

Table 4.6
PQR Supplementary Essential Variable Changes for CVN Testing Applications
Requiring WPS Requalification for SMAW, SAW, GMAW, FCAW, and GTAW

Variable	SMAW	SAW	GMAW	FCAW	GTAW
Base Metal					
1) A change in Group Number	X	X	X	X	X
2) Minimum thickness qualified is T or 5/8 in [16 mm] whichever is less, except if T is less than 1/4 in [6 mm], then the minimum thickness qualified is 1/8 in [3 mm]	X	X	X	X	X