

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 _____
 Polarity _____ ac or dc
 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 _____

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GROOVE WELD TEST

Specimen No.	Width	Thickness	Area	Ultimate Tensile Load, lb	Ultimate Unit Stress, psi	Character of Failure and Location

GUIDED BEND TEST

Type of Bend	Bend Jig Fig. No.	Result	Type of Bend	Bend Jig Fig. No.	Results

Visual examination _____ Pass _____ Fail _____
 Type and character of failure _____

FILLET WELD TEST

Fracture test _____ Pass or fail
 Root fusion _____ Yes or no
 Macro test: Weld size and contour _____ Sat. or Unsat.
 Penetration _____ Sat. or Unsat.
 Welder's name _____ Clock no. _____ Stamp no. _____
 Tests conducted by: _____ Laboratory
 Test number _____ Per: _____

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 Clause 4, AWS D1.2/D1.2M, *Structural Welding Code—Aluminum*.

Signed _____
 Manufacturer
 Date _____ By _____
 Title _____