

**WELDING TECHNIQUE SHEET (Sample)**

Title: \_\_\_\_\_ WTS No.: \_\_\_\_\_  
 Drawing No.: \_\_\_\_\_ Work Order: \_\_\_\_\_  
 Reference WPS(s): \_\_\_\_\_ Supporting PQR(s): \_\_\_\_\_  
 Process(es): \_\_\_\_\_  Manual  Semi-Automatic  Automatic/Machine  
 Material: \_\_\_\_\_ to \_\_\_\_\_  
 Base Metal Thickness: \_\_\_\_\_ Deposited Weld Metal Thickness: \_\_\_\_\_  
 Preparation: \_\_\_\_\_ Gas: \_\_\_\_\_ Flow Rate: \_\_\_\_\_  
 Backing / Back Gouge: \_\_\_\_\_ Current: \_\_\_\_\_ Polarity: \_\_\_\_\_  
 Welding Position(s): \_\_\_\_\_ Stringer or Weave Bead: \_\_\_\_\_  
 Preheat (Min.) °F: \_\_\_\_\_ Inter-pass (Max.) °F: \_\_\_\_\_  
 Pipe Diameter: \_\_\_\_\_ PWHT Required:  Yes  No

JOINT SKETCH	SPECIAL INSTRUCTIONS

Bead or Layer Sequence						
Pass	Filler Metal	Size	Amps	Volts	Travel Speed	Heat Input (max.)

<b>AUTHORIZED BY</b> _____	<b>DATE</b> _____
----------------------------	-------------------