

WPS QUALIFICATION TEST RECORD FOR ELECTROSLAG AND ELECTROGAS WELDING

PROCEDURE SPECIFICATION

Material specification _____
 Welding process _____
 Position of welding _____
 Filler metal specification _____
 Filler metal classification _____
 Filler metal _____
 Flux _____
 Shielding gas _____ Flow rate _____
 Gas dew point _____
 Thickness range this test qualifies _____
 Single or multiple pass _____
 Single or multiple arc _____
 Welding current _____
 Preheat temperature _____
 Postheat temperature _____
 Welder's name _____

VISUAL INSPECTION (Table 6.1, Cyclically loaded limitations)

Appearance _____
 Undercut _____
 Piping porosity _____

 Test date _____
 Witnessed by _____

TEST RESULTS

Reduced-section tensile test

Tensile strength, psi
 1. _____
 2. _____

All-weld-metal tension test

Tensile strength, psi _____
 Yield point/strength, psi _____
 Elongation in 2 in, % _____

Side-bend tests

1. _____ 3. _____
 2. _____ 4. _____

Radiographic-ultrasonic examination _____

RT report no. _____
 UT report no. _____

Impact tests

Size of specimen _____ Test temp _____
 Ft-lb: 1. _____ 2. _____ 3. _____ 4. _____
 5. _____ 6. _____ Avg. _____
 High _____ Low _____
 Laboratory test no. _____

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Joint Detail
		Amperes	Volts	
Guide tube flux _____ Guide tube composition _____ Guide tube diameter _____ Vertical rise speed _____ Traverse length _____ Traverse speed _____ Dwell _____ Type of molding shoe _____				

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 4 of AWS D1.1/D1.1M, (_____) *Structural Welding Code—Steel*.
 (year)

Procedure no. _____
 Revision no. _____
 Form N-3

Manufacturer or Contractor _____
 Authorized by _____
 Date _____