

Sample PQR Form (GTAW & SMAW – 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								
Type (<i>Manual, Mechanized, etc.</i>)								
Position								
Vertical Progression								
Filler Metal (AWS Spec.)								
AWS Classification								
Diameter								
Manufacturer/Trade Name								
Shielding Gas Compos. (GTAW)								
Flow Rate (GTAW)								
Nozzle Size (GTAW)								
Preheat Temperature								
Interpass Temperature								
Electrical Characteristics	—	—	—	—	—	—	—	—
Electrode Diameter (GTAW)								
Current Type & Polarity								
Amps								
Volts								
Cold or Hot Wire Feed (GTAW)								
Travel Speed								
Maximum Heat Input								
Technique	—	—	—	—	—	—	—	—
Stringer or Weave								
Multi or Single Pass (per side)								
Oscillation (GTAW Mech./Auto.)								
Traverse Length								
Traverse Speed								
Dwell Time								
Peening								
Interpass Cleaning								
Other								

**Sample PQR Form (Test Results – page 2)
PROCEDURE QUALIFICATION RECORD (PQR) TEST RESULTS**

PQR No. _____ Rev. No. _____

TESTS

✓	Type of Tests	Clause/Figure(s) Reference	Acceptance Criteria	Result	Remarks
	Visual Inspection	4.9.1	4.9.1		
	Radiographic Examination	4.9.2.1	4.9.2.2		
	Ultrasonic Testing	4.9.2.1	4.9.2.2		
	2 Transverse Root Bends	4.9.3.1/Fig. 4.8	4.9.3.3		
	2 Transverse Face Bends	4.9.3.1/Fig. 4.8	4.9.3.3		
	2 Longitudinal Root Bends	4.9.3.1/Fig. 4.8	4.9.3.3		
	2 Longitudinal Face Bends	4.9.3.1/Fig. 4.8	4.9.3.3		
	2 Side Bends	4.9.3.1/Fig. 4.9	4.9.3.3		
	4 Side Bends	4.9.3.1/Fig. 4.9	4.9.3.3		
	2 Tensile Tests	4.9.3.4/Fig. 4.10	4.9.3.5		
	All-Weld-Metal Tensions	4.9.3.6/Figs. 4.14 and 4.18	4.14.1.3(b)		
	3 Macroetch	4.9.4	4.9.4.1		
	4 Macroetch	4.9.4	4.9.4.1		
	CVN Tests	4 Part D/Fig. 4.28	4.30 and Table 4.14		

TENSILE TEST DETAILS

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

TOUGHNESS TEST DETAILS

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

CERTIFICATION

Welder's Name	ID Number	Stamp Number	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 Clause 4 of AWS D1.1/D1.1M, (_____) *Structural Welding Code—Steel*.
(year)

Title	
Name	Signature
Date	