



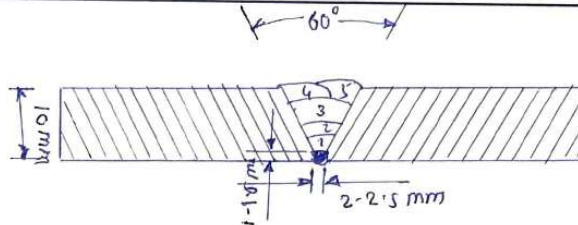
QW – 483
PROCEDURE QUALIFICATION RECORD
(PQR)
 (ASME SECTION IX 2019 EDITION)

COMPANY NAME: JG ACERO INDUSTRIES PVT.LTD

Page 1 of 2

PQR NO. : JGAIPL/SS/PQR/01	Date : 07/01/2021
Welding Process(es) : GTAW + SMAW Type(s) : Manual	WPS No. : JGAIPL/SS/WPS/01 Rev.0

JOINTS : (QW – 402) :



BASE METALS (QW-403)			POST WELD HEATTREATMENT : (QW -407)			
P. No. 8 Gr. No. 1 TO P. No. 8 Gr. No. 1 Material Specification : SA240 TYP 304 To SA240 TYP 304 Thickness of Test coupon : 10 mm			Temperature Range °C : None			
			Time Range : None			
FILLER METAL : (QW – 404)			GAS : (QW-408)	Gas(es)	% Comp Mixture	Flow Rate (lit / min)
Process	GTAW	SMAW	Shielding	Argon	99.99 %	14
SFA No.	5.9	5.4	Trailing	None	---	----
AWS (Class)	ER 308 L	E 308 L	Backing (Only for root pass)	None	---	-----
F. No.	6	4	ELECTRICAL CHARACTERISTICS (QW-409)			
A. No.	8	8	Type of Current : DC	Polarity :GTAW- SP , SMAW -RP		
Size of Filler Metal (mm) dia	2.4 mm	3.15	Amps : * See Tabulation On page 2 of 2	Volts : * See Tabulation On page 2 of 2		
Weld Metal Thk. (mm)	5 mm	5 mm	Tungsten Electrode : 3 mm, 2% Thoriated (EWTH) Size and Type			
Filler Metal Product Form	Solid (Bare)	Solid	Heat Input : Not Recorded			
Other : Nil			TECHNIQUE : (QW-410)			
POSITION : (QW-405)			String or Weave Bead : Weave			
Position(s) of Groove : 3G			Orifice or Gas Cup Size ϕ (mm) : 10 mm			
Weld Progression : Up-Hill			Initial and Inter pass Cleaning : Wire Brush/Wire wheel			
Other : Nil			Method of Back Gouging : Grinding			
			Oscillation : Not Applicable			
			Contact Tube to Work distance (mm) : Not Applicable			
PREHEAT : (QW-406)			Multiple or single Pass per side : Multiple			
Preheat Temperature °C (Min) : Nil			Multiple or Single Electrode : Single			
Inter pass Temperature °C (Max) : 150			Travel Speed (Range) mm / min *See Tabulation : Page 2 of 2			
Preheat Maintenance : None			Peening : None			
			Other : Weld surface cleaned by wire brush			





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PQR NO. : JGAIP/SS/PQR/01

Date : 07/01/2021

Welding Process(es) : GTAW + SMAW

Type(s) : Manual

WPS No. : JGAIP/SS/WPS/01 Rev.0

				Use of thermal processes : Not Applicable					
Weld Layers	Process/es	Filler Metal		Current		Voltage Range	Travel Speed Range mm/min	Maximum Heat Input KJ/mm	Remark
		Class	Dia. mm	Amp Range	Type Polarity				
Root Pass	GTAW	ER- 308 L	2.0	93-94	DCSP	18-19	38.58		
Pass 1	GTAW	ER- 308 L	2.0	102-103	DCSP	18-19	64		
Pass 2	SMAW	E- 308 L	3.15	102-103	DCSP	18-19	74.53		
Pass 3	SMAW	E- 308 L	3.15	66-67	DCRP	22-23	63.66		
Pass 4	SMAW	E- 308 L	3.15	66-67	DCRP	22-23	89.55		
Pass 5	SMAW	E- 308 L	3.15	66-67	DCRP	22-23	88.23		

TENSILE TEST (QW-150)

Specimen No.	Gauge Width mm	Thickness mm	Area mm ²	Ultimate Tensile Load (KN)	Ultimate Tensile Strength N/mm ²	Type of Failure & Location	Result
T1	20.16	9.96	200.79	131.66	655.70	In WM.	Satisfactory
T2	20.18	9.92	200.18	133.80	668.38	In WM.	Satisfactory

GUIDED-BEND TEST (QW-160)

Figure No.	Type	Result
QW462.3(a)	Root Bend Test 1	Satisfactory
QW462.3(a)	Root Bend Test 2	Satisfactory
QW462.3(a)	Face Bend Test 1	Satisfactory
QW462.3(a)	Face Bend Test 2	Satisfactory

Welder Name: Mr. Ranjeet Kushwah + Mehboob Raza

Welder No. : W1+W2

Test Conducted By : VSP Testing & Calibration Laboratory , MIDC Ambad , Nashik- 422 010

Laboratory Test Report No. : E-2890 Dated : 07/01/2021

We certify that the statements in these records are that the test welds were prepared, welded, and tested in accordance with the requirement of ASME Section IX Code 2019 Edition

Manufacturer: JG ACERO INDUSTRIES PVT.LTD

PREPARED BY

APPROVED BY

REVIEWED BY

WELDING ENGINEER
SPM CONSULTANCY SERVICES



WELDING MANAGER
SPM CONSULTANCY SERVICES

CLIENT / TPI