

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

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

JOINTS (QW-402)

Groove Design of Test Coupon

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

<p>BASE METALS (QW-403) Material Spec. _____ Type/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 _____ _____ _____</p>	<p>POSTWELD HEAT TREATMENT (QW-407) Temperature _____ Time _____ Other _____ _____ _____</p>																																																														
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%;">FILLER METALS (QW-404)</td> <td style="width:35%; text-align: center;">1</td> <td style="width:35%; text-align: center;">2</td> </tr> <tr> <td>SFA Specification _____</td> <td></td> <td></td> </tr> <tr> <td>AWS Classification _____</td> <td></td> <td></td> </tr> <tr> <td>Filler Metal F-No. _____</td> <td></td> <td></td> </tr> <tr> <td>Weld Metal Analysis A-No. _____</td> <td></td> <td></td> </tr> <tr> <td>Size of Filler Metal _____</td> <td></td> <td></td> </tr> <tr> <td>Filler Metal Product Form _____</td> <td></td> <td></td> </tr> <tr> <td>Supplemental Filler Metal _____</td> <td></td> <td></td> </tr> <tr> <td>Electrode Flux Classification _____</td> <td></td> <td></td> </tr> <tr> <td>Flux Type _____</td> <td></td> <td></td> </tr> <tr> <td>Flux Trade Name _____</td> <td></td> <td></td> </tr> <tr> <td>Weld Metal Thickness _____</td> <td></td> <td></td> </tr> <tr> <td>Other _____</td> <td></td> <td></td> </tr> </table>	FILLER METALS (QW-404)	1	2	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 _____			<p>GAS (QW-408)</p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th rowspan="2"></th> <th colspan="3" style="text-align: center;">Percent Composition</th> </tr> <tr> <th style="text-align: center;">Gas(es)</th> <th style="text-align: center;">(Mixture)</th> <th style="text-align: center;">Flow Rate</th> </tr> </thead> <tbody> <tr> <td>Shielding _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Trailing _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Backing _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Other _____</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>		Percent Composition			Gas(es)	(Mixture)	Flow Rate	Shielding _____				Trailing _____				Backing _____				Other _____			
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<p>POSITION (QW-405) Position of Groove _____ Weld Progression (Uphill, Downhill) _____ Other _____ _____</p>	<p>ELECTRICAL CHARACTERISTICS (QW-409) Current _____ Polarity _____ Amps. _____ Volts _____ Tungsten Electrode Size _____ Mode of Metal Transfer for GMAW (FCAW) _____ Heat Input _____ Other _____ _____</p>																																																														
<p>PREHEAT (QW-406) Preheat Temperature _____ Interpass Temperature _____ Other _____ _____</p>	<p>TECHNIQUE (QW-410) Travel Speed _____ String or Weave Bead _____ Oscillation _____ Multipass or Single Pass (Per Side) _____ Single or Multiple Electrodes _____ Other _____ _____ _____</p>																																																														

FORM QW-483 (Back)

Tensile Test (QW-150)

PQR No. _____

Specimen No.	Width	Thickness	Area	Ultimate Total Load	Ultimate Unit Stress, (psi or MPa)	Type of Failure and Location

Guided-Bend Tests (QW-160)

Type and Figure No.	Result

Toughness Tests (QW-170)

Specimen No.	Notch Location	Specimen Size	Test Temperature	Impact Values			Drop Weight Break (Y/N)
				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 Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name _____ Clock No. _____ Stamp No. _____

Tests Conducted by _____ Laboratory Test No. _____

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 Boiler and Pressure Vessel Code.

Organization _____

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.)