PROCEDURE QUALIFICATION RECORD (PQR) (For Aluminum and Aluminum Alloys)

Procedure qualification record no.			Date				
WPS no Processes(es)		1	2				
		1		:	2		
	De siene skatak			14/-1-1		14-1-	
	Design sketch			Weldi	ng sequenc	e sketch	
Base metals	to		Pass	Process			Travel
			No.	No.	Amps	Volts	Speed
	to to						
	10						
Filler metals							
	ion						
			Type of v	velding powe	r source		
Tungsten electroc	les (STAW)						
			Single or	r multiple elec	ctrode		
Туре			Stringer	or weave bea	ad		
Backup type			Welding	current			
			Polarity _			AC or DC	
Backgouging			Position	of groove			
Cleaning proced	lure initial		Preheat				
Oxide removal me	ethod		Preheat	temperature			
Degreasing agent	t		Interpase	s temperature	e		
Cleaning proced	lure interpass						
Smut remover		Postweld heat treatment					
Dye penetrant removal		Original temper					
			Final terr	nper			
			Tempera	ture			
			Time				
Form D-12A			Quench_				

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GROOVE WELD TEST

Specimen No.	Width	Thickness	Area	Ultimate Tensile Load, lb	Ultimate Unit Stress, psi	Character of Failure and Location

GUIDED BEND TEST

Type of Bend	Bend Jig Figure No.	Result	Type of Bend	Bend Jig Figure No.	Result

Visual examination Pass Fail

Type and character of failure_____

FILLET WELD TEST

Fracture test Deass Fail	Root fusion 🦳 Yes 🗌 No	
Macro test: Weld size and contour 🗌 Sat. 🗌 Unsat.	Penetration 🗌 Sat. 🗌 Unsat.	
Welder's name	Clock no Stamp no	
Tests conducted by		_ Laboratory
Test number	Per	

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 AWS D15.1: (______), Railroad Welding Specification for Cars and Locomotives. (year)

	Signed
	Manufacturer
Date	Ву
Form D-12B	Title
FUIII D-12D	