AWS PREQUALIFIED WELDING PROCEDURE

WPS: ___________ Revision No.: _______ Date: ___________ Welding Process: ___________

BASE MATERIALS: Spec: ___________ Grade: _______ to Spec: ___________ Grade: _______
Qualified Thickness Range

FILLER METALS: Spec: ___________ & ___________ Class: ___________ & ___________

WELD JOINT:
Joints welded with this procedure shall conform with details as specified by joint designation in GWS 1-09, Weld Joint Design:
Acceptable Joint Designation _________________________ Positions: _______ | _______ | _______

Root Treatment: _________________________ Backing: _________________________
Progression: _________________________ PWHT: _________________________ Preparation: _________________________

SHIELDING Gas: _________________________ PREHEAT: Minimum Temp ° F ___________
Composition: ______ % ______ % ______ % ______ % ______ %
Flow Rate: CFH _________________________ INTERPASS: Maximum Temp ° F ___________

WELDING CHARACTERISTICS: Current and Polarity: _________________________ and _________________________
Transfer Mode: _________________________ Pulsing Cycle: _________________________ to _________________________

WELDING TECHNIQUE: Stringer (S) or Weave (W) Bead: _________________________ Oscillation: _________________________
Single or Multi Pass: _________________________ Single or Multiple Arc: _________________________
Forehand (F) or Backhand(B) for GMAW: _______ GMAW Gun Angle °: _______ to _______

WELDING PARAMETERS

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<tr>
<th>Filler Size</th>
<th>Amp Range</th>
<th>Volt Range</th>
<th>Travel Speed</th>
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NOTE: See back for minimum fillet size and joint designation legend. This procedure may vary within the limits of variables given in 4B, C or D and 5.1.2 of AWS D1.1 1988 of the Structural Welding Code.