QB-484 – SUGGESTED FORMAT A FOR BRAZER/BRAZING OPERATOR PERFORMANCE QUALIFICATIONS (BPQ)

(See QB-301, Section IX, ASME Boiler and Pressure Vessel Code)

Brazer's /Operators Name _____ Identification No. _____

Testing Conditions and Ranges Qualified

Identification of BPS followed during brazing of test coupon _____

Specification of First Test Coupon base Metal _____

Specification of Second Test Coupon base Metal _____

Brazing Variables	Actual Values	Range Qualified
Brazing Process(es)		
Type of brazing (manual, semi-automatic automatic) :		
Base metal P- or S-Number to P-or S-Number	**to**	
☐ Plate ☐ Pipe (enter diameter, if pipe or tube):	″	
First base metal Thickness (in.):		
Second base metal Thickness (in.):		
Joint type (Butt, Lap, Scarf, Socket, etc.):		
If Lap or Socket, Overlap Length (in.)		
Joint Clearance (in.)		
Filler Metal SFA Specification(s) (info only):		
Filler Metal Classification(s) (info only):		
Filler Metal/F-Number		
Filler Metal Product Form:		
First Brazing position		
Second Brazing position		

Testing and Results

Visual Examination of Completed Joint _____ **Date of Test:** _____

Mechanical test ☐Peel (QB-462.3) ☐Section (QB-462.4) ☐ Tension (QB-462.1(e)

Position	Result	Position	Result	Position	Result

Brazing Supervised by: _____ Company: _____

Mechanical tests Conducted by: _____ Company: _____

Specimens evaluated by: _____ Company: _____

Lab Test No.: _____

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

Company Name _____

By: _____ Date: _____