# SAMPLE PROCEDURE QUALIFICATION RECORD (PQR)

(SMAW, GMAW, GTAW, FCAW, OFW, PAW)

Company Name			PQ	R No	D.			Rev. N	lo.	Date
BASE METALS Product Form	Specific	cation (Type or	Grade)		M-No.	Group-No.	Thick.	Size	Sch.	Dia.
Product Form	•		/							
Welded To										
Backing Material										
Other										
							1			
JOINT DETAILS					JOIN	T DETAILS (	Sketch)			
Groove Type										
Groove Angle										
Root Opening				_						
Root Face										
Backgouging										
Method										
POSTWELD HEAT TREATMENT					Ske	tches, welding	symbols, o	r written o	descriptio	n should
Temperature					shc	w the actual a	rrangement	of the tes	st coupon	welded.
Time at Temperature					Wher	e applicable, th	ne root detai	Is of the v	weld groo	ve may be
Other							specifi	ed.		
				-						
PROCEDURE	T	I		1		T	1		,	
Weld Layer(s) / Pass(es)										
Process										
Type (Manual., Mechanized, etc.)										
Preheat Temperature										
Interpass Temperature										
Filler Metal (AWS Spec.)										
AWS Classification										
F-number / A-number										
Nominal Composition										
Manufacturer/Trade Name								-		
Size or Diameter										
Deposited Thickness				-				-		
Maximum Pass Thickness				-				-		
Position				-				-		
Vortical Progression										
Shielding Coo Ormana (OTAM)								-		
Elow Poto (CTAW)								-		
Iralling Gas Compos. (GTAW)								_		
Backing Gas Compos. (GTAW)										
FIOW RATE (GTAW)				<u> </u>				_		
Electrical Characteristics				<u> </u>						
Electrode Diameter (GTAW)				<u> </u>						
Current Type & Polarity				<u> </u>						
Amps										
Volts										
Cold or Hot Wire Feed (GTAW)										
Travel Speed										
Maximum Heat Input										
Technique				1				-		
Cup or Nozzle Size (GTAW)										
Stringer or Weave										
Multi or Single Pass (per side)				1		1				
Oscillation (GTAW Mech./Auto.)				1						
Traverse Length				1		1				
Traverse Speed				1		1				
Dwell Time				1		1				
Peening				1						
Interpass Cleaning				+		+				
	1	1	I	I		I	I			

Figure <u>G.2</u>—Example of a Procedure Qualification Record

## SAMPLE PQR (Test Results - Page 2) (SMAW, GMAW, GTAW, FCAW, OFW, PAW)

			PQR No.		<u> </u>	Rev. No.	
TEST	S						
		Clause / Figu	ıre(s)	Acceptance			
No.	Type of Tests	Referenc	e	Criteria	Result	Remarks	

### TENSILE TEST DETAILS

Specimen Number	Width	Thickness	Area	Ultimate Tensile Load	Ultimate Unit Stress	Type of Failure and Location

#### FRACTURE TOUGHNESS TEST DETAILS

Specimen Number	Notch Location	Notch Type	Specimen Size	Test Temperature	Absorbed Energy	Percent Shear	Lateral Expansion	Other

### CERTIFICATION

Welder's Name	ID number	Stamp Number		Te
			ΙΓ	L
			ΙΓ	Т
			1	F

Tests Conducted by	
Laboratory	
Test number	
File number	

We, the undersigned, 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 D17.1/D17.1M (\_\_\_\_\_) Specification for Fusion Welding for Aerospace Applications. Year

Title:	
Name:	Signature
Date:	Junit

# Figure G.2 (Continued)—Example of a Procedure Qualification Record