

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 _____

Initial Heating 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.)