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.)

BASE METALS (QW-403)
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

FILLER METALS (QW-404)

	1	2
SFA Specification		
AWS Classification		
Filler Metal F-No.		
Weld Metal Analysis A-No.		
Size of Filler Metal		
Filler Metal Product Form		
Supplemental Filler Metal		
Electrode Flux Classification		
Flux Type		
Flux Trade Name		
Weld Metal Thickness		
Other		

POSITION (QW-405)
Position(s) _____
Weld Progression (Uphill, Downhill) _____
Other

PREHEAT (QW-406)
Preheat Temperature _____
Interpass Temperature _____
Other

POSTWELD HEAT TREATMENT (QW-407)
Temperature _____
Time _____
Other

GAS (QW-408)

	Gas(es)	Percent Composition (Mixture)	Flow Rate
Shielding			
Trailing			
Backing			
Other			

ELECTRICAL CHARACTERISTICS (QW-409)
Current _____
Polarity _____
Amps. _____ Volts _____
Waveform Control _____
Power or Energy _____
Arc Time _____
Weld Bead Length _____
Tungsten Electrode Size _____
Mode of Metal Transfer for GMAW (FCAW) _____
Heat Input _____
Other

TECHNIQUE (QW-410)
Travel Speed _____
String or Weave Bead _____
Oscillation _____
Multipass or Single Pass (Per Side) _____
Single or Multiple Electrodes _____
Other

FORM QW-483 (Back)

PQR No. _____

Tensile Test (QW-150)

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

Alternative Tension Specimen Specification (QW-462) _____

Guided-Bend Tests (QW-160)

Type and Figure No.	Result

Toughness Tests (QW-170)

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

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.)