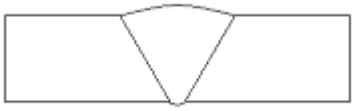
PROCEDURE QUALIFICATION RECORD (PQR)
SECTION IX, QW-483 ASME BOILER AND PRESSURE VESSEL CODE

Your Logo	Your Company Name	
	PQR Number:	
	WPS Used:	
	Welding Process (es) Used:	
	Process (es) Type (s)	

JOINTS (QW-403)



Groove Design of Test Coupon
(For combination qualifications, the deposited weld metal thickness shall be recorded for each filler metal or process used)

BASE METALS (QW-403)	**POSTWELD HEAT TREATMENT (QW-407)**
Material Spec. SA387 to SA387	*Temperature* None performed
Type or Grade 5 to 5	*Time*
P-No. 5B *to P-No.* 5B	*Other*
Thickness of Test Coupon 3/8"	
Diameter of Test Coupon PLATE	
Other 3/16" GTAW deposit	**GAS (QW-408)**
3/16" SMAW deposit	*Type of Gas or Gases* Argon
	Composition of Gas Mixture Welding Grade
	Other
FILLER METALS (QW-404)	
Weld Metal Analysis A-No. 4	
Size of Filler Metal 1/8"	**ELECTRICAL CHARACTERISTICS (QW-409)**
Filler Metal F-No. 6 and 4	*Current* Direct
SFA Specification 5.9 and 5.4	*Polarity* GTAW=EN SMAW=EP
AWS Classification ER502 and E 502	*Amps* See below
Other	*Volts* See below
	Tungsten Electrode Size 1/8"
	Other:
POSITION (QW-505)	
Position of Groove 3G	
Weld Progression (Uphill, Downhill) Uphill	**TECHNIQUE (QW-410)**
Other	*Travel Speed* 2 - 4 IPM
	String or Weave Bead Both
PREHEAT (QW-406)	*Oscillation* Not measured
Preheat Temp. 400 F Minimum	*Multipass or Single Pass (per side)* Multipass
Interpass Temp. 750 F Maximum	*Other*
Other:	

Procedure Qualification Record Form QW-483 (BACK)
PQR Number 00000
Tensile Test (QW-150)

SPECIMEN NO.	WIDTH	THICKNESS	AREA	ULTIMATE TOTAL LOAD LB.	ULTIMATE UNIT STRESS PSI	TYPE OF FAILURE AND LOCATION
627-T1	.714	.379	.2706	21,850	80,700	BM Ductile
627-T2	.721	.376	.2711	22,000	81,200	BM Ductile

Guided-Bend Tests (QW-160)

TYPE AND FIGURE NO.	RESULT
QW 462.3 Root Bend	Satisfactory
QW 462.3 Face Bend	Satisfactory
QW 462.3 Root Bend	Satisfactory
QW 462.3 Face Bend	Satisfactory

Toughness Tests (QW-170)

SPECIMEN NO.	NOTCH LOCATION	NOTCH TYPE	TEST TEMP	IMPACT VALUES	LATERAL EXP		DROP WEIGHT	
					% SHEAR	MILS	BREAK	NO-BREAK

Fillet-Weld Test (QW-180)

Results – Satisfactory: Yes ☐ No ☐	Penetration into Parent Metal: Yes ☐ No ☐
Macro – Results	

Other Tests

Test Type:	
Deposit Analysis:	
Other:	

Welder's Name		**Stamp Number**	
Tests Conducted by:			
Laboratory Test No.			

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Code.

Attested To By: Signature	
Date:	