EPC: Logo	Owner / Buyer: Logo	WPS-Nº		Qualified Date	xx/xx/20xx	Fabricator: Logo
				Field / Shop Welding		

(ASME-IX: QW-200.1) **WELDING PROCEDURE SPECIFICATION** (WPS)

QW-Code	AWS-D1.1_Section 4: Part B (&) EN ISO 15609-1
Welds Application	Structural Welding: (§4.12) Fillet_ Secondary Load Joints

Ref.		Ref.		Process		(§4.4) Weld position		Job: Nº	
Fabricator address						Weldment -Nº		Volumetric NDT	
PQR-Nº		FOR		Compliance Spec.				MDMT: ºC	
PQR-Nº		FOR		Project Drawing/s				HSE - Welding Code	

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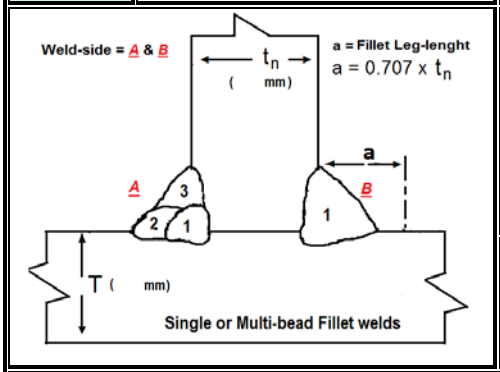
Joint Details	AWS-D1.1-Section 2:_Part-B _ §.2.8 & §2.9	(§Table 4.2) Welding Variables + Qualification Ranges + Technical Notes/ EPC Comments



NCPfirst_ X-Form_PDF example

Remarks					
WPS_QW-Test	EN 9015-1 + Client WPS Qualification Requirement Spec. ….?…..& Hardness Detail Spec. ….?….				
Surface Condition	Rust Grade A	Mill Scale Removal	Clearance Near weld area = 20 mm (Welder's option)		
Weldment Service	Non-building Structure	API 1104; Clause 5.3.2.10: Lay Hot-pass immediately after root pass			
Weldment Manipulation: *Static / Turn Table / Rollers / Lifting Gantry*	Lifting Gantry	(§4.9) Visual Quality Level	Class 1		
(QB-422) Base Metal		Grade		Type	
Safety Factor (S_F) Nº	NR	Weld Reinforcement (mm) = Leg-length x S_F =	NR	Weld Profile	Convex

Groove Angle x^0 ±5º		Radius R_1		Fillet Leg (mm): a = 0.707 x T_n =		(QW-403.2) Metal Thk. Range (mm) 2T =		T =		t_n =	
Groove Angle y^0 ±5º		Radius R_2		Fillet Throat (mm) = 0.7 x Leg =		(§5.15) Joint Preparation					
Misalignments Tolerance (mm)		(§4.10) & (§4.1) Welding Progression		Flat-forehand		(QW-410.6) Back Gouging Method					
Metal Designator	ISO-15608: Group 1	FOR	Sub-group. 1.1	Welded to	Sub-group. 1.2	(§ 4.8.3) Qualified-Metal/Plate Type	Unlisted –Carbon Steel				

§3.5: T-3.2 / §5.6) Preheat (For)		Heating Mode		Heating Temp. ºC (Mini. – Maxi)		Soak-time (min)	
(§3.14) / (§5.8 /T-5.3) SR/PWHT		Heating Rate: ºC /min		Hold: ºC		Soak-time (min)	Cooling Rate: ºC/ min.
Heat Pads Type		Thermocouple Brand & Type		Thermocouple Locations: 1T/C, 2T/C, 3T/C, 4T/C)			
(§2.11) Tacking Method		(§5.14) Tack-length (mm)		Tack-spacing (mm)		(§3.7.1) Vertical-up _Under-cut Repair	Vertical down
(§5.10 & §5.31) Root Backing - Insert/Retainer/Tabs/Ends		(§5.30) Inter-pass cleaning & Dressing					
(QW-404.23) Product Form (GTAW)		Batch-Nº		(QW-404.12) Filler Type		Brand	
(QW-404.23) Product Form (FCAW)		Batch-Nº		(QW-404.12) Filler Type		Brand	
(QW-404.23) Product Form (SMAW)		Batch-Nº		(QW-404.12) Flux Type		Brand	
(§A5.32) Shielding Gas (GTAW)		(§3.7.4) Shielding Gas (FCAW)		Purging Gas			

(QW-256) GTAW	Manual	(QW-253) SMAW	Manual	(QW-255) FCAW / MCAW	Semi - Automatic	(QW-254) SAW	Fully - Automatic

(QW-250 thru. 280) MULTI-PROCESS PROCEDURE (QW-200.4 & QW-451.1) «AND» RECORDED **WELDING PARAMETERS** (QW-409)

QW-403 Bead Nº	§ 3.2 & 4.7.1 Process	QW-404 AWS-Filler Spec. & Class	QW-404 Filler Size mm	QW-409 Amps	QW-409 Volts	QW-409 Travel Speed mm/min	QW-409 Wire Feed inch/min	Cup Size mm	QW-408 Shield Gas Lt/min	QW-410.8 CTWD mm	QW-409 Heat Input kJ/mm	Joint Side A & B	(QW- 410.1) (462.12 /13) Weld Bead Technique
1 TO 2												A	
3 TO -												A	
1 TO -												B	
- TO -													
N*	E*	E*	N*	S* E*	S*	N*	S*	E*	E*	S*	N*	N*	S*+ {QW-409.1(b2)}

(QW-409) Current & Polarity: GTAW	DCRP (+)	(QW-409) Current & Polarity: SAW / SMAW	DCSP (-)	(QW-409) Current & Polarity: FCAW/MCAW	DCSP (-)
(QW-406.8) Max. Inter-pass Thk. Range (mm)	GTAW =	& SMAW =	& FCAW =	(403.2) Max. Inter-pass ºC	
FCAW / MCAW-Metal Transfer: Full or Semi Spray		GTAW_Tungsten Type		(403.2) Min. Inter-pass ºC	
MIG / 'STT-Metal Transfer: Globular, Short-Circuit, Semi Spray		(AWS-D1.1 § 5.27) Peening by: Hammer, Metal-shots, Peening-gun			
Filler Metal _F-Nº		Base Metal _A-Nº		(AWS-D1.1_§C-8.4.1) Fatigue-dressing Method: TIG, UP Burr-grinding,	
(AWS-D1.1 §5.3.2.4) Electrode Manufacturer Recommended Re-drying Temp: ºC				Electrode Manufacturer Recommended Re-drying Soak time (min)	
Acceptance Criterion	AWS-D1.1_Table 6.1 + (4.9.1.1/2) Inspection of CJP + Fillet Welds & (EN ISO 5817-Part B)			Heat Input: ➔ kJ/mm = (Amps x Volts x 60) ÷ TS {where: TS =Travel Speed x 1000}	
Project Specific Note					

Acronym | CHM =Continued Heat & Maintaining, S_F =Safety Factor, {* =Variables}, UP =Ultrasonic Peening, CTWD =Contact-To-Work-Distance, β =ISO 5817-B -Clause , QW =ASME-IX, § =D1.1-Clause, SR =Stress Relief, B+F=Back & Forth,

Declaration	*We declare that this WPS qualification Test coupon was welded & mechanical tested in the presence of the nominated Third Party/s ..... duly signed & stamped herein*					
Rev	Prepared by: (Welding Engineer)	Approved by: (QA / Manager)	AWS Accreditation Nº XXXXXXX	Welding Engineer (Stamp)	Third Party Inspection Agency (Stamp)	Third Party Inspection Agency (Stamp)
			AWS			