

## Sample Procedure Qualification Record (PQR) Form

Procedure Qualification Record (PQR) No. \_\_\_\_\_

Contractor \_\_\_\_\_  
 Authorized by \_\_\_\_\_ Revision No. \_\_\_\_\_  
 Welder \_\_\_\_\_ Test Date \_\_\_\_\_  
 Welding Process:  FCAW-G  FCAW-S  GMAW  SMAW  GTAW

**PQR JOINT TYPE**

Direct Butt  Indirect Butt  T-Joint

Test Assembly:  Figure 8.5(A)  Figure 8.5(B)  Figure 8.5(C)

Position \_\_\_\_\_ Groove Type \_\_\_\_\_  Single Bevel  Double Bevel

Root Opening \_\_\_\_\_ Root Face \_\_\_\_\_ Groove Angle \_\_\_\_\_

Backing:  Yes  No Backing Type \_\_\_\_\_

Backgouging:  Yes  No Backgouging Method \_\_\_\_\_

Technique:  Stringers  Weave

**ELECTRICAL CHARACTERISTICS**

Current:  AC  DCEP  DCEN

Transfer Mode (GMAW):  Short circuiting  Globular  Spray

**BASE METAL**

Material Specification \_\_\_\_\_ Grade \_\_\_\_\_

welded to Material Specification \_\_\_\_\_ Grade \_\_\_\_\_

Carbon Equivalent (Bar) \_\_\_\_\_ Bar size \_\_\_\_\_

Coated Bar:  Yes  No Type of Coating \_\_\_\_\_

**FILLER METAL**

AWS Specification \_\_\_\_\_ AWS Classification \_\_\_\_\_

Describe filler metal (if not covered by AWS specification) \_\_\_\_\_

**SHIELDING**

Gas:  Single  Mixture Composition \_\_\_\_\_ Flow rate \_\_\_\_\_

**PREHEAT/INTERPASS**

Preheat/Interpass Temperature (Min) \_\_\_\_\_

Interpass Temperature (Max) \_\_\_\_\_

**WELDING PARAMETERS**

Pass Number	Electrode Diameter	Current					Travel Speed (ipm)	Joint Detail
		Type	Amperage	WFS ipm [mm/min.]	Volts	Electrical Stickout		

Note: Attach additional sheets as required for detailing each pass.

## Sample Procedure Qualification Record (PQR) Form

Continuation of Procedure Qualification Record (PQR) No. \_\_\_\_\_

### TEST RESULTS

**VISUAL EXAMINATION**

Test Assembly Number One

Pass  Fail (AWS D1.4, Subclause 6.4)

Comments \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Test Assembly Number Two

Pass  Fail (AWS D1.4, Subclause 6.4)

Comments \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

**TENSILE TEST**

Test Assembly Number One

Pass  Fail (AWS D1.4, Subclause 8.3.7.2)

Test Assembly Number Two

Pass  Fail (AWS D1.4, Subclause 8.3.7.2)

Specimen No.	Width	Thickness	Area	Ultimate Tensile Load (lbs)	Ultimate Unit Stress (psi)	Character of Failure and Location

**MACROETCH TEST**

Test Assembly Number One

Pass  Fail (AWS D1.4, Subclause 8.3.7.3)

Test Assembly Number Two

Pass  Fail (AWS D1.4, Subclause 8.3.7.3)

Specimen No.	Results	Remarks

Welder's Name \_\_\_\_\_ Clock No. \_\_\_\_\_ Stamp No. \_\_\_\_\_

Test conducted by \_\_\_\_\_ (Laboratory)

Test Number \_\_\_\_\_

Per \_\_\_\_\_

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in accordance with the requirements of AWS D1.4/D1.4M:2018, *Structural Welding Code—Steel Reinforcing Bars*.

Manufacturer or Contractor \_\_\_\_\_

Authorized by \_\_\_\_\_ Date \_\_\_\_\_