

Sample Procedure Qualification Record (PQR) Form

Procedure Qualification Record (PQR) No. _____

Contractor _____

Authorized by _____

Revision No. _____

Welder _____

Test Date _____

Welding Process: FCAW-G FCAW-S GMAW SMAW

PQR JOINT TYPE

Direct Butt Indirect Butt T-Joint

Test Assembly: Figure 6.5(A) Figure 6.5(B) Figure 6.5(C) Figure 6.5(D)

Position _____ Groove Type _____ Single Bevel Double Bevel

Root Opening _____ Root Face _____ Groove Angle _____

Backing: Yes No Backing Type _____

Backgouging: Yes No Backgouging Method _____

Technique: Stringers Weave

ELECTRICAL CHARACTERISTICS

Current: AC DCEP DCEN

Transfer Mode (GMAW): Short-circuiting Globular Spray

BASE METAL

Material Specification _____ Grade _____

welded to Material Specification _____ Grade _____

Carbon Equivalent (Bar) _____ Bar size _____

Coated Bar: Yes No Type of Coating _____

FILLER METAL

AWS Specification _____ AWS Classification _____

Describe filler metal (if not covered by AWS specification) _____

SHIELDING

Gas: Single Mixture Composition _____ Flow rate _____

PREHEAT/INTERPASS

Preheat/Interpass Temperature (Min) _____

Interpass Temperature (Max) _____

WELDING PARAMETERS

| Pass Number | Electrode Diameter | Current | | | | | Travel Speed (ipm) | Joint Detail |
|-------------|--------------------|---------|----------|-------------------|-------|---------------------|--------------------|--------------|
| | | Type | Amperage | WFS ipm [mm/min.] | Volts | Electrical Stickout | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Note: Attach additional sheets as required for detailing each pass.

Sample Procedure Qualification Record (PQR) Form

Continuation of Procedure Qualification Record (PQR) No. _____

TEST RESULTS

VISUAL EXAMINATION

Test Assembly Number One

Pass Fail (AWS D1.4, Clause 4.4)

Comments _____

Test Assembly Number Two

Pass Fail (AWS D1.4, Clause 4.4)

Comments _____

TENSILE TEST

Test Assembly Number One

Pass Fail (AWS D1.4, Clause 6.3.7.2)

Test Assembly Number Two

Pass Fail (AWS D1.4, Clause 6.3.7.2)

| Specimen No. | Width | Thickness | Area | Ultimate Tensile Load (lbs) | Ultimate Unit Stress (psi) | Character of Failure and Location |
|--------------|-------|-----------|------|-----------------------------|----------------------------|-----------------------------------|
| | | | | | | |
| | | | | | | |

MACROETCH TEST

Test Assembly Number One

Pass Fail (AWS D1.4, Clause 6.3.7.3)

Test Assembly Number Two

Pass Fail (AWS D1.4, Clause 6.3.7.3)

| Specimen No. | Results | Remarks |
|--------------|---------|---------|
| | | |
| | | |

Welder's Name _____ Clock No. _____ Stamp No. _____

Test conducted by _____ (Laboratory)

Test Number _____

Per _____

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in accordance with the requirements of AWS D1.4/D1.4M:2011, *Structural Welding Code—Reinforcing Steel*.

Manufacturer or Contractor _____

Authorized by _____ Date _____