle:** _____ **to** _____

WELDING TECHNIQUE: **Stringer (S) or Weave (W) Bead:** _____ **Oscillation:** _____

Single or Multi Pass: _____ **Single or Multiple Arc:** _____

Forehand (F) or Backhand(B) for GMAW: _____ **GMAW Gun Angle º:** _____ **to** _____

WELDING PARAMETERS			
Filler Size	**Amp Range**	**Volt Range**	**Travel Speed**

NOTE: **See back for minimum fillet size and joint designation legend. This procedure may vary within the limits of variables given in 4B, C or D and 5.1.2 of AWS D1.1 1988 of the Structural Welding Code**.

AUTHORIZED BY | **DATE**