

QW-483 SUGGESTED FORMAT FOR PROCEDURE QUALIFICATION RECORDS (PQR)

(See QW-200.2, Section IX, ASME Boiler and Pressure Vessel Code)

Record Actual Conditions Used to Weld Test Coupon

Company Name _____
Procedure Qualification Record No. _____ Date _____
WPS No. _____
Welding Process (es) _____
Types (Manual, Automatic, Semi-Automatic) _____

JOINTS (QW-402)

Groove Design of Test Coupon (sketch, figure or reference)

(For combination qualifications, the deposited weld metal thickness shall be recorded for each filler metal and process used.)

BASE METALS (QW-403)

Material Specification _____
Type or Grade or UNS Number _____
P No. _____ Group No. _____ to P No. _____ Group No. _____
Thickness of Test Coupon _____
Diameter of Test Coupon _____
Maximum Pass Thickness _____
Other _____

POST WELD HEAT TREATMENT (QW-407)

Temperature _____
Time _____
Other _____

FILLER METALS (QW-404)

	1	2	3
Layer (combination welds)			
SFA Specification	_____	_____	_____
AWS Classification	_____	_____	_____
Filler Metal F No.	_____	_____	_____
Weld Metal Analysis A No.	_____	_____	_____
Size of Filler Metal	_____	_____	_____
Filler Metal Product Form	_____	_____	_____
Supplemental Filler Metal	_____	_____	_____
Electrode Flux Classification	_____	_____	_____
Flux Type	_____	_____	_____
Flux Trade Name	_____	_____	_____
Weld Metal Thickness	_____	_____	_____
Other	_____	_____	_____

GAS (QW-408)

	Gas (es)	Percent Composition (Mixture)	Flow Rate
Shielding	_____	_____	_____
Trailing	_____	_____	_____
Backing	_____	_____	_____
Other	_____	_____	_____

ELECTRICAL CHARACTERISTICS (QW-409)

Current _____
Polarity _____
Amps _____ Volts _____
Tungsten Electrode Size _____
Transfer Mode for GMAW (FCAW) _____
Other _____

POSITION (QW-405)

Position of Groove _____
Weld Progression (Uphill, Downhill) _____
Other _____

TECHNIQUE (QW-410)

Travel Speed _____
String or Weave Bead _____
Oscillation _____
Multipass or Singles Pass (per side) _____
Single or Multiple Electrodes _____
Other _____

PREHEAT (QW-406)

Preheat Temperature _____
Interpass Temperature _____
Other _____

QW-483 (Back)

PQR No. _____

Tensile Test (QW-150)

Specimen Number	Width	Thickness	Area	Ultimate Total Load	Ultimate Unit Stress (psi or MPa)	Type of Failure & Location

Guided Bend Tests (QW-160)

Type and Figure No.	Result

Toughness Tests (QW-170)

Specimen Number	Notch Location	Specimen Size	Test Temperature	Impact Values			Drop Weight Break (Yes/No)
				Ft-lb or J	% Shear	Mils (in.) or mm	

Comments _____

Fillet Weld Test (QW-180)

Result- Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro - Results _____

Other TestsType of Test _____
Deposit Analysis _____
Other _____Welders Name _____ Clock No. _____ Stamp No. _____
Tests Conducted by _____ Laboratory Test Number _____

We certify that statements made 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 Boiler and Pressure Vessel Code

Manufacturer or Contractor _____

Date _____ Certified By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the code.)