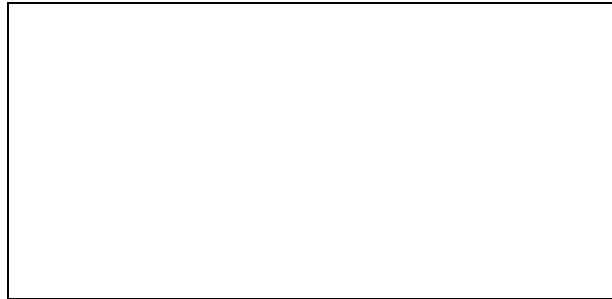


STUD WELDING PROCEDURE SPECIFICATION (WPS) Yes
OR PROCEDURE QUALIFICATION RECORD (PQR) Yes
OR WELDER QUALIFICATION RECORD (WQR) Yes

Company name _____
 Supporting PQR no.(s) _____
 Operator name _____
 Stud material _____
 Material specifications _____
 Weld base diameter _____

Test no. _____
 Revision no. _____ Date _____
 By _____
 Authorized by _____ Date _____

Stud Base Sketch/Application Detail



Base material

Specification _____
 Alloy and temper _____
 Group no. _____ Surface condition HR CR
 Coating _____
 Cleaning method _____
 Decking gage _____

Shape

Flat Round Tube Angle
 Thickness _____

Ferrule

Part no. _____
 Ferrule description _____

Position

Overhead _____ Downhand _____ Sidehand _____
 Angular _____ degrees from normal
 Angle iron _____ Inside radius _____ Heel of angle _____

Shielding gas

Shielding gas(es) _____
 Composition _____
 Flow rate _____

Machine data

Power supply _____
 Make _____ Model _____
 Stud gun model _____
 Weld time Secs. _____ Cycles _____
 Current _____ ±5% OCV _____
 Polarity _____ Lift _____
 Plunge (protrusion) _____
 Weld cable size _____ Length _____
 Number of grounds (workpiece leads) _____

WELD TEST RESULTS

Stud No.	Visual Acceptance	Option #1 Bend Test	Option #2 Tension Test	Option #3 Torque Test*
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				

*Note: Torque test optional for threaded fasteners only.

Mechanical tests conducted by _____ Date _____
 (Company)

We, the undersigned, certify that the statements in this record are correct and the test welds were prepared, welded, and tested in accordance with the requirements of AWS B2.1/B2.1M, (_____), *Specification for Welding Procedure and Performance Qualification*.
 (year)

Signed by _____ Title _____ Date _____
 (Contractor/Applicator)

Source: Adapted from AWS D1.1/D1.1M:2008, *Structural Welding Code—Steel*, Annex N Form N-9, American Welding Society.

Figure F.4—Example of a Welding Procedure Specification and Procedure Qualification Record for Stud Welding