

**SOLDERING PROCEDURE QUALIFICATION RECORD (SPQR) – SAMPLE FORM**

SPQR No. \_\_\_\_\_ Date \_\_\_\_\_ SPS No. \_\_\_\_\_

Company \_\_\_\_\_

Solderer Name and ID No. \_\_\_\_\_

Soldering Process \_\_\_\_\_ Manual  Mechanized  Automatic

Soldering Equipment \_\_\_\_\_

**SOLDERING CONDITIONS**

**BASE METAL:**

Specification \_\_\_\_\_ BM No. \_\_\_\_\_ Thickness \_\_\_\_\_

Preparation \_\_\_\_\_

Other \_\_\_\_\_

**FILLER METAL:**

Alloy Grade \_\_\_\_\_ FM No. \_\_\_\_\_ Form \_\_\_\_\_

Method of Application \_\_\_\_\_ Other \_\_\_\_\_

SOLDERING FLUX \_\_\_\_\_ Other \_\_\_\_\_

BATH COMPOSITION \_\_\_\_\_ Other \_\_\_\_\_

SOLDERING ATMOSPHERE \_\_\_\_\_ Other \_\_\_\_\_

SOLDERING TEMPERATURE \_\_\_\_\_ Other \_\_\_\_\_

SOLDERING TIME \_\_\_\_\_

SOLDER HEAT TREATMENT \_\_\_\_\_

OTHER \_\_\_\_\_

**JOINT DESIGN TESTED:**

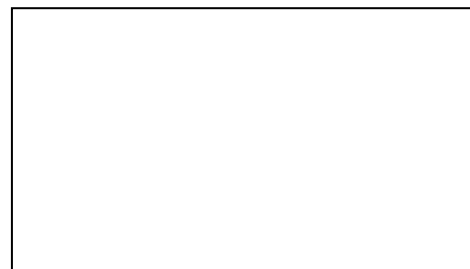
Type \_\_\_\_\_

Clearance \_\_\_\_\_

Lap Length \_\_\_\_\_

Soldering Flow Position \_\_\_\_\_

Other \_\_\_\_\_



Joint Design Tested

TEST RESULTS

SPQR No. \_\_\_\_\_ Date \_\_\_\_\_

VISUAL	<u>Pass</u>	<u>Fail</u>
_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	<input type="checkbox"/>	<input type="checkbox"/>

TENSION

Specimen No.	UTS psi	Remarks	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	_____	<input type="checkbox"/>	<input type="checkbox"/>

BEND

Specimen No.	Remarks	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>

MACROETCH

Specimen No.	Remarks	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>

PEEL

Specimen No.	Remarks	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>
_____	_____	<input type="checkbox"/>	<input type="checkbox"/>

We certify that the information in this record is correct and that the test solderments were prepared, soldered, and tested in accordance with the requirements of *AWS Specification for Soldering Procedure and Performance Qualification, AWS B2.3/B2.3M*: \_\_\_\_\_

Test conducted by \_\_\_\_\_ Date \_\_\_\_\_

Qualifier

Date

Approved by \_\_\_\_\_ Date \_\_\_\_\_

Employer

Date