



WELDING PROCEDURE DATA SHEET

WPDS NO.: _____
DATE: _____ Rev.: _____

Company Name: _____ Ref. Standards: _____
Address: _____ Ref. WPS: _____

Welding Processes:	1	Pulsed: <input type="checkbox"/> Yes <input type="checkbox"/> No	2	Pulsed: <input type="checkbox"/> Yes <input type="checkbox"/> 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 ()

Heat treatment :	CWB Acceptance	Company Authorization
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Preheat min: _____	Interpasstemp.max.: _____	
	Interpasstemp.min.: _____	

Remarks: _____

Date: _____