

**SAMPLE WELDING  
PROCEDURE DATA SHEET\***

WPDS NO.: \_\_\_\_\_  
DATE: \_\_\_\_\_ Rev.: \_\_\_\_\_

Company Name: \_\_\_\_\_ Ref. Standards: \_\_\_\_\_  
Address: \_\_\_\_\_ Ref. WPS: \_\_\_\_\_

Welding Processes: **1** \_\_\_\_\_ Pulsed:  Yes  No **2** \_\_\_\_\_ Pulsed:  Yes  No  
Shielding Gas Type: \_\_\_\_\_

Positions:		Joint Configuration & Pass/Layer Sequence	
Process Mode:	<input type="checkbox"/> Manual <input type="checkbox"/> Semi-Auto <input type="checkbox"/> Machine <input type="checkbox"/> Auto		
Joint Type:	<input type="checkbox"/> Butt <input type="checkbox"/> Tee <input type="checkbox"/> Corner <input type="checkbox"/> Lap <input type="checkbox"/> Edge		
Penetration:	<input type="checkbox"/> Complete <input type="checkbox"/> Partial ETT= _____ <input type="checkbox"/> Fillet		
Backing:	Material: _____	Thickness: _____	
Backgouging:	<input type="checkbox"/> Yes	Method: _____	
	<input type="checkbox"/> No	Depth: _____	
Electrode Extension:	_____		
Nozzle Diameter(s):	_____		
Flux Classification:	_____		
Tungsten Electrode:	Type: _____	Dia.: _____	
Cleaning Procedures	_____		
CSA W186 Rebar Splice Type:	<input type="checkbox"/> Direct Splice <input type="checkbox"/> Indirect Splice <input type="checkbox"/> Lap Splice <input type="checkbox"/> Rebar to Structural Member Only		

**Identification of Base Material** (for CSA W186 indicate carbon equivalent, max. phosphorus & sulphur content)

Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	_____	_____	_____
II	_____	_____	_____

**Identification of Filler Material**

Process	Trade Name	Classification	Group	Filler Treatment

**Welding Parameters**

Thick-ness ( )	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. ( )	Wire Feed Speed ( )	Current A	Volt V	Current Polarity	Welding Speed ( )	Burn-Off Rate ( )	Gas Flow Rate ( )	Heat Input ( )

<b>Heat treatment :</b>	<b>CWB Acceptance</b>	<b>Company Authorization</b>
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Preheat min: _____	Interpasstemp.max.: _____	
	Interpasstemp.min.: _____	

Remarks: \_\_\_\_\_

Date: \_\_\_\_\_

\*Sample form and may be modified if required