

QW-483 PROCEDURE QUALIFICATION RECORD

PQR NO. XXX

PROCESS: FCAW (Flux cored per QW-404.23)

TYPE: SEMI-AUTOMATIC

JOINTS (QW-402):

4" x .337" (XH) pipe, single bevel to feather edge, no backup.

BASE METALS (QW-403):

Material Spec: SA312 to SA312
Type or Grade: TP304 TO TP304
P-No.: 8 to P.No.: 8
Thickness of Test Piece: .337" (4" XH Pipe)
Diameter of Test Piece: 4.5" OD

POST WELD HEAT TREAT QW-407):

Temperature: 1100 F
Time: .38 Hour Min.
Other:

FILLER METALS (QW-404):

Weld Metal A-No.: 8
Size of Filler Metal: .045"
Filler Metal F-No.: 6
SFA Spec.: 5.22
AWS Class: E308LT-1
Other: No supplemental metal or powdered filler.

GAS (QW-408):

Type of Gas(es): CO2
% Composition of Gas: 100%
Other:

POSITION (QW-405):

Position of Groove: 6G-Inclined
Weld Progression:
Other:

ELECTRICAL CHARACTERISTICS (QW-409):

Current: DC
Polarity: RP
Amps: 200 Volts: 26
Tungsten Electrode Size:
Other: Mode of Metal Transfer: Globular

PREHEAT (QW-406):

Preheat Temp.: N/A
Interpass Temp.:
Other:

TECHNIQUE (QW-410):

Travel Speed: Manual
String or Weave: String
Oscillation: None
Multi or Single Pass: Multi Pass

TENSILE TEST (QW-150):

Spec No.	Size (W x L)	X-Sectional Area	Load - #	PSI	Result
108-1	.736 x .246	.1811	16,348	90,271	Weld - OK
108-2	.734 x .265	.1945	17,372	89,316	Base - Ok

GUIDE BEND TESTS (QW-160):

Number	Type	Figure	Results:
1	Face Bend	QW-463.1(d)	180 OK
2	Face Bend	QW-463.1(d)	180 OK
3	Root Bend	QW-463.1(d)	180 OK
4	Root Bend	QW-463.1(d)	180 OK

OTHER TESTS:

WELDER'S NAME: XXXX

TESTS CONDUCTED BY: XXXX

TEST NO.: Verbal

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 Section IX of the ASME Code.

Date of Test: XX XX XX

BY: XXXX