

**SAMPLE FORM FOR WELDING PROCEDURE QUALIFICATION TEST RECORD (PQR)  
(For Carbon, Low Alloy, and Stainless Steel Sheet Metal)**

Company name \_\_\_\_\_  
 Procedure qualification test record no. \_\_\_\_\_ Date \_\_\_\_\_  
 Welding procedure specification no. \_\_\_\_\_ Rev. \_\_\_\_\_ Date \_\_\_\_\_  
 Welding process(es) \_\_\_\_\_ Type \_\_\_\_\_  
 (Automatic, manual, etc.)  
 Mode of transfer for GMAW \_\_\_\_\_  
 (Short circuiting, spray, etc.)

**JOINTS**

Type of welded joint(s) \_\_\_\_\_  
 \_\_\_\_\_  
 Backing  Yes  No  
 Backing material type \_\_\_\_\_  
 Groove welded from:  
 One side \_\_\_\_\_ Both sides \_\_\_\_\_

**BASE METAL**

Material specification type and grade:  
 Sheet steel \_\_\_\_\_ to \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Support steel \_\_\_\_\_ to \_\_\_\_\_  
 Thickness \_\_\_\_\_

Base metal preparation \_\_\_\_\_

**VISUAL EXAMINATION RESULTS**

Specimen 1 \_\_\_\_\_  
 Specimen 2 \_\_\_\_\_  
 Diameter of arc spot nugget \_\_\_\_\_  
 Test conducted by \_\_\_\_\_  
 per \_\_\_\_\_  
 Lab test no. \_\_\_\_\_  
 Date of test \_\_\_\_\_

**POSITIONS**

Position of groove \_\_\_\_\_  
 Position of fillet \_\_\_\_\_  
 Progression \_\_\_\_\_

**GAS**

Shielding gas \_\_\_\_\_ Flow rate \_\_\_\_\_  
 Percent mixture \_\_\_\_\_

**FLUX**

Filler metal (Table 5.1):  
 Specification \_\_\_\_\_  
 Classification \_\_\_\_\_

**COATING(S)**

Type \_\_\_\_\_  
 Thickness \_\_\_\_\_

Sketch of Joint Details

**TECHNIQUE**

Pass No.	Electrode Size	Electrical Characteristics		Travel Speed	Melting Rate	Wire Feed Speed
		Amperes	Volts			

Welder or welding operator name \_\_\_\_\_  
 Identification no. \_\_\_\_\_ Date of qualification \_\_\_\_\_  
 Welder's social security no. \_\_\_\_\_

The undersigned certifies 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)

Authorized by \_\_\_\_\_ Date \_\_\_\_\_