

**FORM QF-483(c) SUGGESTED FORMAT FOR SIDEWALL-FUSING PROCEDURE QUALIFICATION RECORDS (PQR)**  
**[See QF-201.5(d), Section IX, ASME Boiler and Pressure Vessel Code]**

Company Name \_\_\_\_\_

Procedure Qualification Record No. \_\_\_\_\_ Date \_\_\_\_\_

FPS No. \_\_\_\_\_

Fusing Process(es) \_\_\_\_\_

Joints (QF-402)

Fitting Manufacturer \_\_\_\_\_

Material (QF-403)

Fitting Specification \_\_\_\_\_ Classification \_\_\_\_\_  
to Header Specification \_\_\_\_\_ Classification \_\_\_\_\_  
Branch Size (Diameter) \_\_\_\_\_  
Header Size (Diameter) \_\_\_\_\_  
Fitting Projected Base Area/Cross-Sectional Area \_\_\_\_\_  
Other \_\_\_\_\_

Equipment (QF-406)

Fusing Machine Manufacturer \_\_\_\_\_  
\_\_\_\_\_  
Data Acquisition Used  Yes  No  
Data Acquisition System Manufacturer \_\_\_\_\_  
Hydraulic Extension Hose Length \_\_\_\_\_

Position (QF-404)

Position of Header \_\_\_\_\_  
Position of Branch \_\_\_\_\_  
Other \_\_\_\_\_

Technique (QF-407)

Location  Fabrication Shop  Field  
Cleaning Agent or Method \_\_\_\_\_  
Abrasion Method \_\_\_\_\_

Thermal Conditions (QF-405)

Heater Surface Temperature \_\_\_\_\_  
Drag Pressure \_\_\_\_\_  
Initial Heating Interfacial Pressure \_\_\_\_\_  
Time at Pressure \_\_\_\_\_  
Heat Soak Interfacial Pressure \_\_\_\_\_  
Melt Bead Size or Time \_\_\_\_\_  
Heater Plate Removal Time \_\_\_\_\_  
Fusing Pressure \_\_\_\_\_  
Cool-Down Time at Fusing Pressure \_\_\_\_\_  
Other \_\_\_\_\_

Other

**Visual Examination (QF-141)**

**Elevated Temperature Sustained Pressure Tests (QF-142)**

Joint No.	Heater Temperature	Interfacial Pressure	Result

**Impact Resistance Tests (QF-145)**

Joint No.	Spec. No.	Heater Temperature	Interfacial Pressure	Type of Failure	Location of Failure

**Other**

Fusing Operator's Name \_\_\_\_\_ Identification No. \_\_\_\_\_ Stamp No. \_\_\_\_\_

Tests Conducted By \_\_\_\_\_ Laboratory Test No. \_\_\_\_\_

We certify that the statements in this record are correct and that the test joints were prepared, fused, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Organization \_\_\_\_\_

Date \_\_\_\_\_ Certified By \_\_\_\_\_

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)