

FORM QF-485 SUGGESTED FORMAT FOR PLASTIC PIPE FUSING DATA ACQUISITION LOG REVIEW
(See QF-131 Section IX, ASME Boiler and Pressure Vessel Code)

Job Information _____ Job Number _____
Fusing Machine Operator Name _____ Fusing Machine Operator Identification _____
FPS or SFPS Used _____ Date _____ Time _____
Fusing Machine Identification _____ Fusing Machine Manufacturer _____ Joint Number _____
Pipe Specification _____ Classification _____ to Specification _____ Classification _____
Pipe Size (Diameter) _____ Pipe Wall Thickness _____ Joint Configuration _____

FUSING VARIABLES

Heater Surface Temperature _____ Within Qualification Range Yes No
Interfacial Fusing Pressure _____ Within Qualification Range Yes No
Drag Pressure _____
Butt-Fusing Pressure: _____ Within Qualification Range Yes No
 Calculated Value _____ Recorded Hydraulic-Fusing Pressure _____ Acceptable Yes No
Butt-Fusing Pressure Drop to Less Than Drag Pressure? Yes No
Gauge Pressure During Initial Heat Cycle _____ Elapsed Time During Initial Heat Cycle _____
Gauge Pressure During Heat-Soak Cycle _____ Elapsed Time During Heat-Soak Cycle _____
Gauge Pressure During Fusing and Cool Cycle _____
Elapsed Time During Fusing and Cool Cycle _____ Within Qualification Range Yes No
Melt Bead Size _____ Within Qualification Range Yes No
Heater Plate Removal Time _____ Within Qualification Range Yes No
Data Logger Probe _____ External Probe _____
Data Acquisition System Manufacturer _____

Review of the Recorded Pressure vs. Time Diagram

Acceptable Yes No

Data Acquisition Acceptable Yes No

Examiner name _____ Examiner signature _____

Date _____