

FORM QF-483(a) SUGGESTED FORMAT FOR BUTT-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) _____

<p>_____</p> <p align="center">Pipe Surface Alignment _____</p> <p align="center">Pipe End Preparation of Test Coupon</p>	
<p>Material (QF-403)</p> <p>Specification _____ Classification _____</p> <p>to Specification _____ Classification _____</p> <p>Pipe Size (Diameter) _____</p> <p>Pipe Wall Thickness _____</p> <p>Cross-Sectional Area _____</p> <p>Other _____</p>	<p>Equipment (QF-406)</p> <p>Fusing Machine Manufacturer _____</p> <p>_____</p> <p>Data Acquisition Used <input type="checkbox"/> Yes <input type="checkbox"/> No</p> <p>Data Acquisition System Manufacturer _____</p> <p>Hydraulic Extension Hose Length _____</p>
<p>Position (QF-404)</p> <p>Position of Pipe _____</p> <p>Other _____</p>	<p>Technique (QF-407)</p> <p>Location <input type="checkbox"/> Fabrication Shop <input type="checkbox"/> Field</p> <p>_____</p> <p>_____</p> <p>_____</p>
<p>Thermal Conditions (QF-405)</p> <p>Heater Surface Temperature _____</p> <p>Initial Heating Interfacial Pressure _____</p> <p>Heat Soak Interfacial Pressure _____</p> <p>Fusion Interfacial Pressure _____</p> <p>Drag Pressure _____</p> <p>Butt-Fusing Pressure _____</p> <p>Melt Bead Size _____</p> <p>Heater Plate Removal Time _____</p> <p>Cool-Down Time at Butt-Fusing Pressure _____</p> <p>Other _____</p>	<p>Other</p>