

**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><b>BASE METALS (QW-403)</b>                  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 _____                  _____                  _____</p>	<p><b>POSTWELD HEAT TREATMENT (QW-407)</b>                  Temperature _____                  Time _____                  Other _____                  _____                  _____</p>																																																														
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%;"><b>FILLER METALS (QW-404)</b></td> <td style="width:35%; text-align: center;">1</td> <td style="width:35%; text-align: center;">2</td> </tr> <tr> <td>SFA Specification _____</td> <td></td> <td></td> </tr> <tr> <td>AWS Classification _____</td> <td></td> <td></td> </tr> <tr> <td>Filler Metal F-No. _____</td> <td></td> <td></td> </tr> <tr> <td>Weld Metal Analysis A-No. _____</td> <td></td> <td></td> </tr> <tr> <td>Size of Filler Metal _____</td> <td></td> <td></td> </tr> <tr> <td>Filler Metal Product Form _____</td> <td></td> <td></td> </tr> <tr> <td>Supplemental Filler Metal _____</td> <td></td> <td></td> </tr> <tr> <td>Electrode Flux Classification _____</td> <td></td> <td></td> </tr> <tr> <td>Flux Type _____</td> <td></td> <td></td> </tr> <tr> <td>Flux Trade Name _____</td> <td></td> <td></td> </tr> <tr> <td>Weld Metal Thickness _____</td> <td></td> <td></td> </tr> <tr> <td>Other _____</td> <td></td> <td></td> </tr> </table>	<b>FILLER METALS (QW-404)</b>	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 _____			<p><b>GAS (QW-408)</b></p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th rowspan="2"></th> <th colspan="3" style="text-align: center;">Percent Composition</th> </tr> <tr> <th style="text-align: center;">Gas(es)</th> <th style="text-align: center;">(Mixture)</th> <th style="text-align: center;">Flow Rate</th> </tr> </thead> <tbody> <tr> <td>Shielding _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Trailing _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Backing _____</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Other _____</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>		Percent Composition			Gas(es)	(Mixture)	Flow Rate	Shielding _____				Trailing _____				Backing _____				Other _____			
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<p><b>POSITION (QW-405)</b>                  Position of Groove _____                  Weld Progression (Uphill, Downhill) _____                  Other _____                  _____</p>	<p><b>ELECTRICAL CHARACTERISTICS (QW-409)</b>                  Current _____                  Polarity _____                  Amps. _____ Volts _____                  Tungsten Electrode Size _____                  Mode of Metal Transfer for GMAW (FCAW) _____                  Heat Input _____                  Other _____                  _____</p>																																																														
<p><b>PREHEAT (QW-406)</b>                  Preheat Temperature _____                  Interpass Temperature _____                  Other _____                  _____</p>	<p><b>TECHNIQUE (QW-410)</b>                  Travel Speed _____                  String or Weave Bead _____                  Oscillation _____                  Multipass or Single Pass (Per Side) _____                  Single or Multiple Electrodes _____                  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	Impact 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.)