

PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

(according EN ISO 15609-1:2020)

Name:

Type of the edge preparation:

Lab. group:

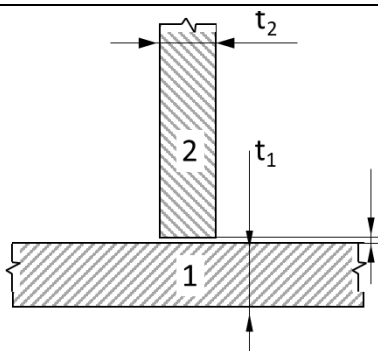
Type of the base materials: 1. 2.

Type of the welded joint:

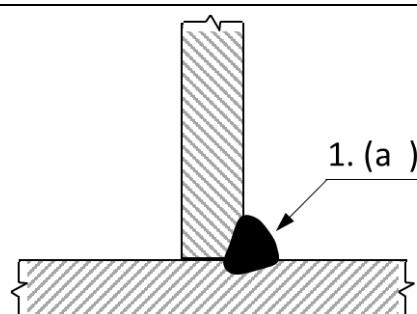
Material thickness (mm): $t_1 =$ $t_2 =$

Welding position:

Joint preparation



Weld buildup



Welding technology data

Weld bead row	Welding process	Size of filler metal $\varnothing$ (mm)	Amperage (A)	Voltage (V)	Current type and polarity (AC / DC)	Wire feed speed (m / min)	Welding speed (cm / min)	Heat input (kJ / mm)
1.								
2.								

Welding equipment type:

serial number:

Filler metals name and standardized designation:

Drying:

Name of the shielding gas:

Flow rate on face side (l/min):

Flow rate on root side (l/min):

Preheat temperature:

Preheat time:

Interpass temperature:

Post weld heat treatment / aging:

(time, temperature, method: heating and cooling speeds)

Additional information's:

Parameters of impulse welding:

Type of weld metal transfer:

Contact tube – work piece distance (mm):

Date:

.....

Approved by

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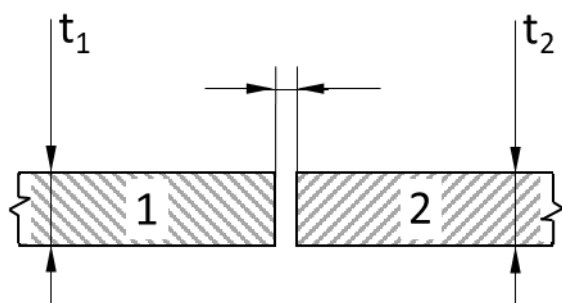
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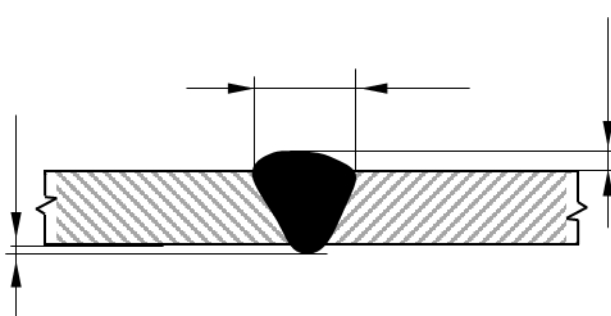
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Welding

QUESTIONS

(Circle the numbers of the three questions received during the lab session)

1. List three types of form-locking connections.
2. List three types of friction-locking connections.
3. List three types of material-locking joints!
4. Classify welding processes according to the mechanism of joint formation.
5. How is a welded joint formed in fusion welding processes?
6. How is a welded joint formed in pressure welding processes?
7. Which type of welding process is most widely used in steel structure manufacturing?
8. List three wire coatings used for the 13x welding processes!
9. List two inert shielding gases for welding!
10. Whats the heat input?

Responses given during lab

IN / OUT	Instructor's signature: