QW-483 SUGGESTED FORMAT FOR PROCEDURE QUALIFICATION RECORD (PQR)

(See QW-200.2, Section IX, ASME Boiler & Pressure Vessel Code)

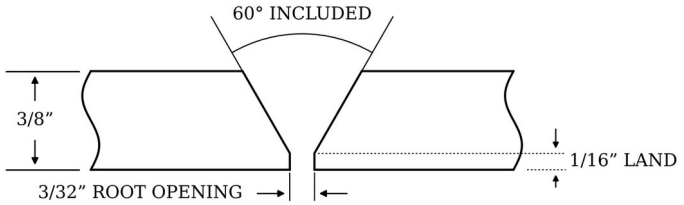
Record Actual Conditions Used to Weld Test Coupon

Company Name	EXAMPLE FAB CO.		
Procedure Qualification Record No.	PQR-001	**Date**	10/02/2026
Welding Process(es)	GTAW / SMAW	**Type(s)**	Manual / Manual

JOINTS (QW-402)

SINGLE-V GROOVE BUTT WELD

INCLUDED ANGLE: 60°
ROOT OPENING: 3/32”
LAND: 1/16”
BACKING: NONE



BASE METAL (QW-403)			
Material Specification	SA-516		
Type or Grade	GR 70		
P-No.	1	**To P-No**	1
Thickness of Coupon	3/8”		
Diameter of Coupon	PLATE		
Other			

FILLER METALS (QW-404)	
SFA Specification No.	5.18 / 5.1
AWS Classification	ER70S-2 / E7018
Filler Metal F No(s).	6 / 4
Weld Metal A No.	1 / 1
Filler Metal Size	3/32” / 1/8”
Other	SOLID / COVERED
Deposited Weld Metal	1/8” GTAW / 1/4” SMAW

POSITION (QW-405)	
Test Position	3G
Other	UPHILL PROGRESSION

PREHEAT (QW-406)	
Preheat Temperature (Minimum)	60°F (AMBIENT)
Interpass Temperature (Maximum)	410°F
Other	

POST WELD HEAT TREATMENT (QW-407)	
Temperature	NONE
Time	NONE
Other	NONE

GAS (QW-408)			
Type	**Gas(es)**	**Mix in %**	**Flow Rate**
Shielding	Argon	100%	20 CFH
Trailing	NONE	NONE	NONE
Backing	NONE	NONE	NONE

ELECTRICAL CHARACTERISTICS (QW-409)			
Current	DC		
Polarity	DCEN (GTAW) / DCEP (SMAW)		
Amperage	105–115/115–130	**Voltage**	11–12/21–23
Tungsten Electrode Size	3/32”		
Other	EWCe-2, #7 CUP		

TECHNIQUE (QW-410)	
Travel Speed	3 IPM / 5 IPM
String or Weave	STRING / STRING + WEAVE
Oscillation	NONE
Multiple or Single Pass	MULTIPLE
Multiple or Single Electrode	SINGLE
Other	

Additional Requirements: SAMPLE ONLY. Fictional company. Not a real qualification.

TQT LAB NO. TQT-EX-0001

PQR No.	PQR-001

Tensile Test (QW-150)

Specimen No.	Width/Dia.	Thickness	Area	Ultimate Total Load lbs.	Ultimate Unit Strength psi.	Type of Failure & Location
T-1	.750”	.375”	.281	21,800	77,600	Duct/Base Metal
T-2	.752”	.374”	.281	21,500	76,500	Duct/Base Metal

Guided Bend Tests (QW-160)

Type and Figure No.	Result
QW462.3a FACE BEND BENT 180˚	PASSED
QW462.3a FACE BEND BENT 180˚	PASSED
QW462.3a ROOT BEND BENT 180˚	PASSED
QW462.3a ROOT BEND BENT 180˚	PASSED (1/32” INDICATION, UNDER 1/8” LIMIT)

Toughness Tests (QW-170)

Specimen No.	Notch Location	Specimen Size	Test Temp.	Impact Values			Drop Weight Break (Y/N)
				Ft. lbs.	% Shear	Mils	

Fillet Weld Test

Results – Satisfactory:	**YES**		**NO**		Penetration into Parent Metal:	**YES**		**NO**	
Macro – Results:	NONE								

Other Tests

Type of Test:	NONE
Deposit Analysis:	NONE
Other:	VISUAL EXAMINATION: ACCEPTABLE

Welders Name	JOE WELDER	S.S. No.		Stamp No.	JW-01

Test Conducted By	Total Quality Testing	Lab No.	TQT-EX-0001
By		Date	10/02/2026

AWS QC1 CWI

We 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 Sect. IX of ASME B&PV Code.

Date	10/06/2026	Manufacturer	EXAMPLE FAB CO.
		By	J. SAMPLE

SAMPLE ONLY. Example data for fictional Example Fab Co. and welder. Not a real qualification.