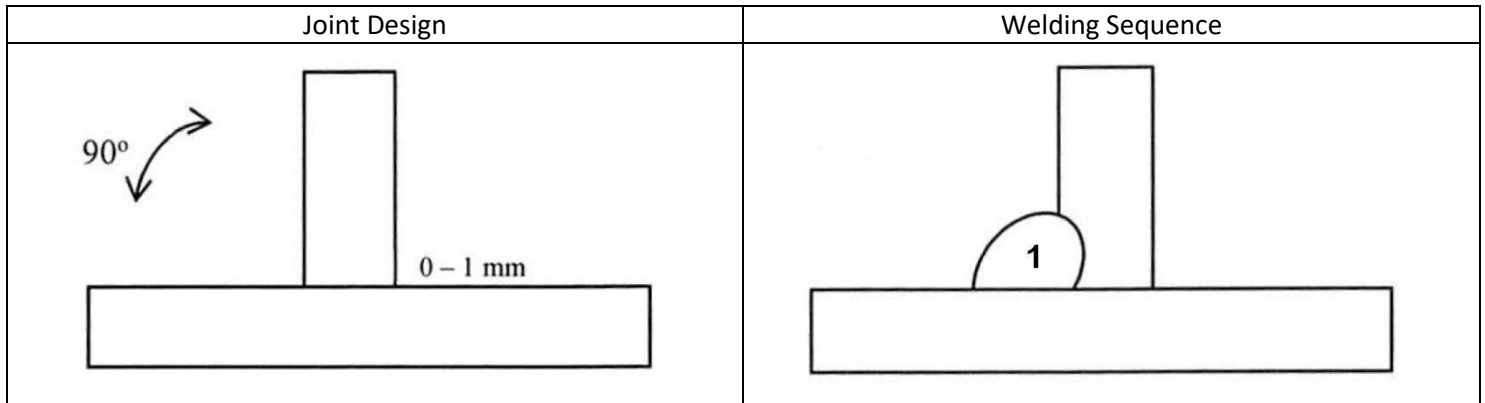


LOGO

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

Weld Procedure Specification (WPS)

Location:	Workshop	Joint Type:	Pipe to Plate SRFW
Manufacturer's WPS No:	P/T-WPS001	Method of Preparation:	Light Grinding
WPQR:	P/T SRFW	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/min	Transfer Mode
1	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	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