

WELDING PROCEDURE SPECIFICATION Quality Control Form		
PROJECT SPECIFICATION NO:		TEST PERFORMED DATE:
PQR NO:		IMPACT TEST: <input type="checkbox"/> YES <input type="checkbox"/> NO
WELDING PROCESS:		WPS NO:
WELDING TYPE: <input type="checkbox"/> MANUAL <input type="checkbox"/> SEMI-AUTOMATIC <input type="checkbox"/> MACHINE <input type="checkbox"/> AUTOMATIC		
JOINTS DESIGN (QW-402)		JOINT DETAILS & SEQUENCE OF BEADS
JOINTS DESIGN		
BACKING: <input type="checkbox"/> NO <input type="checkbox"/> YES		
BACKING MATERIAL OR TYPE:		
RETAINER:		
OTHERS:		
BASE MATERIALS (QW-403)		
P-No: Gr.No: TO P-No: Gr.No:		
Spec, Type and Grade:		
DIAMETER RANGE GROOVE:		
THICKNESS RANGE GROOVE:		
FILLER METALS (QW-404)		PREHEAT (QW-406)
SFA No:		PREHEAT TEMP(MIN 'C)/CHECK/CONTROL:
AWS CLASSIFICATION:		
F No/A No:		PREHEAT METHOD:
MANUFACTURE:		PREHEAT MAINTNANCE:
DEPOSIT THICKNESS QUALIFIED RANGE:		INTER PASS TEMP(Max 'C):
SIZE (mm):		INTER PASS CHECK:
RUN-OUT-LENGTH:		INTER PASS TEMP CONTROL:
ARC TIME:		PWHT (QW-407) <input type="checkbox"/> YES <input type="checkbox"/> NO
NUMBER OF BEAD:		HOLDING TEMP RANGE:
FLUX TRADE NAME:		MIN. HOLDING TIME:
ELECTRIC FLUX (Class)		HEATING RATE:
OTHERS:		COOLING RATE:
POSITION (QW-405)		SHIELDING GAS AND FLOW RATE (QW-408)
GROOVE:		SHIELDING/FLOW RATE:
WELDING PROGRESSION: <input type="checkbox"/> N/A <input type="checkbox"/> UP hill <input type="checkbox"/> Down hill		TRAILING/FLOW RATE:
FILLET:		BACKING/FLOW RATE:
		OTHERS:
PREPARED BY: WELDING ENGINEER	NAME/SIGN:	DATE:
CHECKED BY: QA/QC MANAGER	NAME/SIGN:	DATE:
APPROVED BY: COMPANY	NAME/SIGN:	DATE:

	WELDING PROCEDURE SPECIFICATION	
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ELECTRICAL CHARACTERISTICS (QW-409)
 CURRENT AND POLARITY:
 TUNGSTEN ELECTRODE SIZE AND TYPE:
 MODE OF METAL TRANSFER FOR GMAW / FCAW:
 ELECTRODE WIRE FEED SPEED RANGE (cm/min):
 MAX HEAT INPUT (Kj/cm):
 OTHERS:

TECHNIQUE (QW-410)
 BEAD: BOTH STRING WAVE
 ORIFICE /GAS CUP SIZE:
 OSCILLATION WIDTH AND FREQUENCY:
 CONTACT TUBE TO WORK DISTANCE:
 MULTIPLE OR SINGLE PASS (PER SIDE):
 PEENING:
 JOINT PREPARATION & CLEANING:
 METHOD OF BACK GOUGING:
 OTHERS:

WELD BEAD NO.	PROCESS	CONSUMABLE		ELECTRICAL CHARACTERISTICS			TRAVEL SPEED (cm/minute)	BRAND NAME
		CLASS	DIA(mm)	POLARITY	AMPERAGE	VOLTAGE		

REMARKS :

PREPARED BY: WELDIND ENGINEER	NAME/SIGN:	DATE:
CHECKED BY: QA/QC MANAGER	NAME/SIGN:	DATE:
APPROVED BY: COMPANY	NAME/SIGN:	DATE: