

FORM QF-482 Suggested Format for Fusing Procedure Specifications (FPS)
(See QF-201.3, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name _____ By _____

Fusing Procedure Specification No. _____ Date _____

Revision No. _____ Date _____

FPS Qualification ☐ By testing ☐ SFPS If qualified by testing, supporting PQR No.(s) _____

Fusing Process Type _____

Joints (QF-402)		Details
Joint Type _____		
Pipe End Preparation _____		
Miter Joint Angle _____		
Pipe Surface Alignment _____		
Sketches, production drawings, weld symbols, or written description should show the general arrangement of the parts to be fused. Where applicable, the details of the joint groove may be specified.		
Sketches may be attached to illustrate joint design.		
Materials (QF-403)		
Specification _____ Classification _____ to Specification _____ Classification _____		
Pipe Size (Diameter) _____ Pipe Wall Thickness _____		
Other _____		
Position (QF-404)		
Pipe Position _____		
Other _____		
Thermal Conditions (QF-405)		
Heater Surface Temperature Range _____		
Fusing Interfacial Pressure Range _____		
Drag Pressure Range _____ Butt-Fusing Pressure Range _____		
Melt Bead Size Range _____ Heater Plate Removal Time Range _____		
Cool-Down Time at Butt-Fusing Pressure Range _____		
Equipment (QF-406)		
Fusing Machine Manufacturer _____		
Data Acquisition Used <input type="checkbox"/> Yes <input type="checkbox"/> No Data Acquisition Machine Manufacturer _____		
Hydraulic Hose Length _____		
Technique (QF-407)		
Location <input type="checkbox"/> Fabrication Shop <input type="checkbox"/> Field		
