

QB-483 SUGGESTED FORMAT FOR PROCEDURE QUALIFICATION RECORDS (PQR)
(See QB-200.2, Section IX, ASME Boiler and Pressure Vessel Code)
Record 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/Pipe 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: _____

Post Heat Treatment °F _____ Postbrazing 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 _____

Brazers Name _____ ID No. _____ Company _____

Brazing of Test Coupon Supervised by: _____ Company _____

Test Specimens Evaluated by: _____ Company _____

Laboratory Test No. _____

We certify that statements made 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 _____