

WeldOffice® printout sample - ASME PQR

C-spec P.O. Box 27604, Concord, California 94527 (877) 977-7999 ASME IX Procedure Qualification Record (PQR) Created with WeldOffice® WPS Module



PQR record number	PQR-101	Revision 0	WPS record number	WPS-101	Revision 0
Date	3/30/01		Company name	C-spec	

BASE METALS (QW-403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick.	(in.) Dia.	(in.)
Welded to:	Plate	SA-53 (Type S, Gr. B)	1	1	-	-	.375	-	
	Plate	SA-53 (Type S, Gr. B)	1	1	-	-	.375	-	
and tested:	Without PWHT, With PWHT, With impacts								
Notes:									

POST WELD HEAT TREATMENT (QW-407)

Temperature (°F)	1500	Time (hrs)	8	Type	Stress relief
Heating rate (°F/hr)	200	Method	Furnace		
Cooling rate (°F/hr)	200	Method	Still air		
Notes:					

JOINTS (QW-402)

Joint design	Single-V-groove		
Backing:	None		
Retainers	None		
Groove angle (deg.)	60		
Root opening (in.)	.125		
Root face (in.)	.125		

WELDING PROCESSES

Welding process	SMAW	FCAW
Type	Manual	Semi-automatic

FILLER METALS (QW-404)

SFA specification	5.1	5.20		
AWS classification	E6010	E70T-12		
Filler metal F-number	3	6		
Weld metal A-number	1	11		
Filler metal nominal composition				
Filler metal trade name				
Filler metal size (in.)	3/32	1/8	1/8	3/32
Deposited thickness (in.)	0.125		0.250	
Maximum pass thickness (in.)	0.063		0.125	
Weld deposit chemistry				
Supplemental filler metal	-		-	
Supplemental filler metal vol. (in ²)	-		-	

POSITION (QW-405)

Position of groove	1G	1G
Weld progression	-	-

PREHEAT (QW-406)

Preheat temperature (°F)	70	200
Maximum interpass temperature (°F)	325	350

GAS (QW-408)

Shielding:	Gas type	-	75% Argon, 25% CO2
	Flow rate (cfh)	-	30
Trailing:	Gas type	-	None
	Flow rate (cfh)	-	-
Backing:	Gas type	-	None
	Flow rate (cfh)	-	-

ELECTRICAL (QW-409)

Filler metal size (in.)	3/32	1/8	1/8	3/32
Amperes	100	110 - 115	135	130 - 170
Volts	28	28 - 30	30	28
Travel speed (in./min)	6	7 - 8	7	7 - 9
Maximum heat input (kJ/in.)	28.0	29.5714	34.7143	40.8
Current/polarity	DCEP (reverse polarity)	DCEP (reverse polarity)	DCEP (reverse polarity)	DCEP (reverse polarity)
Wire feed speed (in./min)	-	-	120	138
Arc transfer mode	-	-		Spray

TECHNIQUE (QW-410)

Stringer or weave	Stringer and Weave	Stringer and Weave
Orifice/gas cup size	-	.5
C.T.W.D (in.)	-	.75
Multi/single pass	Single and Multiple passes	Single and Multiple passes
Peening	Not used	Yes
Initial/interpass cleaning	Brushing	Brushing and Grinding
Back gouging method	None	None

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C-spec

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ASME IX Procedure Qualification Record (PQR) - Test results (PWHT)

Created with WeldOffice® WPS Module

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Date	3/30/01		Company name	C-spec	

TENSILE TESTS (QW-150) Reduced section

Specimen number	Width (in.)	Thickness (in.)	Area (in ²)	Ultimate total load (lb)	Ultimate unit stress (psi)	Type of failure and location
T-1	1.5	.375	0.5625	33000	58500	Brittle-Base Metal
T-2	1.5	.375	0.5625	32000	57000	Brittle-Base Metal

Comments: 2 reduced section tension tests per QW-151.1 and QW-462.1(a)

GUIDED BEND TESTS (QW-160)

Type of test	Acceptance criteria	Result	Comments
2 transverse face bends per QW-161.2 and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-451.1
2 transverse root bends per QW-161.3 and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-451.1

Comments:

TOUGHNESS TESTS (QW-170)

Specimen number	Notch location	Notch type	Specimen size (in.) x (in.)	Test temperature (°F)	Impact values			Drop weight break
					(ft lb)	(% Shear)	(Mils)	
BM001	Base Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
BM002	Base Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
BM003	Base Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
BM004	Base Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
BM005	Base Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
HZ001	HAZ	V-notch	0.394 x 0.098	-20	125	50	45	-
HZ002	HAZ	V-notch	0.394 x 0.098	-20	125	50	45	-
HZ003	HAZ	V-notch	0.394 x 0.098	-20	125	50	45	-
HZ004	HAZ	V-notch	0.394 x 0.098	-20	125	50	45	-
HZ005	HAZ	V-notch	0.394 x 0.098	-20	125	50	45	-
WM001	Weld Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
WM002	Weld Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
WM003	Weld Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
WM004	Weld Metal	V-notch	0.394 x 0.098	-20	125	50	45	-
WM005	Weld Metal	V-notch	0.394 x 0.098	-20	125	50	45	-

Comments:

OTHER TESTS

Type of test	Acceptance criteria	Result	Comments
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 Note (8)
Radiographic examination per QW-191 and QW-302.2	QW-191.2	Acceptable	see - ASME IX - QW-142, QW-304

Comments:

CERTIFICATION

Welder's name	ID Number	Stamp number	Mechanical testing by	Nick Mossman
Rod Laver	5555	500	Laboratory test number	PQR-101
			Test file number	PQR-101
			Tests conducted by	Nick Mossman

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.

Welding Engineer

QA Manager

Name	Signature	Name	Signature
Nick Mossman		M. Bernasek	
Date		Date	
3/30/01		3/30/01	