

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

Procedure qualification record no. _____ Date _____

WPS no. _____ Processes(es) 1. _____ 2. _____

1. _____ 2. _____

Design sketch

Welding sequence sketch

Base metals

Group no. _____ to _____

Alloy and temper _____ to _____

Thickness _____ to _____

Filler metals

F-number _____

AWS class _____

Diameter _____

Shielding gas(es) _____

Percent composition _____

Flow rate _____

Tungsten electrodes (STAW) _____

Size _____

Type _____

Backup type _____

Alloy _____

Backgouging _____

Pass No.	Process No.	Amps	Volts	Travel Speed

Type of welding power source _____

Single or multiple electrode _____

Stringer or weave bead _____

Welding current _____

Polarity _____ AC or DC

Position of groove _____

Cleaning procedure initial

Oxide removal method _____

Degreasing agent _____

Cleaning procedure interpass

Smut remover _____

Dye penetrant removal _____

Preheat

Preheat temperature _____

Interpass temperature _____

Postweld heat treatment

Original temper _____

Final temper _____

Temperature _____

Time _____

Quench _____

