

Information required for proper documentation of Welding Procedure Test

Company Name & Address		NOTES & EXAMPLES
Welder's Name		Please print legibly
Welder's ID#		If you don't have an ID system use last four of welders SS no.
Welding Process		SMAW, GMAW, GTAW, etc.
Process Type		Manual, SemiAutomatic, Machine, Automatic
Base Metal Specification		ASTM A240, AMS 5622, etc. Note: 6061, etc. is not a specification.
Base Metal Grade		Type 304(L), Grade B, 6061T-6, etc.
Thickness		3/8", 1/8" to 3/8", etc. For pipe, just list dia and sch. next line
Diameter		Nominal Pipe dia. (NA if plate) - 2.5" NPS, 6" sch 80, etc.
Filler Metal Specification		AWS A5.1, A5.9, AMS 4356, etc.
Filler Metal Class		E7018, ER70S-6, etc.
Filler Metal Diameter		List diameters used - 1/8", 3/32" root/1/8" fill
Shielding Gas/Flow Rate	@ _____	Argon @ 30 CFH, 75%Ar/25%CO2, etc.
Backing Gas/Flow Rate	@ _____	Same as above, NA if none used
Trailing Gas/Flow Rate	@ _____	Same as above, (Typ. Used for Titanium)
Flux Class		Submerged Arc Only - F7A2-EM12K, etc.
Preheat Temperature		List ambient temp. if part is not heated 72 deg. F, 350 deg. F, etc.
Max. Interpass Temp.		Max. temp at start of any pass
Position Welded		Flat, Horizontal, Vertical, Overhead
Direction of Vertical Travel		Uphill or Downhill (NA if not vertical weld)
Current Type/Polarity	_____ / _____	AC, DC / Electrode Positive or Negative
Pulsed?		Yes or No, GMAW or GTAW only
Wire Feed Speed	_____ Inches per minute	GMAW & Sub Arc only - 300 IPM, etc.
Tungsten Electrode Type		GTAW or Plasma only - EWTh-2, EWCe
Tungsten Electrode Dia.		GTAW or Plasma only - 1/8", 3/32", etc.
Stringer or Weave		String, Weave or "Both"
Max. Oscillation Width		Width of weave - 1/4", 3/8", etc.
Contact tube to Work Distance		Tip to work distance for GMAW & Sub Arc 3/8", 3/4", 1", etc.
Initial Plate/Pipe Cleaning		Mechanical (brushing or grinding), Chemical (Degrease, acid etch, etc.)
Interpass Cleaning		Mechanical, etc.
Post Weld Heat Treat Temp		NA if not used - 1175 deg. F
PWHT Time		NA if not used - 1 hour
Machine Model		Brand and model - Miller CC/CV 350, Lincoln CP300, etc.
Torch Model		HW18, 250 amp water cooled, etc.
Gas Cup Size		Cup # or actual ID - #8, 5/8", etc.

Record information for each pass									
Pass #	Filler Dia.	Amps	Volts	Inches travelled	in	How much time		IPM	Temp. at Beginning of Pass
						Minutes	Seconds		
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Sketch joint design showing bevel angle(s), root opening, land, backing, etc.

