CODEWARE®
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FORM QW-482 SUGGESTED FORMAT FOR WELDING PROCEDURE SPECIFICATIONS (WPS)
(See QW-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

Organization Name Codeware, Inc. By

Welding Procedure Specification No. GTAW_1203_1 Date September 3, 2018 Supporting PQR No.(s) GTAW-304Stainless

Revision No. 0 Date

Welding Process(es) [1]GTAW Type(s) [1]Manual
(Automatic, Manual, Machine, or Semi-Automatic)

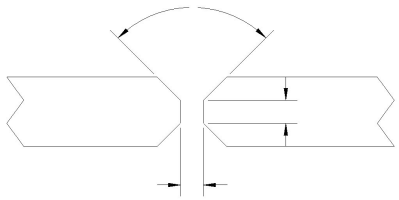
JOINTS (QW-402)

Joint Design	Double V-Groove
Root Spacing (in)	.0625
Groove Angle (°)	60
Backing	Not Permitted
Backing Material (Type)	None
Retainers	None

Sketches, Production Drawings, Weld Symbols, or Written Description should show the general arrangement of the parts to be welded. Where applicable, the details of weld groove may be specified.

Sketches may be attached to illustrate joint design, weld layers, and bead sequence (e.g., for toughness procedures, for multiple process procedures, etc.)

Details



Double V

*BASE METALS (QW-403)

P-No. 8 Group No. to P-No. 8 Group No.

OR

Specification and type, grade, or UNS Number

to Specification and type, grade, or UNS Number

OR

Chem. Analysis and Mech. Prop. None

to Chem. Analysis and Mech. Prop. None

Thickness Range: (in)

Base Metal: Groove [As-Welded] .0625 - 2 Fillet No Min - No Max

Maximum Pass Thickness ≤ ½ in. (13 mm) (Yes) ✔ (No)

Other

*FILLER METALS (QW-404)

Spec. No. (SFA)	[1]5.1
AWS No. (Class)	[1]E6012
F-No.	[1]2
A-No.	[1]1
Size of Filler Metals (in)	[1].125
Filler Metal Product Form	[1]Bare
Supplemental Filler Metal	None
Weld Metal	
Deposited Thickness: (in)	
Groove	[1]No Min - 0.25
Fillet	[1]No Min - 0.25
Electrode-Flux (Class)	None
Flux Type	None
Flux Trade Name	None
Consumable Insert Size	None
Consumable Insert Shape	None

* Each base metal filler metal combination should be recorded individually.
NOTE: Bracketed [ ] numbers indicate process

POSITIONS (QW-405)

Position(s) of Groove: [1]1G - Flat, 1G - Flat
Welding Progression: [1]N/A
Position(s) of Fillet: None

PREHEAT (QW-406)

Preheat Temperature, Minimum (°F): [1]50
Interpass Temperature, Maximum (°F): [1]80
Preheat Maintenance: None
(Continuous or special heating, where applicable, should be specified)

POSTWELD HEAT TREATMENT (QW-407)

Temperature Range (°F): None
Time Range (hours/in): None
Other: No PWHT Permitted

GAS (QW-408)

	Composition	Flow Rate (ft³/hr)
Shielding	[1]Ar=100%,	[1]8
Trailing	[1]Not Used	None
Backing	[1]Not Used	None

ELECTRICAL CHARACTERISTICS (QW-409)

Weld Pass(es)	Process	Filler Metal		Current Type and Polarity	Amps (Range)	Wire Feed Speed (Range)	Energy or Power (Range)	Volts (Range)	Travel Speed (Range)	Other (e.g., Remarks, Comments, Hot Wire Addition, Technique, Torch Angle, etc.)
		Classification	Diameter							
	GTAW	E6012	.125	DCEN	24	None	None	12	8	
	GTAW	E6012	.125	DCEN	24	None	None	12	8	

Amps and volts, or power or energy range, should be specified for each electrode size, poisition, and thickness, etc.

Pulsing Current: [1]Not Permitted
Heat Input (max.) (J/in): None
Tungsten Electrode Type: [1]EWTh-2
Size (in): [1]1/32

TECHNIQUE (QW-410)

String or Weave Bead: [1]String/Weave
Orifice, Nozzle, or Gas Cup Size: [1]1/2
Initial and Interpass Cleaning (Brushing, Grinding, etc.): [1]None
Method of Back Gouging: [1]Brushing, Grinding, Air-arc
Contact Tube to Work Distance (in): None
Multiple or Single Pass (Per Side): [1]Single/Multiple
Multiple or Single Electrodes: None
Electrode Spacing (in): None
Peening: [1]Not Permitted

Date: December 4, 2018
Certified by: