

**FORM QF-482(a) SUGGESTED FORMAT FOR BUTT-FUSING PROCEDURE SPECIFICATIONS (FPS OR SFPS)**  
**(See QF-201.3, Section IX, ASME Boiler and Pressure Vessel Code)**

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

Fusing Procedure Specification No. \_\_\_\_\_ Date \_\_\_\_\_

Revision No. \_\_\_\_\_ Date \_\_\_\_\_

FPS Qualification  By testing  SFPS If qualified by testing, supporting PQR No.(s) \_\_\_\_\_

Fusing Process Type \_\_\_\_\_

Joints (QF-402)	Details
Joint Type _____	
Pipe End Preparation _____	
Miter Joint Angle _____	
Pipe Surface Alignment _____	
<p>Sketches, production drawings, weld symbols, or written description should show the general arrangement of the parts to be fused. Where applicable, the details of the joint groove may be specified.</p> <p>Sketches may be attached to illustrate joint design.</p>	
Materials (QF-403)	
Specification _____ Classification _____ to Specification _____ Classification _____	
Pipe Size (Diameter) _____ Pipe Wall Thickness _____ Cross-Sectional Area _____	
Other _____	

Position (QF-404)

Pipe Position \_\_\_\_\_

Other \_\_\_\_\_

Thermal Conditions (QF-405)	
Heater Surface Temperature Range _____	
Fusing Interfacial Pressure Range _____	
Drag Pressure Range _____	Butt-Fusing Pressure Range _____
Melt Bead Size Range _____	Heater Plate Removal Time Range _____
Cool-Down Time at Butt-Fusing Pressure Range _____	

Equipment (QF-406)

Fusing Machine Manufacturer \_\_\_\_\_

Data Acquisition Used  Yes  No Data Acquisition Machine Manufacturer \_\_\_\_\_

Hydraulic Extension Hose Length \_\_\_\_\_

Technique (QF-407)

Location  Fabrication Shop  Field

\_\_\_\_\_