

**Sample WPS Form (GMAW & FCAW)  
WELDING PROCEDURE SPECIFICATION (WPS)**

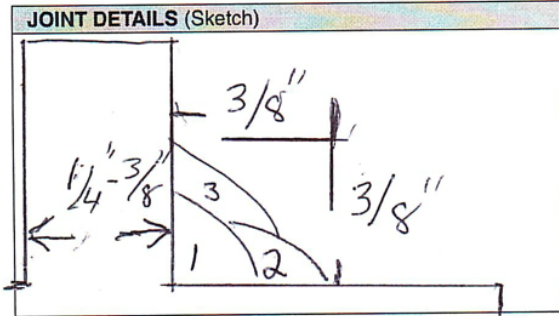
Moraine Park Technical College  
 Company Name \_\_\_\_\_  
 Kelly Komoroski  
 Authorized by \_\_\_\_\_ Date 9/27/2024

AWS WELD EVENT \_\_\_\_\_  
 WPS No. \_\_\_\_\_  
 Sample WPS/ \_\_\_\_\_  
 Supporting PQR(s) \_\_\_\_\_  
 Rev. No. \_\_\_\_\_ Date 11/13/24  
 N/A  
 CVN Report \_\_\_\_\_

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material	A36		1
Welded To	A36		1
Backing Material	N/A	N/A	N/A
Other	N/A		

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds	N/A	N/A
CJP Groove w/CVN	N/A	N/A
PJP Groove Welds	N/A	N/A
Fillet Welds	X	N/A
DIAMETER	N/A	N/A

JOINT DETAILS	
Groove Type	N/A
Groove Angle	N/A
Root Opening	N/A
Root Face	N/A
Backgouging	N/A
Method	N/A



POSTWELD HEAT TREATMENT	
Temperature	N/A
Time at Temperature	N/A
Other	N/A

PROCEDURE									
Weld Layer(s)	3								
Weld Pass(es)	3								
<b>Process</b>	GMAW								
Type (Semiautomatic, Mechanized, etc.)	Semiauto								
<b>Position</b>	Horizontal								
Vertical Progression	N/A								
<b>Filler Metal (AWS Spec.)</b>	A5.1								
AWS Classification	ER70S-6								
Diameter	.035								
Manufacturer/Trade Name	L-56								
<b>Shielding Gas (Composition)</b>	75/25 or 90/10								
Flow Rate	20-35cfh								
Nozzle Size	1/2" 3/4"								
<b>Preheat Temperature</b>	50 deg min								
Interpass Temperature	500 deg								
<b>Electrical Characteristics</b>	---	---	---	---	---	---	---	---	---
Current Type & Polarity	DCEP								
Transfer Mode	globular/spray								
Power Source Type (cc, cv, etc.)	CV								
Amps	180-260								
Volts	25-27.5								
Wire Feed Speed	520-600								
Travel Speed	12-20 ipm								
Maximum Heat Input	-N/A-								
<b>Technique</b>	---	---	---	---	---	---	---	---	---
Stringer or Weave	Stringer								
Multi or Single Pass (per side)	multi-pass								
Oscillation (Mechanized/Automatic)	N/A								
Traverse Length	N/A								
Traverse Speed	N/A								
Dwell Time	N/A								
Number of Electrodes	1								
Contact Tube to Work Distance	3/8"-1/2"								
Peening	none								
Interpass Cleaning	wire brush								
<b>Other</b>	N/A								