

<b>ESW-NG PROCEDURE QUALIFICATION RECORD</b>	Document No.: _____ Issue Date: _____ Rev. _____ Page No.: _____ Prepared by: _____ Approved: _____
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Date:	WPS No.:	PQR NO.:
Specification/Code:	Material Specification:	
Welding Process:            ESW-NG	Welding/Machine:        MECHANIZED—AUTOMATIC	
Welding Operator:	Welding Operator ID:	
Material Thickness:	Thickness Qualified:	
Filler Metal Specification:	Filler Metal Classification:	
Filler Metal Manufacturer:	Trade Name:	
Test Plate Heat Number:	Test Plate Producer:	

Single/Multiple Pass:        SINGLE	Preheat Temperature: NO PREHEAT REQUIREMENT
Welding Current:	Postheat Requirements:        NONE
Polarity:	Interpass Temperature:        N/A
Root Treatment:	

Preweld Flux Dump:	Flux Type:
Initial Flux Feed:	Current:
In-Weld Flux Feed:	Voltage:
Vertical Rate of Rise (in weld):	Wire Feed Rate:
Electrode Diameter:	Number of Electrodes:
Sealing Material for Slag Run-Out:	

Form N-8

**Form N-8—ESW-NG Procedure Qualification Record**

COOLING SHOES			WELD JOINT DETAIL		CONSUMABLE GUIDE	
Shoe Material:			Welding Position: VERTICAL		Guide Material:	
A:	B:	C:	Progression: UPWARD		A:	B:

NDE TESTING RESULTS (ACCEPTANCE PER AWS D1.5, 8.26.2.1 [for RT], 8.26.3.1—Table 8.4 [for UT])	
RT Testing Performed by:	Technician:
Test Report Number:	Results:
UT Testing Performed by:	Technician:
Test Report Number:	Results:

MACROETCH/VISUAL INSPECTION RESULTS (ACCEPTANCE PER AWS D1.5, 7.19.2.1, 8.26.1)		
Performed by:	No. of Samples:	Cracks:
Technician:	Complete Fusion:	Undercut:
Test Report Number:	Underfill:	Porosity:

Form N-8

### Form N-8 (Continued)—ESW-NG Procedure Qualification Record

<b>MECHANICAL TESTING RESULTS</b>			
<b>CVN TESTS (Rpt #:            ) )</b>	Prepared Per: AWS D1.5, Fig. <u>7.13</u>		Acceptance Per: AWS D1.5, Table <u>7.3</u>
<b>WELD METAL</b>			
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
		ft·lb	
	Test Temperature:		
	Average:	ft·lb	
	Req'd.: 20 ft·lb @ -20 °C [27 J @ 0 °F]		
	Result:		
<hr/>			
<b>All Weld Metal Tensile (Rpt #:            ) )</b>	Prepared Per: AWS D1.5, Fig. <u>7.9</u>		Acceptance Per: AWS D1.5, Table <u>7.3</u>
<b>PARAMETER</b>	<b>TEST VALUE</b>	<b>REQUIREMENT</b>	<b>TEST RESULT</b>
Tensile Strength:		70 ksi, min.	
Yield Strength:		50 ksi, min.	
Elongation:		22%, min.	

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**Form N-8 (Continued)—ESW-NG Procedure Qualification Record**

<b>Reduced Sect. Tensile (Rpt #: )</b>		Prepared Per: AWS D1.5, Fig. <u>7.10</u>		Acceptance Per: AWS D1.5, Table <u>7.3</u>	
SAMPLE REF.	SAMPLE SIZE	TEST VALUE	REQUIREMENT	TEST RESULT	

<b>SIDE BEND TEST (Rpt #: )</b>		Prepared Per: AWS D1.5, Fig. <u>7.11</u>		Acceptance Per: AWS D1.5, <u>7.19.1</u>	
Test Ref.:	Result:	Test Ref.:	Result:	Test Ref.:	Result:
Test Ref.:	Result:	Test Ref.:	Result:	Test Ref.:	Result:

Authorized by:	Witnessed by:	Approval:
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**Form N-8 (Continued)—ESW-NG Procedure Qualification Record**