

EPC: Logo		Owner / Buyer: Logo		WPS-N°		Qualified Date: xx/xx/20xx		Fabricator: Logo	
						Field / Shop Welding			
<b>WELDING PROCEDURE SPECIFICATION (WPS)</b>									
		QW							
		Welds Application							
Ref.		Ref.		Process		Weld position		Job: N°	
Fabricator address				Weldment -N°				Volumetric NDT	
POR-N°		FOR		Compliance Spec.				MDMT: °C	
POR-N°		FOR		Project Drawing/s				HSE - Welding Code	

**NCPFIRST**

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Page 1 of 1

Joint Details		Welding Variables + Qualification Ranges + Technical Notes / Comments													
		NCP_Messege: Always use a copy of the originally Template.													
		Remarks													
		WPS_QW-Test													
		Surface Condition			Mill Scale Removal										
		Weldment Service			Lay Hot-pass immediately after root pass										
		Weldment Manipulation: Static / Turn Table / Rollers / Lifting Gantry			Visual Quality Level										
		Base Metal			Grade			Type							
		Safety Factor (S <sub>r</sub> ) N°			Weld Reinforcement (mm) = Weld-cap t <sub>e</sub> x S <sub>r</sub> =			Weld Profile							
		Groove Angle x° ±5°		Radius R <sub>1</sub>		Fillet Leg (mm): a = 0.707 x T <sub>n</sub> =			QW-Base Metal Thk. Range (mm) 2T =			T =		t <sub>n</sub> =	
		Groove Angle y° ±5°		Radius R <sub>2</sub>		Fillet Throat (mm) = 0.7 x Leg =			Joint Preparation Method						
Misalignments Tolerance (mm)		Welding Progression			(Back Gouging Method										
Metal Designator		FOR		Welded to		Qualified-Pipe Diameter Range (mm)									
Preheat (For)		Heating Mode		Heating Temp. °C (Mini. – Maxi)			Soak-time (min)								
SR/PWHT		Heating Rate: °C/min		Hold: °C		Soak-time (min)		Cooling Rate: °C/min.							
Heat Pads Type		Thermocouple Brand & Type			Thermocouple Locations: 1T/C, 2T/C, 3T/C, 4T/C)										
Tacking Method		Weld-length (mm)		Weld-spacing (mm)		Tack Weld Dressing/Removal									
Backing-plate / Tabs /Ends		Inter-pass cleaning & Dressing													
Product Form (GTAW)		Batch-N°		Filler Type			Brand								
Product Form (FCAW)		Batch-N°		Filler Type			Brand								
Product Form (SAW)		Batch-N°		Flux Type			Brand								
Shielding Gas (GTAW)		Shielding Gas (FCAW / MCAW)			Purging Gas										
GTAW		SMAW		FCAW / MCAW			SAW								
<b>MULTI-PROCESS PROCEDURE «AND» RECORDED **WELDING PARAMETERS**</b>															
Bead N°	Process	AWS-Filler Spec. & Class	Filler Size mm	Amps	Volts	Travel Speed mm/min	Wire Feed inch/min	Cup Size mm	Shield Gas Lt/min	CTWD mm	Heat Input kJ/mm	Purge Gas Lt/min	Weld-Bead Technique		
1 TO 2															
3 TO n															
- TO -															
- TO -															
N*	E*	E*	N*	S* E*	S*	N*	S*	E*	E*	S*	N*	N*	S*		
Current & Polarity: GTAW		Current & Polarity: SAW / SMAW			Current & Polarity: FCAW/MCAW										
Max. Inter-pass Thk. Range (mm)		GTAW =		& SMAW =		& FCAW =		Max. Inter-pass °C							
FCAW / MCAW-Metal Transfer: Full or Semi Spray		GTAW_Tungsten Type			Min. Inter-pass °C										
MIG / STT-Metal Transfer: Globular, Short-Circuit, Semi Spray		Peening by: Hammer, Metal-shots, Peening-gun													
Filler Metal _F-N°		Base Metal _A-N°		Fatigue-dressing Method: TIG, UP Burr-grinding,											
Electrode Manufacturer Recommended Re-drying Temp: °C		Electrode Manufacturer Recommended Re-drying Soak time (min)													
Acceptance Criterion		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 <sub>r</sub> =Safety Factor, [* = Variables], UP =Ultrasonic Peening, CTWD =Contact-To-Work-Distance, thk =Thickness, β = XXXXXX, § = XXXXXX, 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)	Accreditation		Welding Engineer (Stamp)	Third Party Inspection Agency (Stamp)	Third Party Inspection Agency (Stamp)							
			N°	XXXXXXX										
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