

ASME IX 'SWPS' Supplementary Guidance Documents

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
1-1-1-001	Carbon Steel	SMAW	Single or Double V Butt welded both sides	3mm	38mm	ALL VU	With or without PWHT.
1-1-1-002	Carbon Steel	SMAW	Single V Butt welded one side	3mm	38mm	ALL VD	With or without PWHT.
1-1-1-003	Carbon Steel	SMAW	Single V Butt welded one side	3mm	38mm	ALL VD (root) ALL VU (fill)	With or without PWHT.
1-1-1-2-001	Carbon Steel	GTAW / SMAW	Single V Butt welded one side	3mm	38mm	ALL VU	With or without PWHT.
1-1-2-001	Carbon Steel	GTAW	Single V Butt welded one side	3mm	38mm	ALL VU	With or without PWHT.
1-1-4-001	Carbon Steel	FCAW (CO2)	Single or Double V Butt welded both sides	3mm	38mm	ALL VU	A version of this procedure with PWHT is not available.
1-1-4-002	Carbon Steel	FCAW (Ar+CO2)	Single or Double V Butt welded both sides	3mm	38mm	ALL VU	With or without PWHT.
1-2-1-001	Stainless Steel	SMAW	Single or Double V Butt welded both sides	3mm	38mm	ALL VU	Consumable selection guide online.
1-2-1-002	Carbon Steel to Stainless Steel	SMAW	Single or Double V Butt welded both sides	3mm	38mm	ALL VU	Consumable selection guide online.
1-2-1-2-001	Stainless Steel	GTAW / SMAW	Single V Butt welded one side	3mm	38mm	ALL VU	Consumable selection guide online.
1-2-1-2-002	Carbon Steel to Stainless Steel	GTAW / SMAW	Single V Butt welded one side	3mm	38mm	ALL VU	Consumable selection guide online.
1-2-2-001	Stainless Steel	GTAW	Single V Butt welded one side	3mm	38mm	ALL VU	Consumable selection guide online.
1-2-2-002	Carbon Steel to Stainless Steel	GTAW	Single V Butt welded one side	3mm	38mm	ALL VU	Consumable selection guide online.

AWS D1.1 Section 3 Prequalified WPS

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
2-1-1-001	Carbon Steel	SMAW	Square Butt + backing	3mm	6mm / unlimited	ALL VU	Joint type may be prohibited for cyclic loading applications. Unlimited thickness applicable to one side of corner joints.
2-1-1-002	Carbon Steel	SMAW	Square Butt welded both sides	3mm	6mm / unlimited	ALL VU	This download includes 2 WPS. Unlimited thickness for one side of T & corner joints.
2-1-1-004	Carbon Steel	SMAW	Single V Butt + backing	3mm	Unlimited	ALL VU	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-1-006	Carbon Steel	SMAW	Single & Double V Butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS.
2-1-1-009	Carbon Steel	SMAW	Single Bevel Butt + Backing	3mm	Unlimited	ALL VU	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-1-011	Carbon Steel	SMAW	Single & Double Bevel butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-1-014	Carbon Steel	SMAW	Single and multi-pass fillets	3mm	Unlimited	ALL VU	This download includes 2 WPS. Lap joint may be prohibited for cyclic loading applications.
2-1-3-001	Carbon Steel	GMAW	Square Butt + backing	3mm	10mm	ALL VU	Joint type may be prohibited for cyclic loading applications. Unlimited thickness applicable to one side of corner joints.
2-1-3-002	Carbon Steel	GMAW	Square Butt welded both sides	3mm	10mm / Unlimited	ALL VU	This download includes 2 WPS. Unlimited thickness for one side of T & corner joints.
2-1-3-004	Carbon Steel	GMAW	Single V Butt + backing	3mm	Unlimited	1G / 3G / 4G	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-3-006	Carbon Steel	GMAW	Single & Double V Butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS.
2-1-3-009	Carbon Steel	GMAW	Single Bevel Butt + Backing	3mm	Unlimited	ALL VU	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-3-011	Carbon Steel	GMAW	Single & Double Bevel butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-3-014	Carbon Steel	GMAW	Single and multi-pass fillets	3mm	Unlimited	ALL VU	This download includes 2 WPS. Lap joint may be prohibited for cyclic loading applications.
2-1-4-001	Carbon Steel	FCAW	Square Butt + backing	3mm	10mm	ALL VU	Joint type may be prohibited for cyclic loading applications. Unlimited thickness applicable to one side of corner joints.
2-1-4-002	Carbon Steel	FCAW	Square Butt welded both sides	3mm	10mm / Unlimited	ALL VU	This download includes 2 WPS. Unlimited thickness for one side of T & corner joints.
2-1-4-004	Carbon Steel	FCAW	Single V Butt + backing	3mm	Unlimited	1G / 3G / 4G	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-4-006	Carbon Steel	FCAW	Single & Double V Butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS.

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
2-1-4-009	Carbon Steel	FCAW	Single Bevel Butt + Backing	3mm	Unlimited	ALL VU	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-4-011	Carbon Steel	FCAW	Single & Double Bevel butt welded both sides	3mm	Unlimited	ALL VU	This download includes 3 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-4-014	Carbon Steel	FCAW	Single and multi-pass fillets	3mm	Unlimited	ALL VU	This download includes 2 WPS. Lap joint may be prohibited for cyclic loading applications.
2-1-5-001	Carbon Steel	SAW	Square Butt welded both sides	6mm	10mm / 16mm / Unlimited	1G	This download includes 3 WPS. Square butt weld suitable for up to 16mm. Square T-butt weld suitable for up to 10mm one side and unlimited the other side.
2-1-5-004	Carbon Steel	SAW	Single V Butt & Corner Butt + backing	6mm	50mm / unlimited	1G	This download includes 4 WPS. Includes 2 "wide gap" WPS suitable for unlimited thickness. Joints may be prohibited for cyclic loading applications.
2-1-5-008	Carbon Steel	SAW	Single & Double V Butt welded both sides	6mm	Unlimited	1G	This download includes 3 WPS. WPS using Single V butt welded both sides limited to 12mm to 50mm thickness range.
2-1-5-011	Carbon Steel	SAW	Single Bevel Butt + Backing	6mm	Unlimited	1G	This download includes 2 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-5-013	Carbon Steel	SAW	Single & Double Bevel butt welded both sides	6mm	Unlimited	1G	This download includes 3 WPS. Joint type may be prohibited for cyclic loading applications.
2-1-5-016	Carbon Steel	SAW	Single and multi-pass fillets	6mm	Unlimited	1F / 2F	This download includes 2 WPS. Lap joint may be prohibited for cyclic loading applications.

ISO 15612 Qualified WPS with PQR and Test Records

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
10-1-1-002	Carbon Steel	MMAW	Single & Double-Sided Butts and Fillets	3mm	17.12mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 57.15 mm. WPS suitable for multi-pass fillet welds on material thickness 4.0mm to 10.27mm.
10-1-2-001	Carbon Steel	GTAW	Single & Double-Sided Butts and Fillets	3mm	17.12mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 57.15 mm. WPS suitable for multi-pass fillet welds on material thickness 4.0mm to 10.27mm.
10-1-14-001	Carbon Steel	MMAW / FCAW	Single & Double-Sided Butts and Fillets	3mm	16mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 150 mm for PA and PC positions and ≥ 500 mm for all other positions. WPS suitable for 3.0-6.0mm single pass fillet welds used MMAW (111) and multi-pass fillet welds using FCAW (136) on material thickness 4.0mm to 9.4mm.
10-1-14-002	Carbon Steel	MMAW / FCAW	Single & Double-Sided Butts and Fillets	16mm	64mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 150 mm for PA and PC positions and ≥ 500 mm for all other positions. WPS suitable for 3.0-6.0mm single pass fillet welds used MMAW (111) and multi-pass fillet welds using FCAW (136) on material thickness ≥ 5 mm.
10-1-14-003	Carbon Steel	MMAW / FCAW	Single & Double-Sided Butts and Fillets	9.13mm	36.52mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 84.15 mm. WPS suitable for 3.0-6.0mm single pass fillet welds used MMAW (111) and multi-pass fillet welds using FCAW (136) on material thickness 9.13mm to 21.91mm.
10-1-24-001	Carbon Steel	GTAW / FCAW	Single & Double-Sided Butts and Fillets	9.13mm	36.52mm	ALL VU	WPS suitable for plate and pipe with outside diameters ≥ 84.15 mm. WPS suitable for 3.0-6.0mm single pass fillet welds used GTAW (141) and multi-pass fillet welds using FCAW (136) on material thickness 9.13mm to 21.91mm.

AS/NZS 3992 Section 2 Prequalified WPS

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
4-1-1-001	Carbon Steel	SMAW	Single V Butt with or without backing	3mm	20mm	ALL VU	This download includes 2 WPS. E7016 used for root pass on WPS without backing.
4-1-1-003	Carbon Steel	SMAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-1-005	Carbon Steel	SMAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	
4-1-13-001	Carbon Steel	SMAW / GMAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	GMAW spray transfer only suitable for 1G (flat) position.
4-1-135-001	Carbon Steel	SMAW / GMAW / SAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	GMAW spray transfer only suitable for 1G (flat) position.
4-1-14-001	Carbon Steel	SMAW / FCAW	Single V Butt welded one side	3mm	20mm	ALL VU	None
4-1-145-001	Carbon Steel	SMAW / FCAW / SAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	None
4-1-15-001	Carbon Steel	SMAW / SAW	Single V Butt with or without backing	3mm	20mm	All VU / 1G	This download includes 2 WPS. E7016 used for root pass on WPS without backing. E7018 used for 2nd / 3rd pass on WPS without backing.
4-1-15-003	Carbon Steel	SMAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	All VU / 1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-2-001	Carbon Steel	GTAW	Single V Butt with or without backing	3mm	20mm	ALL VU	This download includes 2 WPS.
4-1-2-003	Carbon Steel	GTAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-2-005	Carbon Steel	GTAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	None
4-1-21-001	Carbon Steel	GTAW / SMAW	Single V Butt welded one side	3mm	20mm	ALL VU	None
4-1-23-001	Carbon Steel	GTAW / GMAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	GMAW spray transfer only suitable for 1G (flat) position.
4-1-235-001	Carbon Steel	GTAW / GMAW / SAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	GMAW spray transfer only suitable for 1G (flat) position.
4-1-24-001	Carbon Steel	GTAW / FCAW	Single V Butt welded one side	3mm	20mm	ALL VU	None

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
4-1-245-001	Carbon Steel	GTAW / FCAW / SAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	None
4-1-3-001	Carbon Steel	GMAW	Single V Butt + backing	3mm	20mm	1G	None
4-1-3-002	Carbon Steel	GMAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-3-004	Carbon Steel	GMAW	Single and multi-pass T-fillet welds	3mm	40mm	1F / 2F	None
4-1-35-001	Carbon Steel	GMAW / SAW	Single V Butt + backing	3mm	20mm	1G	None
4-1-35-002	Carbon Steel	GMAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-4-001	Carbon Steel	FCAW	Single V Butt + backing	3mm	20mm	ALL VU	None
4-1-4-002	Carbon Steel	FCAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-4-004	Carbon Steel	FCAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	None
4-1-45-001	Carbon Steel	FCAW / SAW	Single V Butt + backing	3mm	20mm	All VU / 1G	None
4-1-45-002	Carbon Steel	FCAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	All VU / 1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-5-001	Carbon Steel	SAW	Single V Butt + backing	3mm	20mm	1G	None
4-1-5-002	Carbon Steel	SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-1-5-004	Carbon Steel	SAW	Single and multi-pass T-fillet welds	3mm	40mm	1F / 2F	None
4-2-1-001	Stainless Steel	SMAW	Single V Butt + backing	3mm	20mm	ALL VU	None
4-2-1-002	Stainless Steel	SMAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V WPS limited to 20mm.
4-2-1-004	Stainless Steel	SMAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	None
4-2-15-001	Stainless Steel	SMAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	All VU / 1G	This download includes 2 WPS. Single V WPS limited to 20mm.
4-2-2-001	Stainless Steel	GTAW	Single V Butt with or without backing	3mm	20mm	ALL VU	None
4-2-2-003	Stainless Steel	GTAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V limited to 20mm.
4-2-2-005	Stainless Steel	GTAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	None
4-2-21-001	Stainless Steel	GTAW / SMAW	Single V Butt welded one side	3mm	20mm	ALL VU	None
4-2-23-001	Stainless Steel	GTAW / GMAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	GMAW spray transfer only suitable for 1G (flat) position.

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
4-2-24-001	Stainless Steel	GTAW / FCAW	Single V Butt welded one side	3mm	20mm	ALL VU	None
4-2-25-001	Stainless Steel	GTAW / SAW	Single V Butt welded one side	3mm	20mm	All VU / 1G	None
4-2-3-001	Stainless Steel	GMAW	Single V Butt + backing	3mm	20mm	1G	None
4-2-3-002	Stainless Steel	GMAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	1G	This download includes 2 WPS. Single V limited to 20mm.
4-2-3-004	Stainless Steel	GMAW	Single and multi-pass T-fillet welds	3mm	40mm	1F / 2F	None
4-2-35-001	Stainless Steel	GMAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	1G	This download includes 2 WPS. Single V limited to 20mm.
4-2-4-001	Stainless Steel	FCAW	Single V Butt + backing	3mm	20mm	ALL VU	None
4-2-4-002	Stainless Steel	FCAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	ALL VU	This download includes 2 WPS. Single V limited to 20mm.
4-2-4-004	Stainless Steel	FCAW	Single and multi-pass T-fillet welds	3mm	40mm	ALL VU	None
4-2-45-001	Stainless Steel	FCAW / SAW	Single & Double V Butt welded both sides	3mm	20mm / 40mm	All VU / 1G	This download includes 2 WPS. Single V limited to 20mm.
4-2-5-001	Stainless Steel	SAW	Single V Butt + backing	3mm	20mm	1G	None
4-2-5-002	Stainless Steel	SAW	Single and multi-pass T-fillet welds	3mm	40mm	1F / 2F	None

AS/NZS 1554 Qualified WPS with PQR and Test Records

WPS #	Material	Processes	Joint Type	T (min)	T (max)	Position	Additional Notes
5-1-1-001	Steel Type 1 to 6	MMAW	Single & Double Bevel Butt welds	4mm	16mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-1-002	Steel Type 1 to 6	MMAW	Single & Double Bevel Butt welds	4mm	16mm	3G VU	Tested and qualified WPS with PQR
5-1-1-003	Steel Type 1 to 6	MMAW	Single & Double V Butt welds	4mm	16mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-1-004	Steel Type 1 to 6	MMAW	Single & Double V Butt welds	4mm	16mm	3G VU	Tested and qualified WPS with PQR
5-1-1-005	Steel Type 1 to 6	MMAW	Single and multi-pass fillet welds	Unlimited	Unlimited	1F / 2F / 4F	Tested and qualified WPS with PQR
5-1-1-006	Steel Type 1 to 6	MMAW	Single and multi-pass fillet welds	Unlimited	Unlimited	3F VU	Tested and qualified WPS with PQR
5-1-1-007	Steel Type 1	MMAW	Single & Double V Butt welds	4.28mm	17.12mm	ALL VU	Tested and qualified WPS with PQR
5-1-2-001	Steel Type 1	GTAW	Single & Double V Butt welds	4.28mm	17.12mm	ALL VU	Tested and qualified WPS with PQR
5-1-4-001	Steel Type 1 to 6	FCAW	Single and multi-pass fillet welds	Unlimited	Unlimited	1F / 2F / 4F	Tested and qualified WPS with PQR
5-1-4-002	Steel Type 1 to 6	FCAW	Single and multi-pass fillet welds	Unlimited	Unlimited	3F VU	Tested and qualified WPS with PQR
5-1-14-001	Steel Type 1 to 6	MMAW / FCAW	Single & Double Bevel Butt welds	4mm	16mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-14-002	Steel Type 1 to 6	MMAW / FCAW	Single & Double Bevel Butt welds	4mm	16mm	3G VU	Tested and qualified WPS with PQR
5-1-14-003	Steel Type 1 to 6	MMAW / FCAW	Single & Double V Butt welds	4mm	16mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-14-004	Steel Type 1 to 6	MMAW / FCAW	Single & Double V Butt welds	4mm	16mm	3G VU	Tested and qualified WPS with PQR
5-1-14-005	Steel Type 1 to 6	MMAW / FCAW	Single & Double Bevel Butt welds	16mm	64mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-14-006	Steel Type 1 to 6	MMAW / FCAW	Single & Double Bevel Butt welds	16mm	64mm	3G VU	Tested and qualified WPS with PQR
5-1-14-007	Steel Type 1 to 6	MMAW / FCAW	Single & Double V Butt welds	16mm	64mm	1G / 2G / 4G	Tested and qualified WPS with PQR
5-1-14-008	Steel Type 1 to 6	MMAW / FCAW	Single & Double V Butt welds	16mm	64mm	3G VU	Tested and qualified WPS with PQR
5-1-14-009	Steel Type 1	MMAW / FCAW	Single & Double V Butt welds	9.13mm	36.52mm	ALL VU	Tested and qualified WPS with PQR
5-1-24-001	Steel Type 1	GTAW / FCAW	Single & Double V Butt welds	9.13mm	36.52mm	ALL VU	Tested and qualified WPS with PQR