

Documentation of Welding Procedure Test



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witnessed by GL Surveyor (Name, date, signature, stamp)

1. WPS (Welding Procedure Specification)


 Preliminary status

 Final status

General information

WPS No. / Rev No.:		/	Date of test weld:	
Company name:		Department:		Place:
Welding process (EN ISO 4063):	111 - SMAW	Number of electrodes:		Joint type: Plate Butt weld
Welding position (ISO /ASME):	PA - 1G	Method of preparation:		Gouging / grinding:
Backing:	without	Tungsten electrode Ø:	[mm]	Welding layer: Single-layer
Preheating temp.:	[°C]	Interpass temp.:	[°C]	PWHT:

Material specification

Base material 1:	GL-A	Base material 2:	GL-A
Material thickness [mm]:		Material thickness [mm]:	
Outside diameter [mm]:		Outside diameter [mm]:	

Welding consumables

Filler metal		Gas	Flux		GL grade
Manufacturer	Brand name		Manufacturer	Brand name	

Joint preparation (sketch) and welding details

Joint design	Welding sequences

Run	Process	Ø filler metal [mm]	Current [A]	Voltage [V]	Type of current / polarity	Wire feed speed [m/min]	Travel speed [cm/min]	Heat input [kJ/cm]
	111 - SMAW		-	-			-	-
	111 - SMAW		-	-			-	-
	111 - SMAW		-	-			-	-
	111 - SMAW		-	-			-	-
	111 - SMAW		-	-			-	-

Further information

Shop primer			Other:
Manufacturer	Brand name	Dry film thickness	
		[µm]	

Place/Date

Welding Supervisor (Name and Signature)

2. Welding Data Sheet



General information

WPS No. / Rev No.:	/	Date of test weld:	
Welding position:	PA - 1G	Preheating temp.:	[°C] PWHT:

Joint preparation (sketch) and welding details

Joint design	Welding sequences

Run	Welding Process	Ø filler metal [mm]	Current [A]	Voltage [V]	Type of current / polarity	Wire feed speed [m/min]	Travel speed [cm/min]	Heat input [kJ/cm]
1	111 - SMAW							
2	111 - SMAW							
3	111 - SMAW							
4	111 - SMAW							
5	111 - SMAW							
6	111 - SMAW							
7	111 - SMAW							
8	111 - SMAW							
9	111 - SMAW							
10	111 - SMAW							
11	111 - SMAW							
12	111 - SMAW							
13	111 - SMAW							
14	111 - SMAW							
15	111 - SMAW							
16	111 - SMAW							
17	111 - SMAW							
18	111 - SMAW							
19	111 - SMAW							
20	111 - SMAW							

Base material heat No.:		Welding consumable lot No.:	
Name of welder / operator:			

Further information

Welding Supervisor (Name, date, Signature)

Test witnessed by GL Surveyor (Name, date, signature, stamp)

3. WPQR (Welding Procedure Qualification Record)



General information

WPS No. / Rev No.:	/	Date of test weld:	
WPQR No.:		Date of laboratory test:	
Welding process::	111 - SMAW	Base material:	GL-A
		Welding position:	PA - 1G

Non-destructive testing

Test Method	Results	Test report No.	Test Method	Results	Test report No.
Visual inspection:			Radiographic test:		
Ultrasonic test:			Magnetic particle test:		
Dye penetrate test:					

Destructive testing

Tensile test		Test report No.:	
Specified YS min. [N/mm ²]:		Specified TS min. [N/mm ²]:	

No.:	Dimension	Area [mm ²]	Test load Fr [N]	YS [N/mm ²]	Break load Fm [N]	TS [N/mm ²]	Elongation [%]	R.A. [%]	Location / Character of fracture

Bend test			Test report No.:		
Specified degree [°]:			Mandrel diameter. [mm]:		
Type	Dimension (W x T)	Result	Type	Dimension (W x T)	Result

Notched bar impact test			Test report No.:	
Test temperature[°C]:			Minimum requirement [J]:	
Notch location	Result 1 [J]	Result 2 [J]	Result 3 [J]	Average [J]
Weld metal				0
Fusion line				0
Fusion line + 2 mm				0
Fusion line + 5 mm				0
Fusion line + 10 mm				0

Hardness tests HV 10		Test report No.:						
Sketch "Double Click: Image in \\Forms with Makro\Z449DE"	Points	1	2	3	4	5	6	
	WM	A						
		B						
	HAZ	A						
		B						
	BM	A						
		B						

Test Method	Results	Test report No.	Test Method	Results	Test report No.
Macro photo			Fracture Test		
Micro photo					

Test Laboratory (Name, date, signature, stamp)

Lab test witnessed by GL Surveyor (Name, date, signature, stamp)

The latest edition of the General Terms and Conditions of Germanischer Lloyd is applicable. German law applies.

2.1. Further Welding Data Sheet

Run	Welding Process	Ø filler metal [mm]	Current [A]	Voltage [V]	Type of current / polarity	Wire feed speed [m/min]	Travel speed [cm/min]	Heat input [kJ/cm]
21	111 - SMAW							
22	111 - SMAW							
23	111 - SMAW							
24	111 - SMAW							
25	111 - SMAW							
26	111 - SMAW							
27	111 - SMAW							
28	111 - SMAW							
29	111 - SMAW							
30	111 - SMAW							
31	111 - SMAW							
32	111 - SMAW							
33	111 - SMAW							
34	111 - SMAW							
35	111 - SMAW							
36	111 - SMAW							
37	111 - SMAW							
38	111 - SMAW							
39	111 - SMAW							
40	111 - SMAW							
41	111 - SMAW							
42	111 - SMAW							
43	111 - SMAW							
44	111 - SMAW							
45	111 - SMAW							
46	111 - SMAW							
47	111 - SMAW							
48	111 - SMAW							
49	111 - SMAW							
50	111 - SMAW							

Welding Supervisor (Name, date, Signature)

Test witnessed by GL Surveyor (Name, date, signature, stamp)