PROCEDURE QUALIFICATION RECORD (PQR)

Procedure Qualification Record no. _____ Date _____

WPS no. _____ Process(es) 1. _____ 2. _____

1. _____ 2. _____

Design Sketch

Welding Sequence Sketch

Base metals

Group no. _____ To _____

Alloy and Temper _____ To _____

Thickness _____ To _____

Filler metals

F-number _____

AWS class _____

Diameter _____

Shielding gas(es) _____

Percent composition _____

Flow rate _____

Tungsten electrode (GTAW) _____

Size _____

Type _____

Backup type _____

Alloy _____

Backgouging _____

Pass No.	Process No.	Amps	Volts	Travel Speed

Type of welding power source _____

Single or multiple electrode _____

Stringer or weave bead _____

Welding current _____
ac or dc

Polarity _____

Position of groove _____

Cleaning procedure initial

Oxide removal method _____

Degreasing agent _____

Cleaning procedure interpass _____

Smut removal _____

Dye penetrant removal _____

Preheat

Preheat temperature _____

Interpass temperature _____

Postweld heat treatment _____

Original temper _____

Final temper _____

Temperature _____

Time _____

Quench _____

Form E(b)