

FORM QF-483(c) SUGGESTED FORMAT FOR SIDEWALL-FUSING PROCEDURE QUALIFICATION RECORDS (PQR)
[See QF-201.5(d), Section IX, ASME Boiler and Pressure Vessel Code]

Company Name _____

Procedure Qualification Record No. _____ Date _____

FPS No. _____

Fusing Process(es) _____

Joints (QF-402)

Fitting Manufacturer _____

Material (QF-403)

Fitting Specification _____ Classification _____
to Header Specification _____ Classification _____
Branch Size (Diameter) _____
Header Size (Diameter) _____
Fitting Projected Base Area/Cross-Sectional Area _____
Other _____

Equipment (QF-406)

Fusing Machine Manufacturer _____

Data Acquisition Used Yes No
Data Acquisition System Manufacturer _____
Hydraulic Extension Hose Length _____

Position (QF-404)

Position of Header _____
Position of Branch _____
Other _____

Technique (QF-407)

Location Fabrication Shop Field
Cleaning Agent or Method _____
Abrasion Method _____

Thermal Conditions (QF-405)

Heater Surface Temperature _____
Drag Pressure _____
Heating Initial Interfacial Pressure _____
Time at Pressure _____
Heat Soak Interfacial Pressure _____
Melt Bead Size or Time _____
Heater Plate Removal Time _____
Fusing Pressure _____
Cool-Down Time at Fusing Pressure _____
Other _____

Other

Visual Examination (QF-141)

Elevated Temperature Sustained Pressure Tests (QF-142)

Joint No.	Heater Temperature	Interfacial Pressure	Result

Impact Resistance Tests (QF-145)

Joint No.	Spec. No.	Heater Temperature	Interfacial Pressure	Type of Failure	Location of Failure

Other

Fusing Operator's Name _____ Identification No. _____ Stamp No. _____

Tests Conducted By _____ Laboratory Test No. _____

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

Organization _____

Date _____ Certified By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)