

**STUD WELDING PROCEDURE SPECIFICATION (WPS) Yes**   
**STUD WELDING PROCEDURE QUALIFICATION RECORD (PQR) Yes**   
**STUD WELDING OPERATOR PERFORMANCE QUALIFICATION RECORD Yes**   
**PREPRODUCTION TESTING FORM Yes**

Company name \_\_\_\_\_  
 Operator name \_\_\_\_\_  
 Test number \_\_\_\_\_  
 Weld stud material \_\_\_\_\_  
 Weld stud size and PN#/Manufacturer \_\_\_\_\_

**Base Material**

Specification \_\_\_\_\_  
 Alloy and temper \_\_\_\_\_  
 Surface condition HR  CR   
 Coating \_\_\_\_\_  
 Cleaning method \_\_\_\_\_  
 Decking gage \_\_\_\_\_

**Shape of Base Material**

Flat  Round  Tube   
 Angle  Inside  Outside  Inside radius   
 Thickness \_\_\_\_\_

**Ferrule**

Part No./Manufacturer \_\_\_\_\_  
 Ferrule description \_\_\_\_\_

**Equipment Data**

**Application Settings, Current, and Time Settings**

Make \_\_\_\_\_ Model \_\_\_\_\_  
 Stud gun: Make \_\_\_\_\_ Model \_\_\_\_\_  
 Weld time (seconds) \_\_\_\_\_  
 Current (amperage) \_\_\_\_\_  
 Polarity: DCEN \_\_\_\_\_ DCEP \_\_\_\_\_  
 Lift \_\_\_\_\_  
 Plunge (protrusion) \_\_\_\_\_  
 Weld cable size \_\_\_\_\_ Length \_\_\_\_\_  
 Number of grounds (workpiece leads) \_\_\_\_\_

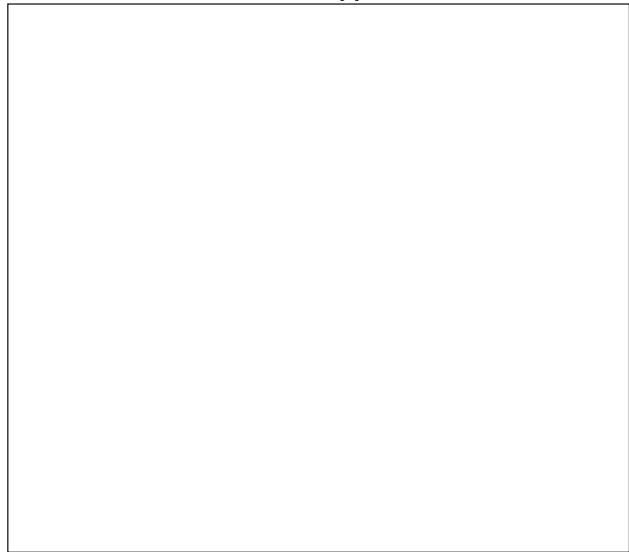
**Welding Position**

Flat (Down hand)  Horizontal (Side hand)  Angular—degrees from normal  Overhead

**Shielding Gas**

Shielding gas(es)/Composition \_\_\_\_\_  
 Flow rate \_\_\_\_\_

**Stud Base Sketch/Application Detail**



**WELD TEST RESULTS**

Stud No.	Visual Acceptance	Option #1 Bend Test	Option #2 Tension Test	Option #3 Torque Test*
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				

\* Note: Torque test optional for threaded fasteners only.

Mechanical tests conducted by \_\_\_\_\_ Date \_\_\_\_\_  
 (Company)

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 9 of AWS D1.6/D1.6M, (\_\_\_\_\_) *Structural Welding Code—Stainless Steel*.  
 (year)

Signed by \_\_\_\_\_ Title \_\_\_\_\_ Date \_\_\_\_\_  
 (Contractor/Applicator/Other)