QB-482 SUGGESTED FORMAT FOR BRAZING PROCEDURE SPECIFICATIONS (BPS)
(See QB-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name _____ By _____

BPS Number _____ Revision: _____ Date issued: _____

Supporting PQRs: _____

Brazing Process(es) _____ Type (s) _____
(Automatic, Manual, Machine, or Semi-Automatic)

Joint Design (QB-408)

Joint Design: Type: _____ Clearance: _____

Overlap: Minimum: _____ Maximum: _____

Base Metal (QB-402)

P/S Number _____

to P/S Number: _____

Other _____

Base Metal Thickness

Minimum: _____

Maximum: _____

Brazing Filler Metal (QB-403)

Specification Number: _____

AWS Classification _____

F-Number _____

Filler Metal Product Form _____

_____

Brazing Temperature (QB-404)

Brazing temperature range _____

Post Braze Heat Treatment (QB-409)

Temperature Range _____

Time Range _____

Flow Positions (QB-407)

Positions permitted: _____

Flow Direction _____

Brazing Flux, Fuel Gas, or Atmosphere (QB-406)

Flux AWS Class, Composition or Trade Name: _____

Fuel gas: _____

Furnace Temperature _____

Atmosphere Type _____

Other: _____

Technique (QB-410) and Other Information

Initial Cleaning: _____

Flux Application: _____

Nature of Flame (Oxidizing, Neutral, Reducing): _____

Torch Tip Sizes _____

Postbraze Cleaning _____

Inspection _____

Manufacturer _____

By: _____

Title: _____ Date: _____