

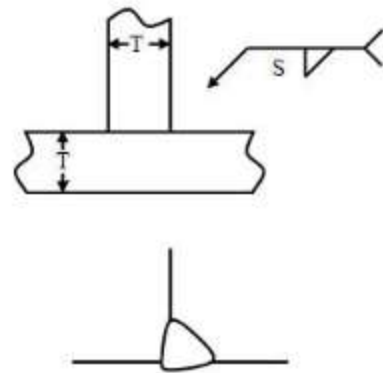
Sample Welding Procedure Specification (WPS) Form – Answer Key  
For SAW, SMAW, GMAW, GTAW, FCAW

|                 |                        |                                  |               |
|-----------------|------------------------|----------------------------------|---------------|
| Company:        | REAL WORKS Fabrication | Approved By: (Instructor's Name) |               |
| WPS Number:     | GM2FT1701/4            | Date:                            | Today's date  |
| Welding Process | GMAW                   | Type(s)                          | Semiautomatic |

[Manual, Semiautomatic, Automatic, Robotic, Mechanized]

|                                 |               |
|---------------------------------|---------------|
|                                 |               |
| <b>BASE &amp; FILLER METALS</b> |               |
| Material Type:                  | Mild Steel    |
| Thickness of Metal:             | ¼" (.250)     |
| Wire Type:                      | ER70S         |
| Filler Metal Size:              | 0.035         |
| Bead Height:                    | 0.25 in       |
|                                 |               |
| <b>POSITIONS</b>                |               |
| Preheat:                        | 50F           |
| Position:                       | T Joint       |
| Fillet/Groove:                  | Fillet        |
|                                 |               |
| <b>SHIELDING</b>                |               |
| Gas(es):                        | 75%Ar/25% CO2 |
| Flow Rate:                      | 25-35 CFH     |
|                                 |               |

Joint Details



Sketches, production drawings, welding symbols or written description should show general arrangement of the parts of the weld

|                                   |               |                        |              |
|-----------------------------------|---------------|------------------------|--------------|
| <b>ELECTRICAL CHARACTERISTICS</b> |               | <b>OTHER VARIABLES</b> |              |
| Transfer Mode:                    | Short Circuit | Number of Passes:      | 1            |
| Polarity:                         | DC (Elect+)   | Technique:             | Stringer     |
| Current:                          | 170 Amps      | Push/Pull              | Push         |
| Voltage:                          | 23 Volts      | CTWD (STD):            | 3/8 – 5/8 in |
| Wire Feed Speed (WFS):            | 360 ipm       | Speed (STD) (in/min):  | 7.6 – 9.4    |
|                                   |               | Travel Angle (Range):  | 0-10         |
|                                   |               | Work Angle (Range):    | 37-53        |