



QB-483 BRAZING PROCEDURE QUALIFICATION RECORDS (PQR)

(See QB-200.2, Section IX, ASME Boiler and Pressure Vessel Code)

BPS Followed During Brazing of Test Coupon: _____ **PQR No.:** _____

Brazing Process(es) Used: _____ Date Coupon Was Brazed: _____

Base Metal Specification: _____

to Base Metal Specification: _____

P-Number: _____ to P-Number: _____ Plate/Pipe Diameter: _____

Base Metal Thickness (in.): _____ Joint Type: _____

Filler Metal Specification: AWS Classification: _____ F-No.: _____ Product Form: _____

Filler Metal Size: _____ Method of Applying Filler: _____

Flux Type of Trade Name: _____ Gas Backing: _____

Overlap Used (in.): _____ Clearance Between Parts: _____

Position and Flow Direction: _____

Fuel Gas: _____ Flame Type: _____

Postbrazing Heat Treatment (°F): _____ Postbrazing Heat Treatment Time (hr): _____

Cleaning Prior to Brazing: _____

Cleaning After Brazing: _____

Other: _____

Tensile Tests

Specimen	Width/Dia. (in.)	Thickness (in.)	Area (sq in.)	Ultimate load (lb)	Ultimate Stress (psi)	Failure Location

Bend Tests

Type	Results	Type	Results

Peel or Section Tests

Type	Results	Type	Results

Other Tests: _____

Brazer's Name: _____ ID No.: _____ Company: _____

Brazing of Test Coupon Supervised by: _____ Company: _____

Test Specimens Evaluated by: _____ Company: _____

Laboratory Test Number: _____

We hereby certify that the statements in this record are correct and that the test welds were prepared, brazed, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Organization: _____

By: _____ Date: _____