(13)

FORM QB-483 SUGGESTED FORMAT FOR A BRAZING PROCEDURE QUALIFICATION RECORD (PQR)
(See QB-200.2, Section IX, ASME Boiler and Pressure Vessel Code)
Record of Actual Variables Used to Braze Test Coupon

Organization Name _____

BPS Followed During Brazing of Test Coupon _____ PQR No. _____

Brazing Process(es) Used _____ Date Coupon Was Brazed _____

Base Metal (QB-402)

Base Metal Specification _____ to Base Metal Specification _____

P-Number _____ to P-Number _____

Base Metal Thickness _____ to Base Metal Thickness _____

Plate or Pipe/Tube _____

Brazing Filler Metal (QB-403)

Filler Metal Specification: AWS Classification _____ F-No. _____ Filler Metal Product Form _____

Joint Design (QB-408)

Overlap _____ Joint Type _____ Joint Clearance _____

Brazing Temperature (QB-404)

Brazing Temperature Range _____

Brazing Flux, Fuel Gas, or Atmosphere (QB-406)

Flux (AWS Class., Compostion, Trade Name, or None) _____ Atmosphere Type _____

Fuel Gas _____ Furnace Temperature _____ Other _____

Flow Position (QB-407)

Position _____ Flow Direction _____

Postbraze Heat Treatment (QB-409)

Temperature _____ Time _____

Technique (QB-410)

Cleaning Prior to Brazing _____

Postbraze Cleaning _____

Nature of Flame (Oxidizing, Neutral, Reducing) _____

Other _____

Tensile Tests (QB-150)

Specimen	Width/ Diameter	Thickness	Area	Ultimate Load	UTS (psi or MPa)	Failure Location

Bend Tests (QB-160)

Type	Results	Type	Results

Peel Tests (QB-170) or Section Tests (QB-180)

Type	Results	Type	Results

Other Tests _____

Brazer's/Brazing Operator's Name _____ ID No. _____

Brazing of Test Coupon Supervised by _____

Test Specimens Evaluated by _____ Company _____

Laboratory Test Number _____

We hereby certify that the statements in this record are correct and that the test coupons were prepared, brazed, and tested in accordance with the requirements of Section IX of the ASME BOILER AND PRESSURE VESSEL CODE.

Organization _____

Certified by _____ Date _____

(07/13)