

Weld Procedure

Company Info

Name	
Address	
Phone	
Fax	

Procedure #:	
Rev:	
PQR:	
Date:	

1	Base Metals/Specification/Type/Cond				
2	Thickness Range (in.)				
3	Filler metal	Specifications:		Type:	
4	Special Requirements				
5	Filler Metal Diameter (in.)				
6	Consumable Insert	Specifications:		Type:	Size (in.):
7	Flux	Specifications:		Type:	Mesh Size:
8	Deposit Thickness Range (in.)			Min. No. of Layers:	
9	Filler Metal Feed Rate (ipm)				
10	Electrode Type (GTAW)	▼			
11	Electrode Diameter (in.)				
12	Electrode Extension (in.)				
13	Welding Process	▼		Mode:	▼
14	Mode of Metal Transfer	▼			
15	Power Supply Make/Model/Type				
16	Torch/Head Make/Model/Type				
17	Welding Current Range (Amps)				
18	Slope Control (Short Circuit, if used)				
19	Voltage Range (Volts)				
20	Type of Current and Polarity	▼		Wave Form:	
21	Pulsed Parameters	Peak Volts/Amps:		Bkgrd Volts/Amps:	
22	Program:	Pulses/Sec:		Misc.	
23	Gas Cup/Nozzle Size(Dia) (in./#)				
24	Shielding Gas	Type:		Flow Rate Range (CFH):	
25	Purge/ Backing Gas	Type:		Flow Rate Range (CFH):	
26	Trailing Gas	Type:		Flow Rate Range (CFH):	
27	Temperatures	Preheat (°F) (min.):		Interpass (°F) (max.):	
28	Post Weld Heat Treatment	Temperature (°F):		Time:	
29	Heat Input (KJ/in)				
30	Torch Travel Speed (ipm)				
31	Welding Position(s) /Progression				
32	Fabrication Document(s)				
33	Welding Classifications/Limits				
34	Non Destructive Testing	In accordance with fabrication document and drawing requirements			
35	Cleaning:	The joint members to be welded, including the base metal surfaces, shall be cleaned to remove foreign material for a minimum of 1 inch from the weld edge. Mill scale or metallic oxides shall be removed from surfaces on which weld metal will be deposited. Slag shall be removed from all weld metal surfaces prior to depositing subsequent passes or layers and upon completion of the weld.			
36	<input checked="" type="radio"/> Specify Joint Type <input type="radio"/> Exception Statement	Qualified within the stated limits of process, position, base metal and thickness to weld all MIL-STD-22D joint designs except (Mark the exceptions below that apply) <ul style="list-style-type: none"> <input type="checkbox"/> Joints welded with preplaced filler metal inserts <input type="checkbox"/> Butt joints welded from one side with no backing or preplaced filler metal insert <input type="checkbox"/> Socket welds and fillet type seal welds in pipe with nominal wall thickness less than 3/16". <input type="checkbox"/> Seal welds other than edge or fillet types <input type="checkbox"/> Weld joints with included angles less than _____ degrees <input type="checkbox"/> Single pass for pressure containing joints <input type="checkbox"/> Tube-to-tubesheet welds <input type="checkbox"/> Cladding 			

Contact Information	Name:	Phone/email address:	
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