

PROCEDURE QUALIFICATION RECORD (PQR) FOR STUD WELDING APPLICATIONS

Procedure Qualification Record No. _____ Date _____

WPS No. _____ Process _____

Machine Settings

Power Supply Make _____

Model No. _____

Stud Gun Model _____

Timer Range Setting _____

Current/Polarity _____

Capacitance or Power Tap Setting _____

Amperage Range Setting _____

Stud-to-work Distance _____

Lift Setting _____

Cable Size _____ Length _____

Other _____

Base Metals

M-No. _____ Specification _____

Thickness _____ to _____

Alloy and Temper _____

Pipe or Tube Diameter _____

Alloy and Temper _____

Ferrules

Ferrule Material _____

Ferrule Specification _____

Ferrule Description _____

Cleaning

Initial Oxide Cleaning _____

Initial Oil & Dirt Cleaning _____

Stud Base Sketch



Stud Materials

F-No. _____ Specification _____

Stud Diameter _____

Other _____

Shielding Gas

Shielding Gas(es) _____

Percent Composition _____

Flow Rate _____

Other _____

Other

Welding Position _____

Welding Agent _____

Ferrule Description _____

Test Results	Visual Acceptance	Bend Test	Tension Test Option No. 1	Tension Test Option No. 2
Stud No. 1	_____	_____	_____	_____
Stud No. 2	_____	_____	_____	_____
Stud No. 3	_____	_____	_____	_____
Stud No. 4	_____	_____	_____	_____
Stud No. 5	_____	_____	_____	_____
Stud No. 6	_____	_____	_____	_____
Stud No. 7	_____	_____	_____	_____
Stud No. 8	_____	_____	_____	_____
Stud No. 9	_____	_____	_____	_____
Stud No. 10	_____	_____	_____	_____

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

Signed _____

(Manufacturer)

By _____

Date _____

Title _____

Form E(e)