# Weld Procedure Specification (WPS)

<table>
<thead>
<tr>
<th>Location:</th>
<th>Workshop</th>
<th>Joint Type:</th>
<th>Single Run Fillet</th>
</tr>
</thead>
<tbody>
<tr>
<td>Manufacturer’s WPS No:</td>
<td>SRFW-WPS001</td>
<td>Method of Preparation:</td>
<td>Light Grinding</td>
</tr>
<tr>
<td>WPQR:</td>
<td>SRFW</td>
<td>Parent Material Designation:</td>
<td>BS EN 10025 S355JR</td>
</tr>
<tr>
<td>Manufacturer:</td>
<td>Company Name</td>
<td>Material Thickness:</td>
<td>X to Xm</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](image)

## Welding Sequence

![Welding Sequence Diagram](image)

## 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°

RWC Signature:

**Key:**

NA = Not Applicable  
G = Globular  
S = Spray