PROCEDURE QUALIFICATION RECORD WORKSHEET
PQR NUMBER_____

Welder's Name _____ ID_____ Welding Test Date _____
Process _____ Position_____ Joint Detail: ☐ Fig. 5.1 ☐ Fig. 5.2
Electrode(s) Mfg. Designation_____ ☐ Fig. 5.3 ☐ Fig. 5.8
AWS Electrode Classification _____ Electrical Stick Out _____
Flux Mfg. Designation _____ AWS Flux Classification _____
Postweld Heat Treatment: Temp._____ Hold Time_____ Heating/Cooling Rate _____

		Diam.	Current	WFS*	Voltage	Current and Polarity
Electrode	(1)					
	(2)					
	(3)					

Shielding Gas _____ Dew Point _____ Flow Rate _____ Gas Cup Size _____
Travel Speed: Min. _____ Max._____
Base Metal Specification and Thickness_____ Heat Number _____
Backing Metal Specification and Thickness _____ Heat Number _____
Preheat Temp._____ Interpass Temp. Min. _____ Max._____

Pass Number	Layer	Process	FILLER METAL	CURRENT						TEMPERATURE	
			Diam.	Type & Polarity	Wire Feed Speed	Amp	Volts	Travel Speed	Stick Out	Preheat	Interpass

*Optional
Page _____ of _____

For multiple electrodes list each electrode on separate line. For parallel electrodes show "2 @ _____" under number and diameter. Preheat and interpass temperature measured at mid length of plates approximately 25 mm [1 in] from the weld center line.

State/3rd Party Witness _____ Mfr./Contractor _____

Date _____

Form N-4

Form N-4—Procedure Qualification Record (PQR) Worksheet