DEPARTEMEN TEKNIK MATERIAL DAN METALURGI

FTIRS – ITS

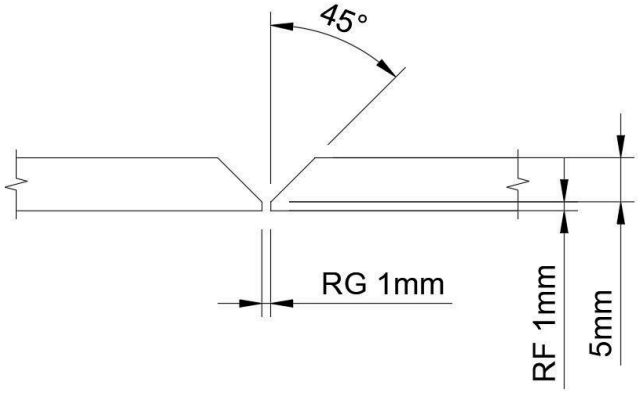
UNTUK MAHASISWA

WELDING PROCEDURE SPECIFICATIONS (WPS)

Company Name	: …..		
Welding Procedure Specification No.	: …..	Date	: …..
Supporting PQR No.	: …..	Rev. No.	: …..
This Spesification shall be in accordance with	: …..		
Welding Process (es)	: …..		
Type (Manual, Automatic, Semi-Auto)	: …..		

JOINTS (QW – 402)

Joint Design	: …..
Backing Material	: …..
Edge Preparation	: …..
Backing (Yes/No)	: …..
Other	: …..



BASE METAL (QW – 403)

P No. :	Group No.	: …..	to P No. : …..	Group No. : …..
Specification type & grade		: …..		
To Specification type & grade		: …..		
Chem. Analysis & Mech Prop.		: …..		
Thickness Range		: …..		
Pipe Dia Range		: …..		
Other		: …..		

FILLER METALS (QW – 404)

F No.	: …..	Other	: …..
A No.	: …..	Other	: …..
Spec. No. (SFA)	: …..		
AWS No. (Class)	: …..		
Size of filler metal / mm	: …..	Brand Name	: …..
Electrode Flux (Class)	: …..	Consumable Insert	: …..
Flux Trade Name	: …..		
Other	: …..		

POSITION (QW -405)

Position of Groove	: …..
Weld Progression	: …..
Uphill, downhill	: …..
Position of fillet	: …..
Other	: …..

PREHEAT (QW – 408)

Preheat Temp. Min	: …..
interpass Temp Max.	: …..
Method	: …..
Other	: …..

STRUCTURAL WELDER / WELDING OPERATOR QUALIFICATION TEST RECORD	Foto
Welder Name : Stamp : nrp Date :	

THE ABOVE WELDER IS QUALIFIED FOR THE FOLLOWING RANGE										
DEPOSIT SEQUENCE	**PROCESS**	**TYPE**	**POSITION**	**PROGRESS**	**DC AC**	**AMPRERE**	**VOLTAGE**	**TRAVEL SPEED**	**POLARITY**	**FILLER METAL OR ELECTRODE**
Root										
Hot										
Fill & Cap										

	ACTUAL VALUES	**RANGE OF QUALIFIED**
Plate or Pipe **Position** **Diameter** **Wall Thickness** **Groove or Fillet Weld** **Backing Gas and Flow Rate**		

TYPE OF NDE	
VT	
PT	
MT	
UT	
RT	

	NDT Inspector	**Lab Director**	**Department Director**
Name : Date : Signature :	*grader*	*Teknisi lab*	*Dosen matkul*

Alat

NO	NAMA ALAT/MESIN	KETERANGAN
1		
2		
3		
4		
5		
6		
7		
8		
9		
10		

Bahan

NO	NAMA BAHAN	KETERANGAN
1		
2		
3		
4		
5		
6		
7		
8		
9		
10		

PEMBAHASAN

Pembahasan:

KESIMPULAN DAN SARAN

Kesimpulan:

Saran:

DAFTAR PUSTAKA

LAMPIRAN

1.	**2.**	**3.**
4.	**5.**	**6.**
7.	**8.**	**9.**
10.	**11.**	**12.**

Keterangan :

1. XXX
2. XXX
3. XXX
4. XXX

Perhitungan *Travel Speed* :