



Labour and Immigration
Mechanical and Engineering

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Brazing Procedure Qualification Records (BPQR)
(See QB-200.2, Section IX, ASME Boiler and Pressure Vessel Code)
Record of Actual Conditions Used to Braze Test Coupon

Company Name: _____
 BPS Followed During Brazing of Test Coupon: _____ PQR No.: _____
 Brazing Process(es) Used: _____ Date Coupon Was Brazed: _____
 Base Metal Specification: _____
 To Base Metal Specification: _____
 P-Number: _____ to P-Number: _____ Plate/Pip Diameter: _____
 Base Metal Thickness (in.) _____ Joint Type: _____
 Filler Metal Specification: AWS Classification: _____ F-No. _____ Product Form: _____
 Filler Metal Size: _____ Method of Applying Filler: _____
 Flux Type or Trade Name: _____ Gas Backing: _____
 Overlap Used (in.): _____ Clearance Between Parts: _____
 Position and Flow Direction: _____
 Fuel Gas: _____ Flame Type: _____
 Postblaze Heat Treatment (°F): _____ Postblaze Heat Treatment Time (hr): _____
 Cleaning Prior to Brazing: _____
 Cleaning After Brazing: _____
 Other: _____

Tensile Tests

Specimen	Width/Dia. (in.)	Thickness (in.)	Area (sq in.)	Ultimate load (lb.)	Ultimate Stress (psi)	Failure Location

Bend Tests

Type	Results	Type	Results

Peel or Section Tests

Type	Results	Type	Results

Other Tests: _____
 Brazer's Name: _____ ID No.: _____ Company: _____
 Brazing of Test Coupon Supervised by: _____ Company: _____
 Test Specimens Evaluated by: _____ Company: _____
 Laboratory Test Number: _____

We hereby certify that the statements in this record are correct and that the test welds were prepared, brazed, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Manufacturer: _____

By: _____

Date: _____