

WELDING PROCEDURE SPECIFICATION

WPS No :

WELD No.				RAW MATERIAL	Part 1	Part 2	Part 3
Edges preparation by		Oxygen cutting Machining	Grinding	Plate / Forged/ Cast			
				Grade			
Edges inspection		Visual Magnetic particles	DPT	As per standard			
				Thickness			
Weld surface finishing		Rough (as welded) Sand blasted	Ground	HEAT TREATMENTS			
				Preheating: Temperature	Min	oC	Max
				Post heating : Temperature	oC	During	hours
				Cooling:		Natural	Normalizing
						Thermal covering	Stress relieving
						Furnace	
QUALIFICATION						Procedure	Welders
Required levels, grades or groups							
As per standard							
Qualification procedure No.							
				INSPECTION	Extent	As per standard No	Grade
				Visual			
				DPT			
				Magnetic particles			
				Ultra sonic			
				X Rays			
PENETRATION							
Full penetration required						<input type="checkbox"/>	No
						<input type="checkbox"/>	Yes
Back gouging procedure							
Back gouging inspection							
COATED ELECTRODES AND FLUX DRYING PROCEDURE							
Oven drying						Temperature	oC
						hours	During
Conservation in welder's personal oven							oC
Maximum flux thickness in the oven :							mm
OTHER DATE							

