**WELDING TECHNIQUE SHEET (Sample)**

<table>
<thead>
<tr>
<th>Title:</th>
<th>WTS No.:</th>
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</thead>
<tbody>
<tr>
<td>Drawing No.:</td>
<td>Work Order:</td>
</tr>
<tr>
<td>Reference WPS(s):</td>
<td>Supporting PQR(s):</td>
</tr>
</tbody>
</table>

**Process(es):**
- [ ] Manual
- [ ] Semi-Automatic
- [ ] Automatic/Machine

**Material:**

**Base Metal Thickness:** ___________ to ___________

**Deposited Weld Metal Thickness:** ___________

**Preparation:**
- Gas: ___________
- Flow Rate: ___________

**Backing / Back Gouge:**
- Current: ___________
- Polarity: ___________

**Welding Position(s):**
- Stringer or Weave Bead: ___________

**Preheat (Min.) °F:** ___________

**Inter-pass (Max.) °F:** ___________

**Pipe Diameter:** ___________

**PWHT Required:**
- [ ] Yes
- [ ] No

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**JOINT SKETCH**

**SPECIAL INSTRUCTIONS**

**Bead or Layer Sequence**

<table>
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<tr>
<th>Pass</th>
<th>Filler Metal</th>
<th>Size</th>
<th>Amps</th>
<th>Volts</th>
<th>Travel Speed</th>
<th>Heat Input (max.)</th>
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**AUTHORIZED BY**

**DATE**

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Page 1 of 1