FORM QF-482(b) SUGGESTED FORMAT FOR ELECTROFUSION FUSING PROCEDURE SPECIFICATION (FPS OR MEFPS)
(See QF-201.3, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name_____ By_____

Fusing Procedure Specification No. _____ Date_____

Revision No. _____ Date_____

FPS qualification   By testing   MEFPS   If qualified by testing, supporting PQR   No.(s) _____

Joints (QF-402)   Details

    Joint Design_____

    Pipe End Cut max. out-of-square_____

    Maximum Fit-up Gap_____

        Max. Axial Misalignment_____

        Max. out-of-roundness_____

Sketches, production drawings, joint symbols, or written description
should show the general arrangement of the parts to be fused.
Where applicable, the details of the joint groove may be specified.

Materials (QF-403)

    Fitting Specification _____Classification_____ to Pipe Specification_____Classification_____

    Fitting Manufacturer_____ Pipe Size (diameter)_____ Pipe Wall Thickness_____

Thermal Conditions (QF-405)

    Minimum material & fusing temperature_____°F (°C)   Maximum material and fusing temperature_____°F (°C)

    Nominal fusion time at minimum temp_____   Nominal fusion time at maximum temp_____

    Minimum cool down time at min. temp_____   Minimum cool down time at max. temp_____

    Fusion Voltage_____

    Other_____

Equipment (QF-406)

    Minimum Power Supply_____(KVA)   Processor Manufacturer_____Model_____

    Power Cord: Material_____ Max. length _____ft (m) Min. Gage_____ Min. Amps_____

    Saddle Clamp Type_____ ☐ N/A

    Other_____

Technique (QF-407)

    Pre-scrape cleaning fluid_____ Post-scrape cleaning agent _____

    Scraping Device_____ Pipe marker type_____

    Other_____