

ESW-NG PROCEDURE QUALIFICATION RECORD	Document No.: _____
	Issue Date: _____ Rev. _____
	Page No.: _____
	Prepared by: _____
	Approved: _____

Date:	WPS No.:	PQR NO.:
Specification/Code:		Material Specification:
Welding Process:	ESW-NG	Welding/Machine: MECHANIZED—AUTOMATIC
Welding Operator:		Welding Operator ID:
Material Thickness:		Thickness Qualified:
Filler Metal Specification:		Filler Metal Classification:
Filler Metal Manufacturer:		Trade Name:
Test Plate Heat Number:		Test Plate Producer:

Single/Multiple Pass:	SINGLE	Preheat Temperature: NO PREHEAT REQUIREMENT
Welding Current:		Postheat Requirements: NONE
Polarity:		Interpass Temperature: N/A
Root Treatment:		

Preweld Flux Dump:	Flux Type:
Initial Flux Feed:	Current:
In-Weld Flux Feed:	Voltage:
Vertical Rate of Rise (in weld):	Wire Feed Rate:
Electrode Diameter:	Number of Electrodes:
Sealing Material for Slag Run-Out:	

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Form N-9—ESW-NG Procedure Qualification Record

COOLING SHOES			WELD JOINT DETAIL		CONSUMABLE GUIDE	
Shoe Material:			Welding Position: VERTICAL		Guide Material:	
A:	B:	C:	Progression: UPWARD		A:	B:

NDE TESTING RESULTS (ACCEPTANCE PER AWS D1.5M/D1.5, 8.26.2.1 [for RT], 8.26.3.1—Table 8.4 [for UT])	
RT Testing Performed by:	Technician:
Test Report Number:	Results:
UT Testing Performed by:	Technician:
Test Report Number:	Results:

MACROETCH/VISUAL INSPECTION RESULTS (ACCEPTANCE PER AWS D1.5M/D1.5, 7.19.2.1, 8.26.1)		
Performed by:	No. of Samples:	Cracks:
Technician:	Complete Fusion:	Undercut:
Test Report Number:	Underfill:	Porosity:

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Form N-9 (Continued)—ESW-NG Procedure Qualification Record

MECHANICAL TESTING RESULTS			
CVN TESTS (Rpt #:	)	Prepared Per: AWS D1.5M/D1.5, Figs. 7.13 and 7.15	Acceptance Per: AWS D1.5M/D1.5, Table 7.3
		WELD METAL	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		Test Temperature:	
		Average: ft·lb	
		Req'd.: 20 ft·lb @ -20 °C [27 J @ 0 °F]	
		Result:	
All Weld Metal Tensile (Rpt #:	)	Prepared Per: AWS D1.5M/D1.5, Fig. 7.9	Acceptance Per: AWS D1.5M/D1.5, Table 7.3
PARAMETER	TEST VALUE	REQUIREMENT	TEST RESULT
Tensile Strength:		70 ksi, min.	
Yield Strength:		50 ksi, min.	
Elongation:		22%, min.	

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Reduced Sect. Tensile (Rpt #:)		Prepared Per: AWS D1.5M/D1.5, Fig. 7.10		Acceptance Per: AWS D1.5M/D1.5, Table 7.3	
SAMPLE REF.	SAMPLE SIZE	TEST VALUE	REQUIREMENT	TEST RESULT	

SIDE BEND TEST (Rpt #:)		Prepared Per: AWS D1.5M/D1.5, Fig. 7.11		Acceptance Per: AWS D1.5M/D1.5, 7.19.1	
Test Ref.:	Result:	Test Ref.:	Result:	Test Ref.:	Result:
Test Ref.:	Result:	Test Ref.:	Result:	Test Ref.:	Result:

Authorized by:	Witnessed by:	Approval:

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