

**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 \_\_\_\_\_  
 AWS BM-Number \_\_\_\_\_ to AWS BM-Number \_\_\_\_\_  
 Base Metal Thickness \_\_\_\_\_ to Base Metal Thickness \_\_\_\_\_  
 Plate or Pipe or 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., Composition, Trade Name, or None) \_\_\_\_\_ Atmosphere Type \_\_\_\_\_  
 Fuel Gas \_\_\_\_\_ Furnace Temperature \_\_\_\_\_ Other \_\_\_\_\_

**Flow Position (QB-407)**

Position \_\_\_\_\_ Flow Direction \_\_\_\_\_

**Postbrazing Heat Treatment (QB-409)**

Temperature \_\_\_\_\_ Time \_\_\_\_\_

**Technique (QB-410)**

Cleaning Prior to Brazing \_\_\_\_\_  
 Postbrazing Cleaning \_\_\_\_\_  
 Nature of Flame (Oxidizing, Neutral, Reducing) \_\_\_\_\_  
 Other \_\_\_\_\_

**Tensile Tests (QB-150)**

Specimen	Width or 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 or 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 \_\_\_\_\_