ANNEX N AWS D1.1/D1.1M:2010

## WELDING PROCEDURE SPECIFICATION (WPS) Yes PREQUALIFIED \_ **QUALIFIED BY TESTING** or PROCEDURE QUALIFICATION RECORDS (PQR) Yes

	By				
mpany Name	Date				
elding Process(es)	Semiautomatic				
Supporting PQR No.(s)					
INT DESIGN USED					
pe:	Fillet:				
Single Double Weld Backing: Yes No No					
Backing Material:					
oot Opening Root Fac					
Groove Angle: Radius (J–U) Back Gouging: Yes No Method					
	Globular Spray DCEN Pulsed				
ASE METALS	]				
aterial Spec	•				
pe or Grade					
ickness: Groove					
ameter (Pipe)					
LER METALS					
VS Specification	r side)				
AWS Classification					
	ongitudinal				
HIELDING	_ateral				
ıx Ga	Angle				
Co	ce				
ectrode-Flux (Class) Flo					
Ga					
PREHEAT					
eheat Temp., Min					
Interpass Temp., Min Max					
erpass Temp., Min					

Pass or Weld Layer(s)		Filler Metals		Current				
	Process	Class	Diam.	Type & Polarity	Amps or Wire Feed Speed	Volts	Travel Speed	Joint Details

Form N-1 (Front)

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## Procedure Qualification Record (PQR) # \_\_\_\_\_ Test Results

## TENSILE TEST

				ISILL ILSI				
Specimen No.	Width	Thickness	Area	Ultimate Tensile Load, lb	Ultimate Unit Stress, psi	Character of Failure and Location		
			GUIDE	D BEND TEST				
Specimen No.	Type of Bend		Result	Remarks				
VISUAL INSPECTION Appearance Undercut Piping porosity Convexity Test date Witnessed by  Other Tests				FILLET WELD TEST RESULTS  Minimum size multiple pass Maximum size single pass				
Welder's name	;			Clock no	Stam	np no		
Tests conducte	ed by				Labo	oratory		
				Test number				
We, the unders tested in confor	signed, certify the mance with the	that the stateme e requirements	ents in this reco	AWS D1.1/D1.1M, ( Signed	t the test welds were) Structura (year)  Manufacturer or Con			
				Date				

Form N-1 (Back)