

Blank Sample PQR Form (SAW – page 1) PROCEDURE QUALIFICATION RECORD (PQR)

Company Name	PQR No.	Rev. No.	Date
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BASE METALS	Specification	Type or Grade	AWS Group No.	Thickness	Size (NPS)	Schedule	Diameter
Base Material							
Welded To							
Backing Material							
Other							

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

JOINT DETAILS (Sketch)

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

PROCEDURE									
Weld Layer(s)									
Weld Pass(es)									
Process	SAW								
Type (<i>Semiautomatic, Mechanized, etc.</i>)									
Position									
Filler Metal (AWS Spec.)									
AWS Classification									
Electrode Diameter									
Electrode/Flux Classification									
Manufacturer/Trade Name									
Supplemental Filler Metal									
Preheat Temperature									
Interpass Temperature									
Electrical Characteristics	—	—	—	—	—	—	—	—	—
Current Type & Polarity									
Amps									
Volts									
Wire Feed Speed									
Travel Speed									
Maximum Heat Input									
Technique	—	—	—	—	—	—	—	—	—
Stringer or Weave									
Multi or Single Pass (per side)									
Number of Electrodes									
Longitudinal Spacing of Arcs									
Lateral Spacing of Arcs									
Angle of Parallel Electrodes									
Angle of Electrode (Mech./Auto.)									
Normal To Direction of Travel									
Oscillation (<i>Mechanized/Automatic</i>)									
Traverse Length									
Traverse Speed									
Dwell Time									
Peening									
Interpass Cleaning									
Other									

