QW-483 PROCEDURE QUALIFICATION RECORD (PQR)

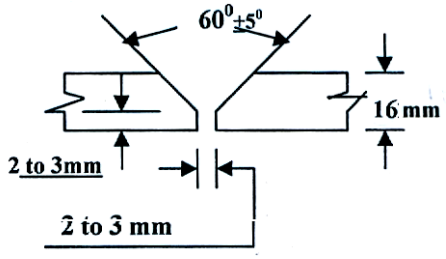
(See QW-201.2, Section IX, ASME Boiler and Pressure Vessel Code)

RECORD ACTUAL CONDITIONS USED TO WELD TEST COUPON

Company Name : **CONCEPT PROJECT & CONSULTANCY SERVICES**

Procedure Qualification Record No. 090/1 Date : 10-02-2016
WPS No. 090/1 Date : 02-02-2016
Welding Process(es) MMAW
Types (Manual, Automatic, Semi-Auto) Manual

JOINTS (QW-402)



BASE METALS (QW-403) Material Spec. IS 2062 -2011 Type or Grade E 250 Grade BR P. No. To P. No. Thickness of Test Coupon 10 MM Diameter of Test Coupon NA Other NA	**FILLER METALS (QW-404)** Weld Metal Analysis A-No. 1 Size of Filler Metal 2.5 MM, 3.15MM Filler Metal F-No. 2 SFA Specification 5.1 AWS Classification E 6013 Other NA
POSITION (QW-405) Position of Groove 1G for MMAW Weld progression (Fore Hand, Back, Fore Hand) Other NA	**PREHEAT (QW-406)** Preheat Temp. None Interpass Temp. Within 250°C Max. Other NA
POSTWELD HEAT TREATMENT (QW-407) Temperature NA Time NA Other NA	**GAS (QW-408)** Type of Gas or Gases NA Composition of Gas Mixture NA Other NA
ELECTRICAL CHARACTERISTICS (QW-409) Current DC Polarity EP Amps. 85 to 165 Volts | 27 to 32 V Tungsten Electrode Size NA Other NA	**TECHNIQUE (QW-410)** Travel Speed 50-100 mm/Min String or Weave Bead Root Run String bead, Subsequent Runs-Weave Bead Oscillation NA Multipass or Single Pass (per side) Multipass Single or Multiple Electrodes Single Other NA