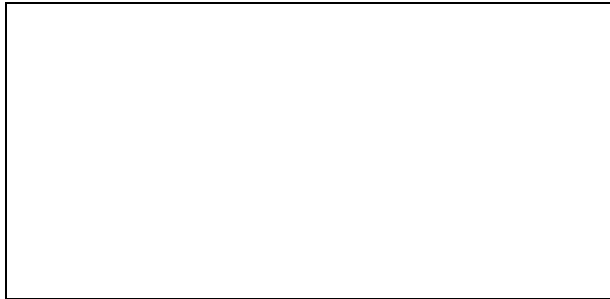


**STUD WELDING PROCEDURE SPECIFICATION (WPS) Yes**   
**OR PROCEDURE QUALIFICATION RECORD (PQR) Yes**   
**OR WELDER QUALIFICATION RECORD (WQR) Yes**

Company name \_\_\_\_\_  
 Supporting PQR no.(s) \_\_\_\_\_  
 Operator name \_\_\_\_\_  
 Stud material \_\_\_\_\_  
 Material specifications \_\_\_\_\_  
 Weld base diameter \_\_\_\_\_

Test no. \_\_\_\_\_  
 Revision no. \_\_\_\_\_ Date \_\_\_\_\_  
 By \_\_\_\_\_  
 Authorized by \_\_\_\_\_ Date \_\_\_\_\_

**Stud Base Sketch/Application Detail**



**Base material**  
 Specification \_\_\_\_\_  
 Alloy and temper \_\_\_\_\_  
 Group no. \_\_\_\_\_ Surface condition HR  CR   
 Coating \_\_\_\_\_  
 Cleaning method \_\_\_\_\_  
 Decking gage \_\_\_\_\_

**Shape**  
 Flat  Round  Tube  Angle   
 Thickness \_\_\_\_\_

**Ferrule**  
 Part no. \_\_\_\_\_  
 Ferrule description \_\_\_\_\_

**Position**  
 Overhead \_\_\_\_\_ Downhand \_\_\_\_\_ Sidehand \_\_\_\_\_  
 Angular \_\_\_\_\_ degrees from normal  
 Angle iron \_\_\_\_\_ Inside radius \_\_\_\_\_ Heel of angle \_\_\_\_\_

**Shielding gas**  
 Shielding gas(es) \_\_\_\_\_  
 Composition \_\_\_\_\_  
 Flow rate \_\_\_\_\_

**Machine data**

Power supply  
 Make \_\_\_\_\_ Model \_\_\_\_\_  
 Stud gun model \_\_\_\_\_  
 Weld time Secs. \_\_\_\_\_ Cycles \_\_\_\_\_  
 Current \_\_\_\_\_ ±5% OCV \_\_\_\_\_  
 Polarity \_\_\_\_\_ Lift \_\_\_\_\_  
 Plunge (protrusion) \_\_\_\_\_  
 Weld cable size \_\_\_\_\_ Length \_\_\_\_\_  
 Number of grounds (workpiece leads) \_\_\_\_\_

**WELD TEST RESULTS**

Stud No.	Visual Acceptance	Option #1 Bend Test	Option #2 Tension Test	Option #3 Torque Test*
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				

\*Note: Torque test optional for threaded fasteners only.

Mechanical tests conducted by \_\_\_\_\_ Date \_\_\_\_\_  
 (Company)

We, the undersigned, certify that the statements in this record are correct and the test welds were prepared, welded, and tested in accordance with the requirements of AWS B2.1/B2.1M, (\_\_\_\_\_), *Specification for Welding Procedure and Performance Qualification*.  
 (year)

Signed by \_\_\_\_\_ Title \_\_\_\_\_ Date \_\_\_\_\_  
 (Contractor/Applicator)

Source: Adapted from AWS D1.1/D1.1M:2008, *Structural Welding Code—Steel*, Annex N Form N-9, American Welding Society.

**Figure F.4—Example of a Welding Procedure Specification and Procedure Qualification Record for Stud Welding**