

Field fit-up aid. Weld to your approved WPS and inspector.

FITUP DC fit-up sheet

Each weld row shows its saved WPS profile and target values.

Weld	Run / joint	Profile / authority	Bevel target / checked	Fit-up target / checked	Status
W-14	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 37.4 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/32 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	IN
W-13	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 37.4 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/32 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	IN
W-12	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 37.4 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/32 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	IN
W-11	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 41.2 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/16 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	Review
W-10	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 37.4 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/32 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	IN
W-9	Run A 6 in SCH40 Carbon, GTAW root	Job WPS WPS-12 ASME B31.3 2024	Target 37.5 deg +/- 2.5 deg Checked 37.4 deg flat	Gap target 3/32 in +/- 1/32 in Gap checked 3/32 in Land target 1/16 in +/- 1/32 in Land checked 1/16 in Hi-lo max 1/16 in OK	IN