

PQR-SINGLE PROCESS

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| pqr_number | |
| pqr_revision_number | |
| wps_number | |
| revision_number | |
| qualified_to | |
| date | |
| company_name | |
| reference_documents | |
| welding_process | |
| Type | |
| metal1_specification | |
| metal1_grade | |
| metal1_uns | |
| metal1_p_number | |
| metal1_group_number | |
| welded_to_specification | |
| welded_to_grade | |
| welded_to_uns | |
| welded_to_p_number | |
| welded_to_group_number | |
| thickness_of_test_coupon | |
| diameter_of_test_coupon | |
| tested_with | |
| base_metal_maximum_pass_thickness | |
| base_metal_other | |
| welding_process | |
| filler1_sfa | |
| filler1_classification | |
| filler1_f_number | |
| filler1_a_number | |
| filler1_chemical_analysis_or_trade_name | |
| filler1_size | |
| filler1_product_form_type | |
| filler1_weld_metal_thickness | |
| consumable_insert_sfa | |
| consumable_insert_classification | |
| consumable_insert_f_number | |
| consumable_insert_a_number | |
| consumable_insert_chemical | |
| consumable_insert_size | |
| consumable_insert_productform | |
| | |
| filler_metal_other | |
| position_of_groove | |
| welding_progression | |
| position_fillet | |
| position_other | |
| preheat_temp | |
| interpass_temp | |
| preheat_maintenance | |
| preheat_other | |
| pwht_temp_range | |
| pwht_time_range | |
| pwht_heating_rate | |
| pwht_heating_type | |
| pwht_cooling_rate | |
| pwht_cooling_type | |
| pwht_other | |
| shieldgas_mixture | |
| shieldgas_flow_rate | |
| trailinggas_mixture | |
| trailinggas_flow_rate | |
| backinggas_mixture | |
| backinggas_flow_rate | |
| gas_other_mixture | |
| gas_other_flow_rate | |
| current_polarity | |
| ampere_range | |
| voltage_range | |
| pulsing_current | |
| electrical_other | |
| tungsten_type | |
| tungsten_size | |
| travel_speed | |
| heat_input_max | |
| wire_feed_type | |
| wire_feed_speed | |
| string_weave | |
| orifice_gas_cup_size | |
| initial_interpass_cleaning | |
| methode_back_gouging | |
| oscillation | |
| contact_tube_to_work_distance | |
| multi_single_pass | |
| multi_single_electrode | |
| peening | |
| surface_cleaning | |
| technique_other | |
| joint_image1 | |
| joint_image2 | |
| joint_design_name | |
| joint_backing | |
| joint_root_spacing | |
| backing_material | |
| retainers | |
| joint_other | |
| note | |
| | |
| tensile_test_specimen_no_array | |
| tensile_test_width_array | |
| tensile_test_thickness_array | |
| tensile_test_area_array | |
| tensile_test_ultimate_total_load_array | |

PQR-GTAW+SMAW PROCESS

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|--|--|
| pqr_number | |
| pqr_revision_number | |
| wps_number | |
| revision_number | |
| qualified_to | |
| date | |
| company_name | |
| reference_documents | |
| welding_process | |
| Type | |
| metal1_specification | |
| metal1_grade | |
| metal1_uns | |
| metal1_p_number | |
| metal1_group_number | |
| welded_to_specification | |
| welded_to_grade | |
| welded_to_uns | |
| welded_to_p_number | |
| welded_to_group_number | |
| thickness_of_test_coupon | |
| diameter_of_test_coupon | |
| tested_with | |
| base_metal_maximum_pass_thickness | |
| base_metal_other | |
| gtaw_filler1_sfa | |
| gtaw_filler1_classification | |
| gtaw_filler1_f_number | |
| gtaw_filler1_a_number | |
| gtaw_filler1_chemical_analysis_or_trade_name | |
| gtaw_filler1_size | |
| gtaw_filler1_product_form_type | |
| gtaw_filler1_weld_metal_thickness | |
| | |
| smaw_filler1_sfa | |
| smaw_filler1_classification | |
| smaw_filler1_f_number | |
| smaw_filler1_a_number | |
| smaw_filler1_chemical_analysis_or_trade_name | |
| smaw_filler1_size | |
| smaw_filler1_product_form_type | |
| smaw_filler1_weld_metal_thickness | |
| | |
| consumable_insert_SFA | |
| consumable_insert_classification | |
| consumable_insert_f_number | |
| consumable_insert_a_number | |
| consumable_insert_chemical | |
| consumable_insert_size | |
| consumable_insert_productform | |
| filler_metal_other | |
| | |
| gtaw_position_of_groove | |
| gtaw_welding_progression | |
| gtaw_position_fillet | |
| gtaw_position_other | |
| smaw_position_of_groove | |
| smaw_welding_progression | |
| smaw_position_fillet | |
| smaw_position_other | |
| gtaw_preheat_temp | |
| gtaw_interpass_temp | |
| gtaw_preheat_maintenance | |
| gtaw_preheat_other | |
| smaw_preheat_temp | |
| smaw_interpass_temp | |
| smaw_preheat_maintenance | |
| smaw_preheat_other | |
| gtaw_current_polarity | |
| gtaw_ampere_range | |
| gtaw_voltage_range | |
| gtaw_pulsing_current | |
| gtaw_travel_speed | |
| gtaw_wire_feed_type | |
| gtaw_wire_feed_speed | |
| gtaw_heat_input_max | |
| gtaw_tungsten_type | |
| gtaw_tungsten_size | |
| gtaw_electrical_other | |
| smaw_current_polarity | |
| smaw_ampere_range | |
| smaw_voltage_range | |
| smaw_pulsing_current | |
| smaw_travel_speed | |
| smaw_heat_input_max | |
| smaw_electrical_other | |
| gtaw_string_weave | |
| gtaw_orifice_gas_cup_size | |
| gtaw_multi_single_pass | |
| gtaw_multi_single_electrode | |
| gtaw_oscillation | |
| smaw_string_weave | |
| smaw_orifice_gas_cup_size | |
| smaw_multi_single_pass | |
| smaw_multi_single_electrode | |
| print smaw_oscillation | |
| maximum_pass_thickness | |
| initial_interpass_cleaning | |
| methode_back_gouging | |
| peening | |
| surface_cleaning | |
| technique_other | |
| joint_image1 | |

[illegible][illegible]

