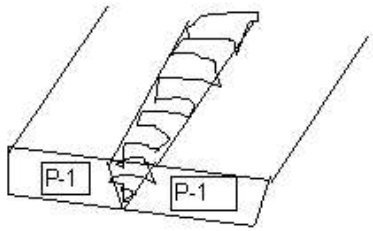
QW-483 SUGGESTED FORMAT FOR PROCEDURE QUALIFICATION RECORDS (PQR)
(See QW-200.2, Section IX, ASME Boiler and Pressure vessel Code)
Record Actual Conditions Used to Weld Test Coupon

Company Name: XYZ COMPANY
Procedure Qualification Record No.: GMAW-2 Date: 3-29-92
WPS No.: GMAW-2
Welding Process(s): GMAW SHORT CIRCUITING ARC
Types (Manual, Automatic, Semi-Auto.): SEMI-AUTO
JOINTS (QW-402)



Groove Design of Test Coupon
(For combination qualifications, the deposited weld metal thickness shall be recorded for each filler metal or process used.)

BASE METALS (QW-403)
Material Spec.: SA 516
Type or Grade: GR 70
P-No.: 1 to P-No.: 1
Thickness of Test Coupon: .450"
Diameter of Test Coupon: N/A
Other:

FILLER METALS (QW-404)
SFA Specification: 5.18
AWS Classification: ER 70 S-2
Filler Metal F No.: 6
Weld metal Analysis No.: 1
Size of Filler metal: 1/8"
Other:
Weld Metal Thickness: .450"

POSITION (QW-405)
Position of Groove: 3G
Weld Progression (Uphill, Downhill) DOWNHILL
Other:

PREHEAT (QW-406)
Preheat Temp.: 160 DEG F
Interpass temp 650 DEG
Other:

POSTWELD HEAT TREATMENT (QW-407)
Temperature: NONE
Time:
Other:

GAS (QW-408)
Percent Composition

	Gas(es)	(Mixture)	Flow Rate
Shielding:	YES	100%AR	20 CFH
Trailing:	NONE		
Backing:	NONE		

ELECTRICAL CHARACTERISTICS (QW-409)
Current: DC
Polarity: RP
Amps.: 130 Volts: 17
Tungsten Electrode Size: NA
Other:

TECHNIQUE (QW-410)
Travel Speed: 12 IPM
String orWeaveBead WEAVE
Oscillation: NONE
Multipass or Single Pass (per side): MULTIPASS
Single or Multiple Electrodes: SINGLE
Other:

QW-483 (Back)
POR No.: GMAW-2

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load Lb.	Ultimate Unit Stress psi	Type of Failure & Location
T-1	.750	.450	.337	23,000	68,249	DF-BM
T-2	.749	.449	.336	23,500	69,940	DF-WELD

Guided Bend Tests (QW-160)

Type and Figure No.	Result
FACE #1	PASS
FACE #2	PASS 1/4" CORNER CRACK - NO DEFECT
ROOT #1	PASS
ROOT #2	PASS - 1/8" CRACK

Toughness Tests (QW-170)

Specimen No.	Notch Location	Specimen Size	Test Temp.	Impact Values			Drop Weight Break (Y/N)
				Ft. Lbs.	% Shear	Mils	
1	WELD	10 MM X 10 MM	-30°F	10 FT LBS			
2	WELD	10 MM X 10 MM	-30°F	26 FT LBS			
3	WELD	10 MM X 10 MM	-30°F	15 FT LBS	N/A	N/A	N/A
4	HAZ	10 MM X 7 MM	-30°F	8 FT LBS			
5	HAZ	10 MM X 7 MM	-30°F	16 FT LBS			
6	HAZ	10 MM X 7 MM	-30°F	15 FT LBS			

Comments: TEST COUPON WAS FULLY DEOXIDIZED STEEL

Fillet Weld Test (QW-180)

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

Macro --- Results: _____

Other Tests

Type of Test: _____

Deposit Analysis: _____

Other: _____

Welder's Name: JOE BLOW JR Clock No.: 2 Stamp No.: 3

Tests conducted by: JIMS TEST LAB Laboratory Test No.: 1234

We certify that the statements 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 Code.

Manufacturer: BILLS WELDING SHOP

Date: 2-29-92 By: BILL BLOW