

SAMPLE PROCEDURE QUALIFICATION RECORD (PQR)
(SMAW, GMAW, GTAW, FCAW, OFW, PAW)

Company Name	PQR No.	Rev. No.	Date
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BASE METALS	Product Form	Specification (Type or Grade)	M-No.	Group-No.	Thick.	Size	Sch.	Dia.
Product Form								
Welded To								
Backing Material								
Other								

JOINT DETAILS	
Groove Type	
Groove Angle	
Root Opening	
Root Face	
Backgouging	
Method	

JOINT DETAILS (Sketch)
<p>Sketches, welding symbols, or written description should show the actual arrangement of the test coupon welded. Where applicable, the root details of the weld groove may be specified.</p>

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE									
Weld Layer(s) / Pass(es)									
Process									
Type (<i>Manual., Mechanized, etc.</i>)									
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									
Vertical Progression									
Shielding Gas Compos. (GTAW)									
Flow Rate (GTAW)									
Trailing Gas Compos. (GTAW)									
Flow Rate (GTAW)									
Backing Gas Compos. (GTAW)									
Flow Rate (GTAW)									
Electrical Characteristics									
Electrode Diameter (GTAW)	---	---	---	---	---	---	---	---	---
Current Type & Polarity									
Amps									
Volts									
Cold or Hot Wire Feed (GTAW)									
Travel Speed									
Maximum Heat Input									
Technique									
Cup or Nozzle Size (GTAW)	---	---	---	---	---	---	---	---	---
Stringer or Weave									
Multi or Single Pass (per side)									
Oscillation (GTAW Mech./Auto.)									
Traverse Length									
Traverse Speed									
Dwell Time									
Peening									
Interpass Cleaning									
Other									

Figure G.2—Example of a Procedure Qualification Record

