

**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) \_\_\_\_\_

<p>_____</p> <p align="center">Pipe Surface Alignment _____</p> <p align="center">Pipe End Preparation of Test Coupon</p>	
<p><b>Material (QF-403)</b></p> <p>Specification _____ Classification _____</p> <p>to Specification _____ Classification _____</p> <p>Pipe Size (Diameter) _____</p> <p>Pipe Wall Thickness _____</p> <p>Cross-Sectional Area _____</p> <p>Other _____</p>	<p><b>Equipment (QF-406)</b></p> <p>Fusing Machine Manufacturer _____</p> <p>_____</p> <p>Data Acquisition Used    <input type="checkbox"/> Yes    <input type="checkbox"/> No</p> <p>Data Acquisition System Manufacturer _____</p> <p>Hydraulic Extension Hose Length _____</p>
<p><b>Position (QF-404)</b></p> <p>Position of Pipe _____</p> <p>Other _____</p>	<p><b>Technique (QF-407)</b></p> <p>Location    <input type="checkbox"/> Fabrication Shop    <input type="checkbox"/> Field</p> <p>_____</p> <p>_____</p> <p>_____</p>
<p><b>Thermal Conditions (QF-405)</b></p> <p>Heater Surface Temperature _____</p> <p>Fusing Interfacial Pressure _____</p> <p>Drag Pressure _____</p> <p>Butt-Fusing Pressure _____</p> <p>Melt Bead Size _____</p> <p>Heater Plate Removal Time _____</p> <p>Cool-Down Time at Butt-Fusing Pressure _____</p> <p>Other _____</p> <p>_____</p>	<p><b>Other</b></p> <p>_____</p> <p>_____</p> <p>_____</p> <p>_____</p> <p>_____</p>

