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 (&) AWS-D1.8_Section 6			
		Welds Application	Seismic Welding: (§4.10) CJP-Demand Critical Joints			

Ref.		Ref.		Process	GTAW + SMAW	(§4.4) Weld position	2G + 1G (CJP-Fillet)	Job: Nº	
Fabricator address				Weldment -Nº				Volumetric NDT	LPT + UT
PQR-Nº		FOR		Compliance Spec.	AWS-D1.8_Section 2.1 + Client Spec:			MDMT: ºC	
PQR-Nº		FOR		Project Drawing/s			HSE - Welding Code		ANSI-Z 49.1_(2012)

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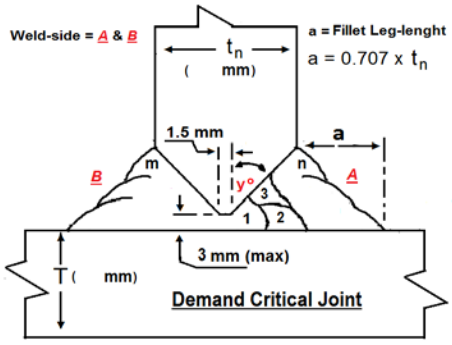
Joint Details	AWS-D1.1-Section 2:_Part-B _ §.2.8 & §2.9	(§Table 4.2) Welding Variables + Qualification Ranges + Technical Notes/ EPC Comments



NCPfirst_ X-Form_PDF example

Remarks	(§3.7.2) Width/Depth Pass Limitation compliance		
WPS_QW-Test	AWS-D1.1 - § 3.5.2.1 & AWS-D1.8_Para 6.1.3 - Annex A _Heat-input Envelop Test. See Test Result attached		
Surface Condition	Rust Grade A	Mill Scale Removal	Clearance Near weld area = 20 mm (Welder's option)
Weldment Service	Seismic 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
R / Safety Factor (S_F) Nº	1.5	Weld Reinforcement (mm) = Leg-length x S_F =	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					
Misalignment Tolerance (mm)		(§4.10) & (§4.1) Welding Progression		Flat-forehand		(QW-410.6) Back Gouging Method		Grinder			
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)	Start & Resume Welding	Heating Mode	Single	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	(β 6.11.1) Weld Tabs	(§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 & β C-A3 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 3	GTAW									5		A	Short Weave
4 TO n	SMAW									Touch-Arc		A	Stringer Beads
1 TO -	SMAW									Short Arc		B	
- TO m	SMAW											B	
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 =	(QW-403.2) + (β C-A3) Max. Inter-pass ºC	
FCAW / MCAW-Metal Transfer: Full or Semi Spray		GTAW_Tungsten Type		(QW-403.2) + (β C-A3) 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,	
(§5.3.2.4 + β1.2.2.3) Electrode Manufacturer Recommended Re-drying Temp: ºC		Electrode Manufacturer Recommended Re-drying Soak time (min)			
Acceptance Criterion	AWS-D1.8_C-A7 & AWS-D1.1_Table 6.1 + (4.9.1.1/2) Inspection of CJP & Fillet Welds	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 = D1.8-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			