Pyramid Co.
123 Any Street
KC, MO 64015

Procedure Qualification Record (PQR)

PQR No.: **PQR #2** Date: **7/3/2011** WPS No.: _____

Welding Process(es) / Type(s): **(1) GMAW / Semiautomatic**

Joint Design (QW-402)
Weld Type: Groove weld
Groove Type: Square groove
Backing: Open butt, no back weld
Root Opening: 1 in.
1

Base Metals (QW-403)
Specification Type and Grade:
A-1008, Grade DS Type B to A-1008, Grade DS Type B
P-No. 1 Group No. 1 to P-No. 1 Group No. 1
Thickness (in.): 1
1

Preheat (QW-406)
Minimum Preheat Temperature: 1 °F
Preheat Maintenance: 1
Maximum Interpass Temperature: 1 °F
1

Postweld Heat Treatment (QW-407)
Type: No PWHT performed
PWHT Temperature: None °F
PWHT Holding Time: None hr.
1

First Process: GMAW **Type:** Semiautomatic

Filler Metals (QW-404)
AWS Classification: E70C-B2L
SFA Specification: 5.28 F-No.: 6
A-No. or Chemical Composition: 3
Filler Metal Trade Name: 1
Filler Metal Product Form: Metal cored
Supplemental Filler Metal: 1
Weld Deposit 't' (in.): 1
Pass Greater Than ½": No

Positions (QW-405)
Position of Joint: 1G - Flat
Weld Progression: N/A
Notes: 1

Gas (QW-408)
Shielding: 100% Argon / 1 CFH
Backing: None / - CFH
Trailing: None / - CFH
1

Electrical Characteristics (QW-409)
Current Type and Polarity: DCEN (straight)
Transfer Mode: Short-circuiting arc

Welding Details

Filler Metal Size (in.):	1	-	-
Amperage Used:	1	-	-
Wire Feed Speed (in/min):	1	-	-
Voltage Used:	1	-	-
Travel Speed (in/min):	1	-	-

Max. Heat Input (J/in): N/R

Technique (QW-410)
Thermal Processes: No
Stringer or Weave Bead: Stringer bead
Nozzle / Gas Cup Size: 1
Contact Tube to Work Distance: 1
Multiple / Single Pass (per side): Single pass

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Tensile Test (QW-150)

Specimen No.	Width (in.)	Thickness (in.)	Area (in²)	Ultimate Total Load (lb)	Ultimate Unit Stress (PSI)	Failure Type and Location
1	1	1	1	1	11111111	Base metal
2	2	2	2	2	22222222	Weld metal

Guided Bend Tests (QW-160)

Type and Figure No.	Result	Type and Figure No.	Result
QW-462.2 Side bend	Acceptable	QW-462.2 Side bend	Acceptable
QW-462.2 Side bend	Acceptable	QW-462.2 Side bend	Acceptable

Hardness Test - Brinell hardness

Location	Readings								
A-1008, Grade DS Type B BM	1								
A-1008, Grade DS Type B HA	2								
Weld metal	3								

Visual Examination: 1

Liquid Penetrant Test: 1

Macro-Examination Test: 1

1

Welder's Name: _____ I.D.: _____ Stamp No.: _____

PQR was done and welding of coupon was witnessed by: Your Company Name

Test conducted by: 1 Lab Test No.: 1

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 A

Verified By John Smith 4/8/2016 Date QA MAnager