



**Welding and NDT**  
**PROCEDURE QUALIFICATION RECORD**  
AS PER QW - 483, ASME SEC.IX, 2017 EDN.  
**(www.weldingandndt.com)**

<b>Company Name :</b> <b>PQR NO. :</b> <b>WPS NO. :</b> <b>Welding Process (es) :</b> <b>Type / Mode :</b>	<b>Qualified to Specification : ASME SECTION IX</b> <b>Date :</b>
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**JOINTS (QW- 402)**

  
  
  
  
  
  
  
  
  
  

GROOVE DESIGN OF TEST COUPON

**BASE METAL (QW-403) :**  
Material Specs :  
Type or Grade :  
P No.:  
Group :  
Thikness :  
Heat Treatment Cond:

**PWHT (QW-407) :**  
PWHT Method :  
PWHT Type :  
Temp.rise Rate :  
Soak Temp. :  
Holding Time :  
Temp. Fall Rate :

**FILLER METAL ( QW - 404 ) :**  
ASME Specification(SFA) :  
AWS Classification :  
Filler F-No. :  
Analysis A-No. :  
Filler Metal/Electrode Size :  
Brand Name :  
Weld metal thickness :

**GAS (QW-408)**

	Gas	Percent Composition Mixture	Flow rate
Shielding :			
Backing :			
Trailing :			

**POSITIONS (QW-405) :**  
Groove Position :  
Weld Progression :  
Other :

**ELECTRICAL CHARACTERISTICS (QW-409)**  
Current :  
Polarity :  
Range Amps:

**PREHEAT (QW-406) :**  
Preheat Temp (Min) :  
Interpass(Max) :  
Method :  
Other :  
  
Contact Tube - Work Distance :

**TECHNIQUE (QW-410) :**  
Travel Speed Range( min) : .  
String /Weave Bead :  
Oscillation :  
Single / Multi-pass :  
Single/Multiple Electrode :  
Contact Tube - Work Distance :

**PREPARED BY:**  
**NAME:**  
**SIGNATURE :**

**AUTHORISED BY :**  
**NAME:**  
**SIGNATURE :**



### Welding and NDT

## PROCEDURE QUALIFICATION RECORD AS PER QW483 ASME SEC. IX ,2017 EDN (www.weldingandndt.com)

#### TENSILE TEST (Transverse Weld) ( QW - 150 ) :

Specimen No.	Width (mm)	Thickness ( mm )	Area ( mm <sup>2</sup> )	UTL Kgf	Tensile Strength (Kg/mm <sup>2</sup> )	FAILURE LOCATION
TT1						
TT2						

#### GUIDED BEND TESTS ( QW - 160 ) :

Type	Number & Specification	Former Diameter(mm)	Bend angle	Results
	SB1(As Per QW462.2)			
	SB2(As Per QW462.2)			
	SB3(As Per QW462.2)			
	SB4(As Per QW462.2)			

#### TOUGHNESS TESTS ( QW - 170 )

Specimen No.	Notch Location	Notch Type	Test Temperature	Impact Values(J)	AVERAGE		Drop Weight	
					VALUE (J)		Break	No Break

#### FILLET WELD TESTS ( QW - 180 ) :

Result -  
Macro Results :

#### OTHER TESTS :

Type of Test :  
Deposit Analysis :  
Other :

REMARKS :

Welder Name (s) :

Stamp No :

REPORT NO

We certify that the statements of this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of ASME Section IX .

PREPARED BY :

NAME:

SIGNATURE :

AUTHORISED BY:

NAME:

SIGNATURE :