Weld Procedure Specification (WPS)

Location: Workshop
Joint Type: Multi Run Fillet
Manufacturer’s WPS No: MRFW-WPS001
Method of Preparation: Light Grinding
WPQR: MRFW
Parent Material Designation: BS EN 10025 S355JR
Manuacture: Company Name
Material Thickness: X to Xmm
Welders Name: Welders Name
Outside Diameter: N/A
Welding Process: 135 (MAG)
Welding Position: PA (Flat)

Joint Design

Welding Sequence

Welding Details:

<table>
<thead>
<tr>
<th>Run</th>
<th>Welding Process</th>
<th>Welding Direction</th>
<th>Size of Filler Material</th>
<th>Current A</th>
<th>Voltage V</th>
<th>Type of Current/Polarity</th>
<th>Wire Feed Speed M/min</th>
<th>Travel Speed mm/sec</th>
<th>Heat Input KJ/min</th>
<th>Transfer Mode</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>MAG</td>
<td>PA</td>
<td>Xmm</td>
<td>XXX - XXX</td>
<td>X - XX</td>
<td>DC+ve</td>
<td>X</td>
<td>X</td>
<td>0.XXX – 0.XXX</td>
<td>DIP</td>
</tr>
<tr>
<td>2</td>
<td>MAG</td>
<td>PA</td>
<td>Xmm</td>
<td>XXX - XXX</td>
<td>X - XX</td>
<td>DC+ve</td>
<td>X</td>
<td>X</td>
<td>0.XXX – 0.XXX</td>
<td>DIP</td>
</tr>
<tr>
<td>3</td>
<td>MAG</td>
<td>PA</td>
<td>Xmm</td>
<td>XXX - XXX</td>
<td>X - XX</td>
<td>DC+ve</td>
<td>X</td>
<td>X</td>
<td>0.XXX – 0.XXX</td>
<td>DIP</td>
</tr>
</tbody>
</table>

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
1: Nozzle diameter = Xmm
2: In all cases the gap between component parts shall be kept to a minimum
3: Actual run sequence will depend on the thickness of the parent material
4: Interpass temperature shall be checked using infrared thermometer
5: Weld finish to be left as-welded unless specified otherwise
6: Weaving Xmm
7: Torch angle X°

RWC Signature:

Key:
NA = Not Applicable  G = Globular  S = Spray