

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) _____

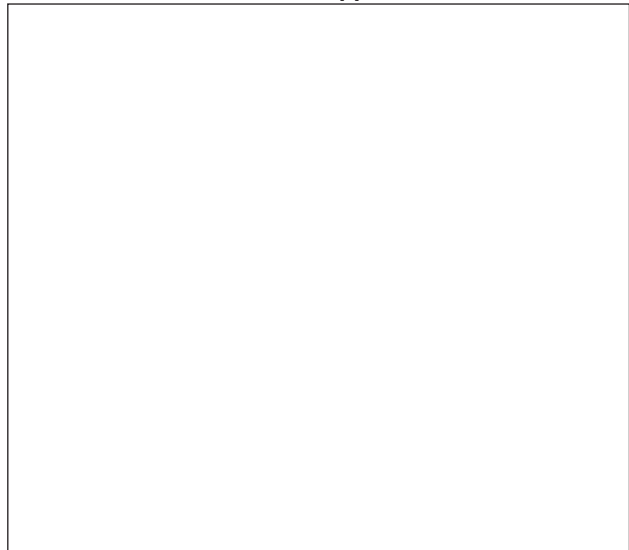
Welding Position

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)