

Form QW-483 Welding Procedure Qualification Record

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

Company 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/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 _____

POSTWELD HEAT TREATMENT (QW-407)

Temperature _____
 Time _____
 Other _____

GAS (QW-408)

Percent Composition

	Gas(es)	(Mixture)	Flow Rate
Shielding	_____	_____	_____
Trailing	_____	_____	_____
Backing	_____	_____	_____
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	_____	_____

ELECTRICAL CHARACTERISTICS (QW-409)

Current _____
 Polarity _____
 Amps. _____ Volts _____
 Tungsten Electrode Size _____
 Mode of Metal Transfer for GMAW (FCAW) _____
 Heat Input _____
 Other _____

POSITION (QW-405)

Position of Groove _____
 Weld Progression (Uphill, Downhill) _____
 Other _____

TECHNIQUE (QW-410)

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

PREHEAT (QW-406)

Preheat Temperature _____
 Interpass Temperature _____
 Other _____

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	Impact Values		Drop Weight Break (Y/N)
				ft-lb or J	% Shear	

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 _____

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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.

Manufacturer or Contractor _____

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.)

03/08