2013 SECTION IX

(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

	e					
		Coupon	D-1- C	F	PQR No	
Brazing Process(e:			Date Cou	pon Was Brazed		
Base Metal (QB-40						
Base Metal Specification				ecification		
P-Number						
Base Metal Thickn			to Base Metal Th	ickness ———		
Plate or Pipe/Tube	·					
Brazing Filler Met						
Filler Metal Specif	ication: AWS Class	sification F	-No	Filler Metal Prod	luct Form	
Joint Design (QB-	408)					
Overlap Joint Type				loint Clearance		
Brazing Temperat	ure (QB-404)					
Brazing Temperati						
Brazing Flux, Feel	Gas, or Atmosphe	re (OB-406)				
•		e Name, or None)	A	tmosphere Type		
Fuel Gas Furnace Temperature						
Flow Position (QB	-407)					
Position		Flow Direction				
		11011 Direction		 _		
Postbraze Heat Tr Temperature	eatment (QB-409)	Time				
Technique (QB-41) Cleaning Prior to I						
Postbraze Cleanin						
				2.40.112.10.11		
Nature of Flame (Oxidizing, Neutral,	Reducing)				
	Oxidizing, Neutral,	Reducing)	-			
Other		Reducing)				-
Other	150)	Reducing)			1	
Other		Reducing)	Area	Ultimate Load	UTS (psi or MPa)	Failure Location
Other	150) Width/		Area	Ultimate Load	UTS (psi or MPa)	Failure Location
Other	150) Width/		Area	Ultimate Load	UTS (psi or MPa)	Failure Location
Other	150) Width/		Area	Ultimate Load	UTS (psi or MPa)	Failure Location
Other Tensile Tests (QB- Specimen	.150) Width/ Diameter		Area	Ultimate Load	UTS (psi or MPa)	Failure Location
Other Tensile Tests (QB- Specimen Bend Tests (QB-1	Width/ Diameter		Area		UTS (psi or MPa)	
Other	Width/ Diameter	Thickness	Area	Ultimate Load	A. A	
Other Tensile Tests (QB- Specimen Bend Tests (QB-1	Width/ Diameter	Thickness	Area		A. A	
Other	Width/ Diameter	Thickness Results	Area		A. A	
Other	Width/ Diameter 30) pe	Thickness Results	Area		A. A	its
Other Tensile Tests (QB- Specimen Bend Tests (QB-10 Ty Peel Tests (QB-17	Width/ Diameter 30) pe	Thickness Results (QB-180)	Area	Туре	Resu	its
Other Tensile Tests (QB- Specimen Bend Tests (QB-10 Ty Peel Tests (QB-17	Width/ Diameter 30) pe	Thickness Results (QB-180)	Area	Туре	Resu	its
Other Tensile Tests (QB- Specimen Bend Tests (QB-10 Ty Peel Tests (QB-17	Width/ Diameter 30) pe	Thickness Results (QB-180)		Туре	Resu	its
Other Tests (QB-17 Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing C	Width/ Diameter 50) pe 70) or Section Tests pe	Thickness Results (QB-180) Results		Туре	Resu	its
Other Tests (QB-17 Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing C Brazing of Test Cc	Width/ Diameter 50) pe (0) or Section Tests pe Operator's Name pupon Supervised I	Thickness Results (QB-180) Results	1D N	Type Type	Resu	its
Other Specimen Bend Tests (QB-16 Ty Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing Q Brazing of Test Cc Test Specimens E	Width/ Diameter 30) pe 10) or Section Tests pe Diperator's Name — pupon Supervised I	Thickness Results (QB-180) Results	1D N	Type Type	Resu	its
Other Tests (QB-17 Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing Q Brazing of Test Cc Test Specimens E	Width/ Diameter 30) pe 10) or Section Tests pe Diperator's Name — pupon Supervised I	Thickness Results (QB-180) Results	1D N	Type Type	Resu	its
Other Specimen Bend Tests (QB-16 Ty Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing C Brazing of Test Cc Test Specimens E Laboratory Test N	Width/ Diameter 50) pe (0) or Section Tests pe Operator's Name oupon Supervised I valuated by umber	Thickness Results (QB-180) Results	ID N	Type Type	Resu	its
Specimen Bend Tests (QB-10 Ty Peel Tests (QB-17 Ty Other Tests Brazer's/Brazing C Brazing of Test Cc Test Specimens E Laboratory Test N We hereby certify	Width/ Diameter 30) or Section Tests pe Operator's Name outpon Supervised I valuated by umber that the statemen	Thickness Results (QB-180) Results	ID N Compa	Type Type	Resu	its
Other	Width/ Diameter 30) or Section Tests pe Operator's Name outpon Supervised I valuated by umber that the statemen	Thickness Results (QB-180) Results by ts in this record are correct and that the BOILER AND PRESSURE VESS	ID N Compa	Type Type Io. ny were prepared, braze	Resu	its
Other Tests (QB-17 Other Tests (QB-17 Other Tests Brazer's/Brazing C Brazing of Test Cc Test Specimens E Laboratory Test N We hereby certify	Width/ Diameter 30) or Section Tests pe Operator's Name outpon Supervised I valuated by umber that the statemen	Thickness Results (OB-180) Results by ts in this record are correct and that ME BOILER AND PRESSURE VESS Organiz	Compa It the test coupons EL CODE.	Type Type Io. ny were prepared, braze	Resu	its