

PROCEDURE QUALIFICATION RECORD WORKSHEET

PQR NUMBER 43

Welder's Name Jim Gentile ID L Welding Test Date 4-14-10
 Process SAW Position F/IG Joint Detail: Fig. 5.1 Fig. 5.2
 Electrode(s) Mfg. Designation LA-75 Fig. 5.3 Fig. 5.8
 AWS Electrode Classification A5.29 ENiK Electrical Stick Out _____
 Flux Mfg. Designation 960 AWS Flux Classification FB A2-ENiK-Ni-H8
 Postweld Heat Treatment: Temp. _____ Hold Time _____ Heating/Cooling Rate _____

Electrode	(1)	Diam.	Current	WFS*	Voltage	Current and Polarity
(2)		<u>3/32</u>	<u>400</u>		<u>30</u>	<u>DC EP</u>
(3)						

Shielding Gas NA Dew Point _____ Flow Rate _____ Gas Cup Size _____
 Travel Speed: Min. _____ Max. _____
 Base Metal Specification and Thickness SAW 1" Heat Number 9104138
 Backing Metal Specification and Thickness SAW 1/2" Heat Number 9103600
 Preheat Temp. 150 Interpass Temp. Min. _____ Max. 450

Pass Number	Layer	Process	FILLER METAL Diam.	CURRENT						TEMPERATURE	
				Type & Polarity	Wire Feed Speed	Amp	Volts	Travel Speed	Stick Out	Preheat	Interpass
1		SAW	3/32	DC EP		400	30	14.1	1/4	750	450
2											
3											
4											
5											
6											
7											
8											
9											
10											
11											
12											
13											
14											
15											
16											
17											
18											450

*Optional
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For multiple electrodes list each electrode on separate line. For parallel electrodes show "2 @ _____" under number and diameter.
 Preheat and Interpass temperature measured at mid length of plates approximately 25 mm [1 in] from the weld center line.

State/3rd Party Witness _____ Mfr./Contractor ARC Ent.
 Date _____

Vermont Agency of Transportation

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Procedure Qualification Record (PQR) Worksheet

CK'D BY David Peterson OK'D BY JWC

Apr 26, 2012

RESUBMIT _____ APPROVED
 BY C. CARLSON DATE 5/7/12