SAMPLE FORM FOR WELDING PROCEDURE QUALIFICATION RECORD (PQR)

Company Name _____

PQR No._____   Date_____

Welding Procedure Specification No. _____ Rev._____   Date _____

Welding Process(es) _____   Type _____   Transfer Mode (GMAW) _____
                                                     (Automatic, Manual, etc.)

JOINT (Table 6.1)

Type of Joint_____

Type of Weld_____

Backing   Yes ☐   No ☐

Backing Material Type_____

Butt Welded From:

   One Side ☐   Both Sides ☐

BASE METAL (1.4)

	Sheet Steel	Supporting Steel
Specification	_____	_____
Grade	_____	_____
Thickness Range	_____	_____
Preparation	_____	_____

COATING(S) (Table 6.2(12)

Coating Type	_____	_____
Coating Thickness	_____	_____

POSITION (Table 1.3)

Position _____

Progression (vertical position)

   Up ☐   Down ☐

FILLER METAL (Table 1.2)

Specification _____

Classification _____

GAS or GAS Mixture (1.6.6.2)

Composition _____
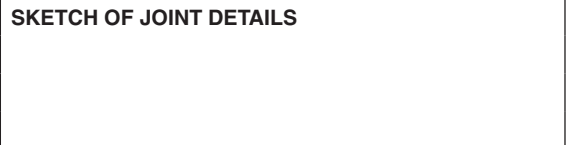
Flow Rate _____

FLUX (1.6.5.2)

Specification _____

Classification _____

PREHEAT Temperature _____

Interpass Temperature _____

POST WELD HEAT TREATMENT

Temperature _____

Time_____

TEST RESULTS (6.7)

Specimen No.	Visual Examination				Mechanical Testing			
	Appearance	Reinforcement	Cracks	Undercut	Nugget Dia.	Fusion	Cracks	Weld Throat (T_w)
1								
2								

Test Conducted By   _____
Date of Test   _____
Lab Test No.   _____

SKETCH OF JOINT DETAILS

TECHNIQUE-Welding Characteristics

Pass No.	Process	Electrode Size	Current Type & Polarity	Amperage	Voltage	Wire Feed Speed	Melting Rate	Travel Speed/Weld Time (Spot Welds)

Welder or Welding Operator Name_____

ID No._____   Date of Qualification_____

The undersigned certifies that the statements in this record are correct and that the test assemblies were prepared, welded, and tested in conformance with the requirements of Clause 6 of AWS D1.3/D1.3M (_____) *Structural Welding Code – Sheet Steel*.

Name/Title_____   Signature_____   Date_____

Form B-1