



QB-482 BRAZING PROCEDURE SPECIFICATIONS (BPS)

(See QB-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

BPS No.: _____ Revision: _____ Date Issued: _____

Supporting PQRs.: _____

Brazing Process(es): _____ Type(s): _____

JOINTS (QB-408)

Joint Design: Type: _____ Clearance: _____

Overlap: Minimum: _____ Maximum: _____

BASE METALS (QB-402)

P/S-No. _____ to P/S-No. _____

Other: _____

Base Metal Thickness

Minimum: _____

Maximum: _____

FILLER METALS (QB-403)

Specification No.: _____

AWS Classification: _____

F-No.: _____

Filler Form: _____

POST BRAZE HEAT TREATMENT (QB-409)

Temperature: _____

Max. Holding Time: _____

BRAZING FLUX, FUEL GAS, OR ATMOSPHERE (QB-406)

Flux Type or Trade Name: _____

Fuel Gas: _____

Flame Type: _____

Recommended Brazing Temperature: _____

Other: _____

FLOW POSITIONS (QB-407)

Position Permitted: _____

Flow Direction: _____

TECHNIQUE (QB-410) AND OTHER INFORMATION

Initial Cleaning: _____

Flux Application: _____

Torch Tip Sizes: _____

Final Cleaning: _____

Inspection: _____

Organization: _____

By: _____

Title: _____ Date: _____