

FORM QF-483(a) SUGGESTED FORMAT FOR BUTT-FUSING PROCEDURE QUALIFICATION RECORDS (PQR)
(See QF-201.5(d), Section IX, ASME Boiler and Pressure Vessel Code)

Company Name _____
Procedure Qualification Record No. _____ Date _____
FPS No. _____
Fusing Process(es) _____

Joints (QF-402)

Pipe Surface Alignment _____

Pipe End Preparation of Test Coupon _____

Material (QF-403)

Specification _____ Classification _____
to Specification _____ Classification _____
Pipe Size (Diameter) _____
Pipe Wall Thickness _____
Cross-Sectional Area _____
Other _____

Equipment (QF-406)

Fusing Machine Manufacturer _____

Data Acquisition Used Yes No
Data Acquisition System Manufacturer _____
Hydraulic Extension Hose Length _____

Position (QF-404)

Position of Pipe _____
Other _____

Technique (QF-407)

Location Fabrication Shop Field

Thermal Conditions (QF-405)

Heater Surface Temperature _____
Fusing Interfacial Pressure _____
Drag Pressure _____
Butt-Fusing Pressure _____
Melt Bead Size _____
Heater Plate Removal Time _____
Cool-Down Time at Butt-Fusing Pressure _____
Other _____

Other

Visual Examination (QF-141)

Elevated Temperature Sustained Pressure Tests (QF-142)

Joint No.	Heater Temperature	Interfacial Pressure	Result

Joint No.	Heater Temperature	Interfacial Pressure	Result

High-Speed Tensile Impact Tests (QF-144)

Joint No.	Spec. No.	Heater Temperature	Interfacial Pressure	Type of Failure	Location of Failure

Joint No.	Spec. No.	Heater Temperature	Interfacial Pressure	Type of Failure	Location of Failure

Attach additional sheet(s) for high-speed tensile test impact test data for pipe larger than NPS 4 (DN 100).

Fusing Operator's Name _____ Identification No. _____ Stamp No. _____

Tests Conducted By _____ Laboratory Test No. _____

We certify that the statements in this record are correct and that the test joints were prepared, fused, 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.)