

FORM QW-483 SUGGESTED FORMAT FOR PROCEDURE QUALIFICATION RECORDS (PQR)
(See QW-200.2, Section IX, ASME Boiler and Pressure Vessel Code)
Record Actual Variables Used to Weld Test Coupon

Organization Name _____
 Procedure Qualification Record No. _____ Date _____
 WPS No. _____
 Welding Process(es) _____
 Types (Manual, Automatic, Semi-Automatic) _____

JOINTS (QW-402)

Groove Design of Test Coupon

(For combination qualifications, the deposited weld metal thickness shall be recorded for each filler metal and process used.)

<p>BASE METALS (QW-403)</p> <p>Material Spec. _____ Type or Grade, or UNS Number _____ P-No. _____ Group No. _____ to P-No. _____ Group No. _____ Thickness of Test Coupon _____ Diameter of Test Coupon _____ Maximum Pass Thickness _____ Other _____</p>	<p>POSTWELD HEAT TREATMENT (QW-407)</p> <p>Temperature _____ Time _____ Other _____</p>																																																			
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<p>POSITION (QW-405)</p> <p>Position(s) _____ Weld Progression (Uphill, Downhill) _____ Other _____</p>	<p>TECHNIQUE (QW-410)</p> <p>Travel Speed _____ String or Weave Bead _____ Oscillation _____ Multipass or Single Pass (Per Side) _____ Single or Multiple Electrodes _____ Other _____</p>																																																			
<p>PREHEAT (QW-406)</p> <p>Preheat Temperature _____ Interpass Temperature _____ Other _____</p>																																																				

FORM QW-483 (Back)

Tensile Test (QW-150)

PQR No. _____

Specimen No.	Width	Thickness	Area	Ultimate Total Load	Ultimate Unit Stress, (psi or MPa)	Type of Failure and Location

Guided-Bend Tests (QW-160)

Type and Figure No.	Result

Toughness Tests (QW-170)

Specimen No.	Notch Location	Specimen Size	Test Temperature	Toughness Values			Drop Weight Break (Y/N)
				ft-lb or J	% Shear	Mils (in.) or mm	

Comments _____

Fillet-Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro — Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other

Welder's Name _____ Clock No. _____ Stamp No. _____

Tests Conducted by _____ Laboratory Test No. _____

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