

**FORM QF-482(a) Suggested Format for Butt-Fusing Procedure Specifications (FPS or SFPS)**  
**(See QF-201.3, Section IX, ASME Boiler and Pressure Vessel Code)**

Company Name \_\_\_\_\_ By \_\_\_\_\_

Fusing Procedure Specification No. \_\_\_\_\_ Date \_\_\_\_\_

Revision No. \_\_\_\_\_ Date \_\_\_\_\_

FPS Qualification  By testing  SFPS If qualified by testing, supporting PQR No.(s) \_\_\_\_\_

Fusing Process Type \_\_\_\_\_

<p><b>Joints (QF-402)</b></p> <p>Joint Type _____</p> <p>Pipe End Preparation _____</p> <p>Miter Joint Angle _____</p> <p>Pipe Surface Alignment _____</p> <p>Sketches, production drawings, weld symbols, or written description should show the general arrangement of the parts to be fused. Where applicable, the details of the joint groove may be specified.</p> <p>Sketches may be attached to illustrate joint design.</p>	<p><b>Details</b></p>
<p><b>Materials (QF-403)</b></p> <p>Specification _____ Classification _____ to Specification _____ Classification _____</p> <p>Pipe Size (Diameter) _____ Pipe Wall Thickness _____ Cross-Sectional Area _____</p> <p>Other _____</p>	
<p><b>Position (QF-404)</b></p> <p>Pipe Position _____</p> <p>Other _____</p>	
<p><b>Thermal Conditions (QF-405)</b></p> <p>Heater Surface Temperature Range _____</p> <p>Fusing Interfacial Pressure Range _____</p> <p>Drag Pressure Range _____ Butt-Fusing Pressure Range _____</p> <p>Melt Bead Size Range _____ Heater Plate Removal Time Range _____</p> <p>Cool-Down Time at Butt-Fusing Pressure Range _____</p>	
<p><b>Equipment (QF-406)</b></p> <p>Fusing Machine Manufacturer _____</p> <p>Data Acquisition Used <input type="checkbox"/> Yes <input type="checkbox"/> No Data Acquisition Machine Manufacturer _____</p> <p>Hydraulic Extension Hose Length _____</p>	
<p><b>Technique (QF-407)</b></p> <p>Location <input type="checkbox"/> Fabrication Shop <input type="checkbox"/> Field</p> <p>_____</p>	