

FORM QB-482 SUGGESTED FORMAT FOR A BRAZING PROCEDURE SPECIFICATION (BPS)
(See QB-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

Organization Name _____ By _____
 BPS Number _____ Revision _____ Date Issued _____
 Supporting PQRs _____
 Brazing Process(es) _____ Type(s) _____
(Automatic, Manual, Machine, or Semi-Automatic)

Joint Design (QB-408)

Joint Design: Type _____ Joint Clearance _____
 Overlap: Minimum _____ Maximum _____

Base Metal (QB-402)

P-Number _____
 to P-Number _____
 AWS BM-Number _____
 to AWS BM-Number _____
 Other _____
 Base Metal Thickness
 Minimum _____
 Maximum _____

Brazing Filler Metal (QB-403)

Specification Number _____
 AWS Classification _____
 F-Number _____
 Filler Metal Product Form _____

Brazing Temperature (QB-404)

Brazing Temperature Range _____

Postbrazing Heat Treatment (QB-409)

Temperature Range _____
 Time Range _____

Brazing Flux, Fuel Gas, or Atmosphere (QB-406)

Flux (AWS Class, Composition, or Trade Name) _____
 Fuel Gas _____
 Furnace Temperature _____
 Atmosphere Type _____
 Other _____

Flow Position (QB-407)

Positions Permitted _____
 Flow Direction _____

Technique (QB-410) and Other Information

Initial Cleaning _____

 Flux Application _____
 Nature of Flame (Oxidizing, Neutral, Reducing) _____
 Torch Tip Sizes _____
 Postbrazing Cleaning _____
 Inspection _____