

ASME WELDING PROCEDURE QUALIFICATION RECORD

PQT No. _____

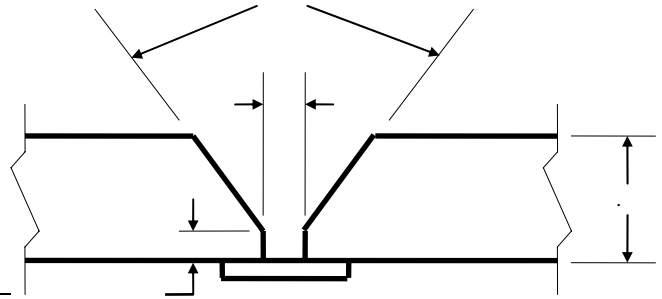
LANL Welding Program

Process: _____
 PQT No. _____

Manual Automatic Semi-automatic
 Date Welded: _____

Joints (QW-402):

Weld Joint Design Used: _____
 Backing Strap Used: Yes No
 Weld Joint Tolerances:
 Included angle: _____
 Root face: _____
 Root opening: _____
 Retainers: _____



Base Metals (QW-403):

Material Spec & Type: _____
 to Spec & Type: _____
 ASME P No. & Group: _____
 to P No. & Group: _____
 Thickness of Test Coupon: _____
 Diameter of Test Coupon: _____
 Type of Backing: _____
 All Passes Less Than 1/2" Thick: Yes No

Post Weld Heat Treatment (QW-407):

Temperature: _____ °F
 Time: _____

Gas (QW-408):

Gas(es): % Composition: Flow Rate:
 Shielding: _____
 Trailing: _____
 Backing: _____

Filler Metals (QW-404):

ASME Specification: _____
 ASME Filler Metal Group No. F: _____
 ASME Weld Metal Analysis No. A: _____
 AWS Classification: _____
 Filler Metal Size: _____
 Weld Metal Thickness Deposited: _____
 Alloy Elements: _____
 Consumable Insert Used For Root Pass:
 Yes No
 Supplemental Filler Metal Used: Yes No

Electrical Characteristics (QW-409):

Welding Current: _____
 Polarity: _____
 Amps: _____ Volts: _____
 Tungsten Electrode Type: _____
 Tungsten Electrode Size: _____
 Travel Speed: _____
 Transfer Mode: _____

Position (QW-405):

Position or Groove: _____
 Weld Progression: _____

Technique (QW-410):

Single or Multiple Pass (per side): _____
 Single or Multiple Electrodes: _____
 Bead Placement Technique: _____
 Orifice, Cup, or Nozzle Size: _____
 Cleaning Method: _____
 Backgouge Method: _____
 Oscillation: _____
 Tube-Work Distance: _____
 Electrode Spacing: _____
 Peening: _____

Preheat (QW-406):

Preheat Temperature: _____ °F
 Interpass Temperature (Max.): _____ °F

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TEST RESULTS:

TENSILE TESTS (QW-150):

Specimen No.	Dimensions		Area (sq. in.)	Ultimate Total Load (lbs.)	Ultimate Tensile Strength (ksi)	Location and Type of Failure
	Width	Thickness				

GUIDED BEND TESTS (QW-160):

Type and Figure No.	Results

TOUGHNESS TESTS (QW-170):

Specimen No.	Notch Location	Specimen Size	Test. Temp.	Impact Values		
				(Ft.-Lbs.)	% Shear	Mils

Code Edition and Addenda: _____ Welder's Name: _____

Welding Conducted By: _____

Testing Laboratory Name and Location: _____

Laboratory Test Report No./Date: _____

We the undersigned, 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 ASME Section IX.

Organization: Los Alamos National Laboratory

Date: _____ Certified By: _____