

Blank 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									

Blank Sample PQR Form (GMAW & FCAW – 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	
POSTWELD HEAT TREATMENT	
Temperature	
Time at Temperature	
Other	

JOINT DETAILS (Sketch)

PROCEDURE								
Weld Layer(s)								
Weld Pass(es)								
Process								
Type (<i>Semiautomatic, Mechanized, etc.</i>)								
Position								
Vertical Progression								
Filler Metal (AWS Spec.)								
AWS Classification								
Diameter								
Manufacturer/Trade Name								
Shielding Gas Composition								
Flow Rate								
Nozzle Size								
Preheat Temperature								
Interpass Temperature								
Electrical Characteristics	—	—	—	—	—	—	—	—
Current Type & Polarity								
Transfer Mode (GMAW)								
Power Source Type (<i>cc, cv, etc.</i>)								
Amps								
Volts								
Wire Feed Speed								
Travel Speed								
Maximum Heat Input								
Technique	—	—	—	—	—	—	—	—
Stringer or Weave								
Multi or Single Pass (per side)								
Oscillation (<i>Mechanized/Automatic</i>)								
Traverse Length								
Traverse Speed								
Dwell Time								
Number of Electrodes								
Contact Tube to Work Dist.								
Peening								
Interpass Cleaning								
Other								

Blank 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	

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								

