QW-482 SUGGESTED FORMAT FOR WELDING PROCEDURE SPECIFICATIONS (WPS) (See QW-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name		By:	
Welding Procedure Specification No.	Date		Supporting PQR No.(s)
Revision No Date			
Welding Process(es)		Type(s)	
			(Automatic, Manual, Machine, or Semi-Auto.)
JOINTS (QW-402)			Details
Joint Design			
Backing (Yes) (No) _			
Backing Material (Type)(Refer to both ba			
(Refer to both ba	acking and retainers.)		
Metal			
□ Nonmetallic □ Other			
Sketches, Production Drawings, Weld Symbol	ls or Written Description		
should show the general arrangement of the pa	•		
applicable, the root spacing and the details			
specified.			
(At the option of the Mfgr., sketches may be at	tached to illustrate joint		
design, weld layers and bead sequence, e.g., for			
dures, for multiple process procedures, etc.)	0		
*BASE METALS (QW-403)			
P-No Group No to	o P-No Grou	p No	
OR			
Specification type and grade			
to Specification type and grade			
OR			
Chem. Analysis and Mech. Prop			
to Chem. Analysis and Mech. Prop			
Thickness Range:			
		Fillet	
Other			
*FILLER METALS (QW-404)			
Spec. No. (SFA)			
AWS No. (Class)			
F-No			
A-No			
Size of Filler Metals			
Weld Metal			
Thickness Range:			
Groove			
Fillet			
Electrode-Flux (Class)			
Flux Trade Name			
Consumable Insert			
Other			

*Each base metal-filler metal combination should be recorded individually.

(7/00) This form (E00006) may be obtained from the Order Dept., ASME, 22 Law Drive, Box 2300, Fairfield, NJ 07007-2300



QW-482 (Back)

	WPS No.	Rev.				
POSITIONS (QW-405)	POSTWELD HEAT	POSTWELD HEAT TREATMENT (QW-407)				
Position(s) of Groove	Temperature Rang	Temperature Range				
Welding Progression: Up Down	Time Range	-				
Position(s) of Fillet						
	GAS (QW-408)					
PREHEAT (QW-406)		Percent Co	mposition			
Preheat Temp. Min		Gas(es) (Mixt	ure) Flow Rate			
Interpass Temp. Max						
Preheat Maintenance	Shielding .					
(Continuous or special heating where applicable should be recorded)	Trailing .					
	Backing					
ELECTRICAL CHARACTERISTICS (QW-409)						
Current AC or DC Polarity						
Amps (Range) Volts (Range)						
(Amps and volts range should be recorded for each electrod						
position, and thickness, etc. This information may be listed in a	tabular					
form similar to that shown below.)						
Tungsten Electrode Size and Type						
	(Pure Tungsten	, 2% Thoriated, etc.)				
Mode of Metal Transfer for GMAW		t circuiting arc, etc.)				
Electrode Wire feed speed range		,				
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						
Travel Speed (Range)						
Peening Other						
Utiler						

		Filler Metal		Current				Other (e.g., Remarks, Com-
Weld Layer(s) Pr	Process	Class	Dia.	Type Polar.	Amp. Range	Volt Range	Travel Speed Range	Ments, Hot Wire Addition, Technique, Torch Angle, etc.)