QF-482(b) SUGGESTED FORMAT FOR ELECTROFUSION FUSING PROCEDURE SPECIFICATION (FPS or MEFPS)
(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 ☐ MEFPS ☐ If qualified by testing, supporting PQR No.(s) _____

Joints (QF-402) Details

Joint Design_____

Pipe End Cut max. out-of-square_____

Maximum Fit-up Gap_____

Max. Axial Misalignment_____

Max. out-of-roundness _____

Sketches, production drawings, joint 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.

Materials (QF-403)

Fitting Specification_____Classification_____ to Pipe Specification_____Classification_____

Fitting Manufacturer_____ Pipe Size (diameter)_____ Pipe Wall Thickness_____

Thermal Conditions (QF-405)

Minimum material & fusing temperature_____°F (°C) Maximum material and fusing temperature_____°F (°C)

Nominal fusion time at minimum temp_____ Nominal fusion time at maximum temp_____

Minimum cool down time at min. temp_____ Minimum cool down time at max. temp_____

Fusion Voltage_____

Other_____

Equipment (QF-406)

Minimum Power Supply_____(KVA) Processor Manufacturer_____Model_____

Power Cord: Material_____Max. length _____ft (m) Min. Gage_____ Min. Amps_____

Saddle Clamp Type_____ ☐ N/A

Other_____

Technique (QF-407)

Pre-scrape cleaning fluid_____ Post-scrape cleaning agent _____

Scraping Device_____ Pipe marker type_____

Other_____