

TOPCOR BELCO

Procedure Qualification Record (PQR)

PQR No.: TopCoreBelco-101-FC/A

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Additional Welding Parameters

Layer(s) and/or Pass(es)	Process	Filler Metal		Current		Voltage Range	Travel Speed Range (in/min)
		AWS Classification	Size (in.)	Type / Polarity	Amperage Range		
2G ROOT	FCAW	E71T-1	0.045	DCEP (reverse)	140	24	5
2G FILL	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	6
2G CAP	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	6.5
2G BW	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	5
3G ROOT	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	4.5
3G FILL	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	5
3G CAP	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	5
3G BW	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	5.5
4G ROOT	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	5
4G FILL	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	7
4G CAP	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	7
4G	FCAW	E71T-1	0.045	DCEP (reverse)	150	24	6.5

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Tensile Test (QW-150)

Specimen No.	Width (in.)	Thickness (in.)	Area (in ²)	Ultimate Total Load (lb)	Ultimate Stress (PSI)	Failure Type and Location
2G-15211	0.750	0.492	0.369	26217	71000	Ductile - BM
2G-15211	0.750	0.490	0.368	25705	69900	Ductile - BM
3G-15211	0.750	0.473	0.355	26080	73500	Ductile - BM
3G-15211	0.750	0.465	0.349	25469	73000	Ductile - BM

Guided Bend Test (QW-160)

Figure Number and Type	Result	Figure Number and Type	Result
QW-462.2 Side bend	Acceptable	QW-462.2 Side bend	Acceptable
QW-462.2 Side bend	Acceptable	QW-462.2 Side bend	Acceptable
QW-462.2 Side bend	Acceptable	QW-462.2 Side bend	Acceptable

Macro-Examination Test: none

Visual Examination: Good

Liquid Penetration Test: Acceptable

RT acceptable see report # G7055 2-3-4

Welder's Name: Vaughn Monroe ID: 90518 Stamp: VM

PQR was done and welding of coupon was witnessed by: TOPCOR BELCO

Tests Conducted By: Larry Boyette Test ID.: 3448

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Code.

Prepared By: _____ 10/27/2005 QA/QC Manager

TOPCORBELCO

Date