

# ASME Sect. IX WPS & PQR Check List

QW-402 JOINTS			SMAW		GTAW		GMAW / FCAW		SAW		OFW		ESW		PAW	
1	∅	in groove design		N		N		N		N		N		N		S
2	±	backing										N				
3	∅	backing composition										N				
4	-	of backing in single sided weld		N				N		N						
5	+	backing or ∅ chemical composition				N										N
10	∅	root spacing		N		N		N		N		N		N		N
11	±	retainers		N		N		N		N			E			N

QW-403 BASE METAL																
1	∅	P-Number										E		E		
2		max. T qualified										E				
4	∅	group number												S		
5	∅	in group number QW-422		S		S		S		S						S
6		T limits for impact test 16 mm min T		S		S		S		S						S
8	∅	T qualified	E		E		E		E							E
9		t pass > 1/2 in (13 mm)	E				E		E				E			
10		T limits qualified (short circuit arc)					E									
11	∅	P-N° qualified	E		E		E		E							
12	∅	P-Number/melt-in														E

QW-404 Filler Metals																
3	∅	size of filler metal				N						N				N
4	∅	F-N°	E		E		E		E		E		E		E	
5	∅	A-N° (ferrous materials only)	E		E		E		E		E		E		E	
6	∅	diameter of electrodes		N			N		N				N			
7	∅	diameter > ¼ in (6 mm)	S													
9	∅	flux/wire classification							E							
10	∅	alloy flux							E							
12	∅	AWS classification	S		S		S				E		S		S	
14	±	filler			E										E	
17	∅	flux type or composition											E			
18	∅	wire to plate											E			
19	∅	consum guide											E			
22	±	consumable insert				N										N
23	∅	solid or metal cored to flux-cored or v-v			E		E									E
24	± / ∅	supplemental Filler Metal					E		E							
27	∅	alloy elements from supplemental filler					E		E							E
29	∅	flux trade designation								N						
30	∅	t	E		E		E		E							E
32		t limits (short circuit arc)					E									
33	∅	AWS classification		N		N		N		N				N		N
34	∅	flux Type neutral/active P#1)							E							
35	∅	flux/wire classification							S	N						
36		recrushed slag							E							
50	±	GTAW flux to aid penetration				N										

QW-405 Positions																
1	+	other position		N		N		N		N		N				N
2	∅	position to vertical	S		S		S								S	
3	∅	↑↓ Vertical Welding		N		N		N								N

QW-406 Preheat																
1		decrease > 100°F (55°C)	E		E		E		E		N				E	
2	∅	preheat maintenance		N		N		N		N						
3		increase > 100°F (55°C) (IP)	S		S		S		S						S	

QW-407 PWHT																
1	∅	PWHT (none, <A1, >A3, >A1&<A3 or combination)	E		E		E		E		E		E		E	
2	∅	PWHT ( time & temperature range)	S		S		S		S				S		S	
4		T Limits >A3	E		E		E		E				E		E	

QW-408 GAS			SMAW	GTAW	GMAW / FCAW	SAW	OFW	ESW	PAW
1	±	trailing or Ø composition		N	N				N
2	Ø	shielding gas single, mixture or %		E	E				
3	Ø	shielding flow rate		N	N				
4	Ø	composition							E
5	±	backing or Ø composition or flow		N	N				N
7	Ø	type fuel gas					E		
9	-	backing or Ø composition P4X, P10I, J, K P5X or P6X		E	E				E
10	Ø	shielding or trailing P10 I,J,K, P5X or P6X		E	E				E
21	Ø	flow rate							N

QW-409 Electrical Characteristics			SMAW	GTAW	GMAW / FCAW	SAW	OFW	ESW	PAW
1	>	heat input	S	S	S	S			S
2	Ø	transfer mode to short circuit or v-v			E				
3	±	pulsing I to DC		N					
4	Ø	AC to DC or v-v, for DC Ø polarity	S N	S N	S N	S N			S N
5	Ø	± 15% I & E range						E	
8	Ø	Amps & (except SMAW & GTAW) volts range	N	N	N	N			N
12	Ø	tungsten electrode		N					N

QW-410 Technique			SMAW	GTAW	GMAW / FCAW	SAW	OFW	ESW	PAW
1	Ø	string/weave for manual or semiautomatic	N	N	N	N		N	N
2	Ø	flame characteristics						N	
3	Ø	orifice cup, or nozzle size		N	N				N
4	Ø	← → Technique						N	
5	Ø	method of cleaning	N	N	N	N		N	N
6	Ø	method of back gouge	N	N	N	N			N
7	Ø	oscillation for machine or automatic		N	N	N		E	N
8	Ø	contact tube to work distance			N	N			
9	Ø	multi to single pass per side	S N	S N	S N	S N			S N
10	Ø	single to multi electrodes for machine & automatic		S N	S N	S N		E	S N
11	Ø	closed to out of chamber welding for P-N° 5X		E					E
12	Ø	melt-in to keyhole							S
15	Ø	electrode spacing machine & automatic		N	N	N		N	N
25	Ø	manual or semiautomatic to machine or automatic	N	N	N	N			
26	±	peening	N	N	N	N	N	N	N
64		use of thermal process for P11A&P11B	E	E	E	E	E	E	E

LEGEND

> Increase / greater than	+ Addition	↑ Uphill	← Forehand	Ø Change
< Decrease / less than	- Deletion	↓ Downhill	→ Backhand	

**E = Essential Variables which must be indicated on both the WPS and recorded on the PQR .**

**Any changes to these variables require requalification of WPS**

**S = Supplementary Essential Variables must be indicated on the WPS and Recorded on the PQR when Impact Testing is required. Changes to these variables when Impact testing is performed require requalification of WPS.**

**N = Nonessential variables must be indicated on the WPS but when changed do not require requalification of WPS**

**NOTE 1:** WPS's are to indicate **all** Essential, Nonessential and when required Supplementary Essential variables applicable for the process. PQR's are to indicate **all** Essential and when required Supplementary Essential variables applicable for the process. Do not indicate variables which are not used as **NA**, they **are** applicable and should be entered on the WPS or PQR as **"None" / "Not used"** or similar.

**NOTE 2:** Be careful of converting a temperature **value** and a temperature **difference** for example: A preheat or interpass temperature of 200°C:  $(9 \times 200°C) / 5 + 32 = 392°F$  with a permitted decrease of 100°F gives  $392°F - 100°F = 292°C$  converted back to °C  $(292°F - 32) \times 5 / 9 = 144,44 °C$ ; the difference is  $200°C - 144,44°C = 55,56$ . This permits an increase or decrease of **55,56°C** not as would be assumed from converting  $100°F(100°F - 32) \times 5 / 9 = 32,7°C$