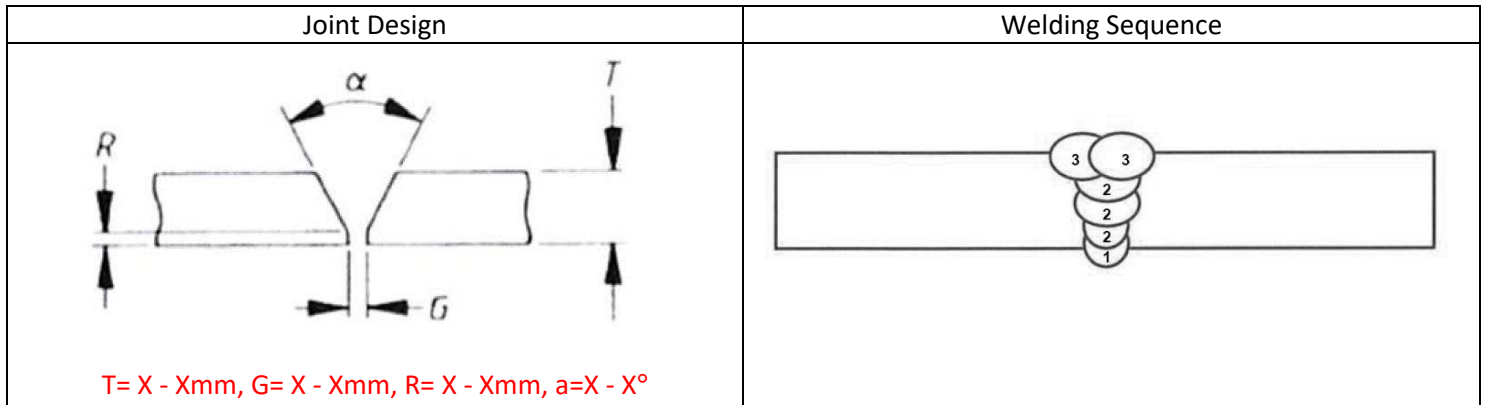


# LOGO

Company Name  
Address Line 1  
Address Line 2  
Town, County  
Postcode

## Weld Procedure Specification (WPS)

Location:	Workshop	Joint Type:	Single Vee Butt
Manufacturer's WPS No:	BUTT-WPS001	Method of Preparation:	Light Grinding
WPQR:	BUTT	Parent Material Designation:	BS EN 10025 S355JR
Manufacture:	Company Name	Material Thickness:	X to Xmm
Welders Name:	Welders Name	Outside Diameter:	N/A
Welding Process:	135 (MAG)	Welding Position:	PA (Flat)



### Welding Details:

Run	Welding Process	Welding Direction	Size of Filler Material	Current A	Voltage V	Type of Current/Polarity	Wire Feed Speed M/min	Travel Speed mm/sec	Heat Input KJ/mm	Transfer Mode
1	MAG	PA	Xmm	XXX - XXX	XX - XX	DC+ve	X	X	0.XXX - 0.XXX	DIP
2	MAG	PA	Xmm	XXX - XXX	XX - XX	DC+ve	X	X	0.XXX - 0.XXX	G & S
3	MAG	PA	Xmm	XXX - XXX	XX - XX	DC+ve	X	X	0.XXX - 0.XXX	DIP

Filler Metal Classification & Trade Name	EN 14341-A: G38 4M G3Si1 / G38 (Brand Name Wire)
Any Special Baking or Drying	Stored in accordance with manufacturers recommendations.
Gas/Flux: - Shielding/Backing	Gas retail name (ISO 14175 – M24 ArCO7/2.5
Shielding Gas Flow Rate	15L/Minute
Tungsten Electrode Type/Size	NA
Details of Back Gouging/Backing	NA
Preheat Temperature	X°C
Interpass Temperature	(°C) 'Maximum recorded in WPQR' (Note 4)
Post Weld Heat Treatment	NA
Time, Temperature, Method	NA
Heating & Cooling Rates	NA
Other Information	<p>1: Nozzle diameter = Xmm</p> <p>2: In all cases the gap between component parts shall be kept to a minimum</p> <p>3: Actual run sequence will depend on the thickness of the parent material</p> <p>4: Interpass temperature shall be checked using infrared thermometer</p> <p>5: Weld finish to be left as-welded unless specified otherwise</p> <p>6: Weaving Xmm</p> <p>7: Torch angle X°</p>

RWC Signature:

Key:

NA = Not Applicable

G = Globular

S = Spray