

WELDING PROCEDURE SPECIFICATION Quality Control Form		
<b>PROJECT SPECIFICATION NO:</b>		TEST PERFORMED DATE:
PQR NO:		IMPACT TEST: <input type="checkbox"/> YES <input type="checkbox"/> NO
WELDING PROCESS:		WPS NO:
WELDING TYPE: <input type="checkbox"/> MANUAL <input type="checkbox"/> SEMI-AUTOMATIC <input type="checkbox"/> MACHINE <input type="checkbox"/> AUTOMATIC		
<b>JOINTS DESIGN (QW-402)</b>		<b>JOINT DETAILS &amp; SEQUENCE OF BEADS</b>
JOINTS DESIGN		
BACKING: <input type="checkbox"/> NO <input type="checkbox"/> YES		
BACKING MATERIAL OR TYPE:		
RETAINER:		
OTHERS:		
<b>BASE MATERIALS (QW-403)</b>		
P-No: Gr.No: TO P-No: Gr.No:		
Spec, Type and Grade:		
DIAMETER RANGE GROOVE:		
THICKNESS RANGE GROOVE:		
<b>FILLER METALS (QW-404)</b>		<b>PREHEAT (QW-406)</b>
SFA No:		PREHEAT TEMP(MIN 'C)/CHECK/CONTROL:
AWS CLASSIFICATION:		
F No/A No:		PREHEAT METHOD:
MANUFACTURE:		PREHEAT MAINTNANCE:
DEPOSIT THICKNESS QUALIFIED RANGE:		INTER PASS TEMP(Max 'C):
SIZE (mm):		INTER PASS CHECK:
RUN-OUT-LENGTH:		INTER PASS TEMP CONTROL:
ARC TIME:		<b>PWHT (QW-407)</b> <input type="checkbox"/> YES <input type="checkbox"/> NO
NUMBER OF BEAD:		HOLDING TEMP RANGE:
FLUX TRADE NAME:		MIN. HOLDING TIME:
ELECTRIC FLUX (Class)		HEATING RATE:
OTHERS:		COOLING RATE:
<b>POSITION (QW-405)</b>		<b>SHIELDING GAS AND FLOW RATE (QW-408)</b>
GROOVE:		SHIELDING/FLOW RATE:
WELDING PROGRESSION: <input type="checkbox"/> N/A <input type="checkbox"/> UP hill <input type="checkbox"/> Down hill		TRAILING/FLOW RATE:
FILLET:		BACKING/FLOW RATE:
		OTHERS:
<b>PREPARED BY: WELDIND ENGINEER</b>	NAME/SIGN:	DATE:
<b>CHECKED BY: QA/QC MANAGER</b>	NAME/SIGN:	DATE:
<b>APPROVED BY: COMPANY</b>	NAME/SIGN:	DATE:

	<b>WELDING PROCEDURE SPECIFICATION</b>	
--	--	--

<b>PROJECT SPECIFICATION NO:</b>	<b>WPS NO:</b>
----------------------------------	----------------

**ELECTRICAL CHARACTERISTICS (QW-409)**  
 CURRENT AND POLARITY:  
 TUNGSTEN ELECTRODE SIZE AND TYPE:  
 MODE OF METAL TRANSFER FOR GMAW / FCAW:  
 ELECTRODE WIRE FEED SPEED RANGE (cm/min):  
 MAX HEAT INPUT (Kj/cm):  
 OTHERS:

**TECHNIQUE (QW-410)**  
 BEAD:  BOTH     STRING     WAVE  
 ORIFICE /GAS CUP SIZE:  
 OSCILLATION WIDTH AND FREQUENCY:  
 CONTACT TUBE TO WORK DISTANCE:  
 MULTIPLE OR SINGLE PASS (PER SIDE):  
 PEENING:  
 JOINT PREPARATION & CLEANING:  
 METHOD OF BACK GOUGING:  
 OTHERS:

WELD BEAD NO.	PROCESS	CONSUMABLE		ELECTRICAL CHARACTERISTICS			TRAVEL SPEED (cm/minute)	BRAND NAME
		CLASS	DIA(mm)	POLARITY	AMPERAGE	VOLTAGE		

**REMARKS :**

<b>PREPARED BY: WELDIND ENGINEER</b>	NAME/SIGN:	DATE:
<b>CHECKED BY: QA/QC MANAGER</b>	NAME/SIGN:	DATE:
<b>APPROVED BY: COMPANY</b>	NAME/SIGN:	DATE: