

**FORM QB-484 SUGGESTED FORMAT FOR A BRAZER OR BRAZING OPERATOR PERFORMANCE QUALIFICATION (BPO)**

**(See QB-301, Section IX, ASME Boiler and Pressure Vessel Code)**

Brazer's or Brazing Operator's Name \_\_\_\_\_ Identification No. \_\_\_\_\_

**Testing Variables and Ranges Qualified**

Identification of BPS Followed During Brazing of Test Coupon \_\_\_\_\_ Date Coupon Was Brazed \_\_\_\_\_

Specification of First Test Coupon Base Metal \_\_\_\_\_

Specification of Second Test Coupon Base Metal \_\_\_\_\_

Brazing Variables (QB-350)	Actual Values	Range Qualified
Brazing Process(es)	_____	_____
Type of Brazing (Manual, Semi-Automatic, Automatic, Machine)	_____	_____
Torch Brazing: Manual or Mechanical	_____	_____
Base Metal P-Number _____ to P-Number	_____	_____
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube)	_____	_____
Base Metal Thickness	_____	_____
to Base Metal Thickness	_____	_____
Joint Type (Butt, Lap, Scarf, Socket, etc.)	_____	_____
If Lap or Socket, Overlap Length	_____	_____
Joint Clearance	_____	_____
Filler Metal (SFA) Specification(s) (info. only)	_____	_____
Filler Metal Classification(s) (info. only)	_____	_____
Filler Metal F-Number	_____	_____
Filler Metal Product Form	_____	_____
Brazing Flow Positions	_____	_____

**Testing and Results**

**Visual Examination of Completed Joint (QB-141.6)** \_\_\_\_\_ **Date of Test** \_\_\_\_\_

**Mechanical Test**  Peel (QB-462.3)  Section (QB-462.4)  Tension (QB-462.1)  
 Transverse Bends [QB-462.2(a)]  Longitudinal Bends [QB-462.2(b)]

Position	Result	Position	Result	Position	Result

Mechanical Tests Conducted by \_\_\_\_\_ Company \_\_\_\_\_

Specimens Evaluated by \_\_\_\_\_ Company \_\_\_\_\_

Lab Test No. \_\_\_\_\_

We certify that the statements in this record are correct and that the test coupons were prepared, brazed, and tested in accordance with the requirements of Section IX of the ASME BOILER AND PRESSURE VESSEL CODE.

Organization \_\_\_\_\_

Certified by \_\_\_\_\_ Date \_\_\_\_\_