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

Company Name _____ PQR No. _____ Rev. No. _____ Date _____

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	

POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

JOINT DETAILS (Sketch)

PROCEDURE								
Weld Layer(s)								
Weld Pass(es)								
Process	**SAW**							
Type *(Semiautomatic, Mechanized, etc.)*								
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 *(Mechanized/Automatic)*								
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	

Form M-1 (Back)

(See http://go.aws.org/D1forms)