

Sample Form (GMAW & FCAW)
PROCEDURE QUALIFICATION RECORD (PQR)

RED Inc.
 Company Name

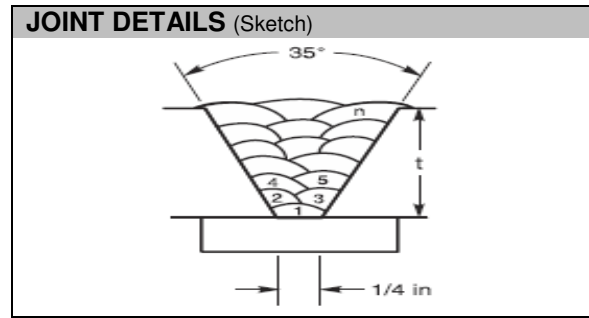
231
 PQR No.

0 **01/18/1988**
 Rev. No. Date

2010 pg 357
 Related WPS(s)

BASE METALS	Specification	Type or Grade	AWS Group No.	Thickness	Size (NPS)	Schedule	Diameter
Base Material	ASTM A131	A	I	1"	-	-	-
Welded To	ASTM A131	A	I	1"	-	-	-
Backing Material	ASTM A131	A	I				
Other							

JOINT DETAILS	
Groove Type	single V groove butt weld
Groove Angle	35° included
Root Opening	1/4"
Root Face	-
Back Gouging	none
Method	-



POSTWELD HEAT TREATMENT	
Temperature	-
Time at Temperature	-
Other	-

PROCEDURE								
Weld Layer(s)	-	-	-	-	-			
Weld Pass(es)	1	2 - 8	9 - 11	12 - 15	16			
Process	FCAW	FCAW	FCAW	FCAW	FCAW			
Type (Semi-auto./Machine/Auto.)	semi-auto.	semi-auto.	semi-auto.	semi-auto.	semi-auto.			
Position	4G	4G	4G	4G	4G			
Vertical Progression	-	-	-	-	-			
Filler Metal AWS Spec.	A5.20	A5.20	A5.20	A5.20	A5.20			
AWS Classification	E71T-1	E71T-1	E71T-1	E71T-1	E71T-1			
Diameter	0.045"	0.045"	0.045"	0.045"	0.045"			
Manufacture/Trade Name	-	-	-	-	-			
Shielding Gas Composition	100 % CO ₂	100 % CO ₂	100 % CO ₂	100 % CO ₂	100 % CO ₂			
Flow Rate	45-55 cfh	45-55 cfh	45-55 cfh	45-55 cfh	45-55 cfh			
Nozzle Size	#4	#4	#4	#4	#4			
Preheat Temperature	75° amb.	75° amb.	75° amb.	75° amb.	75° amb.			
Interpass Temperature	75°-350°	75°-350°	75°-350°	75°-350°	75°-350°			
Electrical Characteristics	---	---	---	---	---	---	---	---
Current Type & Polarity	DCEP	DCEP	DCEP	DCEP	DCEP			
Transfer Mode (GMAW)	-	-	-	-	-			
Power Source Type	-	-	-	-	-			
Amps	180	200	200	200	200			
Volts	26	27	27	27	27			
Wire Feed Speed	(Amps)	(Amps)	(Amps)	(Amps)	(Amps)			
Travel Speed	8	10	11	9	11			
Maximum Heat Input	-	-	-	-	-			
Technique	---	---	---	---	---	---	---	---
Stringer or Weave	stringer	stringer	stringer	stringer	stringer			
Multi or Single Pass (per side)	multipass	multipass	multipass	multipass	multipass			
Oscillation (Machine/Auto.)	-	-	-	-	-			
Number of Electrodes	1	1	1	1	1			
Contact Tube to Work Dist.	3/4-1"	3/4-1"	3/4-1"	3/4-1"	3/4-1"			
Peening	None	None	None	None	None			
Interpass Cleaning	wire brush	wire brush	wire brush	wire brush	wire brush			
Other								

(see aws.org/forms for more examples)

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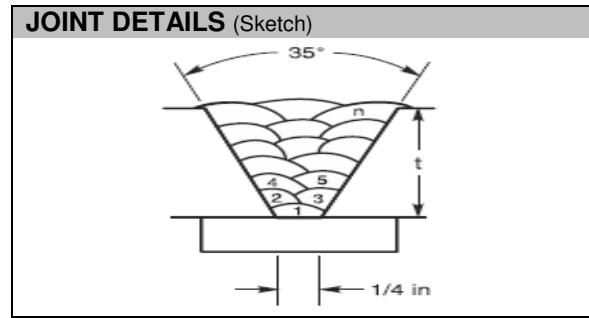
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Backing Material	ASTM A131	A	I				
Other							

JOINT DETAILS	
Groove Type	single V groove butt weld
Groove Angle	35° included
Root Opening	1/4"
Root Face	-
Back Gouging	none
Method	-



POSTWELD HEAT TREATMENT	
Temperature	-
Time at Temperature	-
Other	-

PROCEDURE					
Weld Layer(s)	-	-	-	-	-
Weld Pass(es)	1	2 - 8	9 - 11	12 - 15	16
Process	FCAW	FCAW	FCAW	FCAW	FCAW
Type (Semi-auto./Machine/Auto.)	semi-auto.	semi-auto.	semi-auto.	semi-auto.	semi-auto.
Position	4G	4G	4G	4G	4G
Vertical Progression	-	-	-	-	-
Filler Metal AWS Spec.	A5.20	A5.20	A5.20	A5.20	A5.20
AWS Classification	E71T-1	E71T-1	E71T-1	E71T-1	E71T-1
Diameter	0.045"	0.045"	0.045"	0.045"	0.045"
Manufacture/Trade Name	-	-	-	-	-
Shielding Gas Composition	100 % CO ₂	100 % CO ₂	100 % CO ₂	100 % CO ₂	100 % CO ₂
Flow Rate	45-55 cfh	45-55 cfh	45-55 cfh	45-55 cfh	45-55 cfh
Nozzle Size	#4	#4	#4	#4	#4
Preheat Temperature	75° amb.	75° amb.	75° amb.	75° amb.	75° amb.
Interpass Temperature	75°-350°	75°-350°	75°-350°	75°-350°	75°-350°
Electrical Characteristics	---	---	---	---	---
Current Type & Polarity	DCEP	DCEP	DCEP	DCEP	DCEP
Transfer Mode (GMAW)	-	-	-	-	-
Power Source Type	-	-	-	-	-
Amps	180	200	200	200	200
Volts	26	27	27	27	27
Wire Feed Speed	(Amps)	(Amps)	(Amps)	(Amps)	(Amps)
Travel Speed	8	10	11	9	11
Maximum Heat Input	-	-	-	-	-
Technique	---	---	---	---	---
Stringer or Weave	stringer	stringer	stringer	stringer	stringer
Multi or Single Pass (per side)	multipass	multipass	multipass	multipass	multipass
Oscillation (Machine/Auto.)	-	-	-	-	-
Number of Electrodes	1	1	1	1	1
Contact Tube to Work Dist.	3/4-1"	3/4-1"	3/4-1"	3/4-1"	3/4-1"
Peening	None	None	None	None	None
Interpass Cleaning	wire brush	wire brush	wire brush	wire brush	wire brush
Other					

(see aws.org/forms for more examples)

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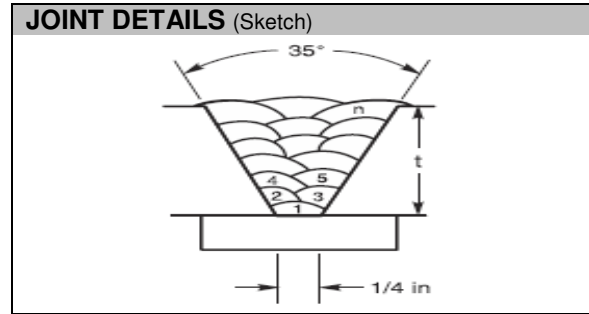
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JOINT DETAILS	
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Back Gouging	none
Method	-



POSTWELD HEAT TREATMENT	
Temperature	-
Time at Temperature	-
Other	-

PROCEDURE					
Weld Layer(s)	-	-	-	-	-
Weld Pass(es)	1	2 - 8	9 - 11	12 - 15	16
Process	FCAW				
Type (Semi-auto./Machine/Auto.)	semi-automatic				
Position	4G				
Vertical Progression	-				
Filler Metal AWS Spec.	A5.20				
AWS Classification	E71T-1	E71T-1	E71T-1	E71T-1	E71T-1
Diameter	0.045"	0.045"	0.045"	0.045"	0.045"
Manufacture/Trade Name	-	-	-	-	-
Shielding Gas Composition	100 % CO ₂				
Flow Rate	45-55 cfh				
Nozzle Size	#4				
Preheat Temperature	75° ambient				
Interpass Temperature	75°-350°				
Electrical Characteristics	---	---	---	---	---
Current Type & Polarity	DCEP	DCEP	DCEP	DCEP	DCEP
Transfer Mode (GMAW)	-	-	-	-	-
Power Source Type	-	-	-	-	-
Amps	180	200	200	200	200
Volts	26	27	27	27	27
Wire Feed Speed	(Amps)	(Amps)	(Amps)	(Amps)	(Amps)
Travel Speed	8	10	11	9	11
Maximum Heat Input	-	-	-	-	-
Technique	---				
Stringer or Weave	stringer				
Multi or Single Pass (per side)	multipass				
Oscillation (Machine/Auto.)	-				
Number of Electrodes	1				
Contact Tube to Work Dist.	3/4-1"				
Peening	None				
Interpass Cleaning	wire brush				
Other					