# Weld Procedure Specification (WPS)

<table>
<thead>
<tr>
<th>Location:</th>
<th>Workshop</th>
<th>Joint Type:</th>
<th>Pipe to Plate SRFW</th>
</tr>
</thead>
<tbody>
<tr>
<td>Manufacturer’s WPS No:</td>
<td>P/T-WPS001</td>
<td>Method of Preparation:</td>
<td>Light Grinding</td>
</tr>
<tr>
<td>WPQR:</td>
<td>P/T SRFW</td>
<td>Parent Material Designation:</td>
<td>BS EN 10025 S355JR</td>
</tr>
<tr>
<td>Manufacture:</td>
<td>Company Name</td>
<td>Material Thickness:</td>
<td>X to Xmm</td>
</tr>
<tr>
<td>Welders Name:</td>
<td>Welders Name</td>
<td>Outside Diameter:</td>
<td>N/A</td>
</tr>
<tr>
<td>Welding Process:</td>
<td>135 (MAG)</td>
<td>Welding Position:</td>
<td>PA (Flat)</td>
</tr>
</tbody>
</table>

## Joint Design

![Joint Design Diagram](image1)

## Welding Sequence

![Welding Sequence Diagram](image2)

## 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>XX-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°

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**RWC Signature:**

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**Key:**

- NA = Not Applicable
- G = Globular
- S = Spray