POCEDURE QUALIFICATION RECORD
Quality Control Form

WPS NO: **DATE:**

PQR NO:
Welding process:
Types: ☐ Manual ☐ Machine ☐ Automatic ☐ Semi-Automatic

PREHEAT:
Preheat Temp (Min 'C):
Inter Pass Temp (Max 'C):

POST WELD HEAT TREATMENT:
Temperature:
Heating rate:
Cooling rate:

JOINTS

GAS (QW-408)

	Gas	Mixture	Flow Rate
Shielding:			
Trailing:			
Backing:			

BASE METALS
Material Spec:
Type or Grade:
P-No: G-No: To P-No: G-No:
Thickness of Test Coupon:
Diameter of Test Coupon:
Other: N/A

ELECTRICAL CHARACTERISTICS
Current: Polarity:
Amps:
Volts:
Tungsten Electrode:

FILLER METALS
SFA Specification:
AWS Classification:
F-No/A-No:
Trade Name/Size:
Deposit Thickness:
Other:

TECHNIQE
Travel Speed:

String or Weave Bead:
Oscillation:
Multi or Single Pass(per side):
Single or Multiple Electrodes:
Others:

POSITION
Position of groove:
Welding Progression : N/A Up hill Down hill

OTHERS TESTS

Type	Result	Remark

Note :

PREPARED BY: WELDIND ENGINEER	NAME/SIGN:	DATE:
CHECKED BY: QA/QC MANAGER	NAME/SIGN:	DATE:
APPROVED BY: COMPANY	NAME/SIGN:	DATE:

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Pass	Filler Metal		Welding Process	Current Polarity	Current (A)		Voltage (V)		Travel Speed (cm/min)	Shield Gas (I/min)	Interpass Temp('C)	Heat Input (kj/cm)	Remark
	Type	Size			Min	Max	Min	Max					

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TENSILE TEST

Identification	Thickness or Diameter(mm)	Width(mm)	Area mm^2	Yield Strength	Ultimate Load, N	Tensile Strength (N / mm^2)	Fracture Location	Elog. %	Red of Area

BEND TESTS

Type	Mandrel Diameter(mm)	Angle of Bend	Test Result

CHARPY "V" NOTCH IMPACT TESTS (Joules)

	Test Temperature:								
	Size (mm):					Lateral Expansion			
Location	WM	FL	FL+2mm						

WELD METALLOGRAPHY		Ferrite Measurement FN	

HARNESS TEST

Line	Base Metal 1	H.A.Z 1	Weld Metal	H.A.Z 2	Base Metal 2

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