

STUD WELDING APPLICATION QUALIFICATION TEST DATA FORM PER SUBCLAUSE 7.6 Yes
PRE-PRODUCTION TEST PER SUBCLAUSE 7.7.1 (WPS) Yes
OR PROCEDURE QUALIFICATION RECORD (PQR) Yes
OR WELDER QUALIFICATION RECORD (WQR) Yes

Company name _____
 Operator name _____
 Test number _____
 Weld stud material _____
 Weld stud size and PN#/Manufacturer _____

Base Material

Specification _____
 Alloy and temper _____
 Surface condition HR CR
 Coating _____
 Cleaning method _____
 Decking gage _____

Shape of Base Material

Flat Round Tube
 Angle Inside Outside Inside radius
 Thickness _____

Ferrule

Part No./Manufacturer _____
 Ferrule description _____

Equipment Data

Application Settings, Current, and Time Settings

Make _____ Model _____
 Stud gun: Make _____ Model _____
 Weld time (seconds) _____
 Current (amperage) _____
 Polarity: DCEN _____ DCEP _____
 Lift _____
 Plunge (protrusion) _____
 Weld cable size _____ Length _____
 Number of grounds (workpiece leads) _____

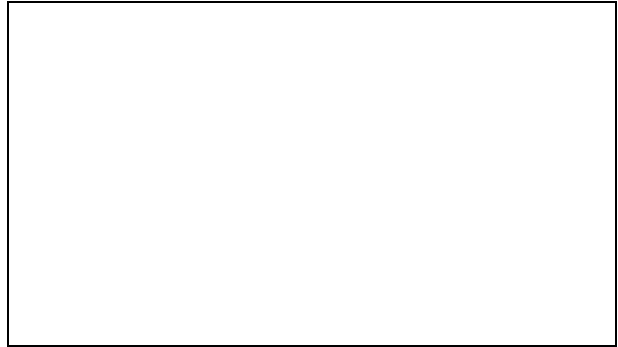
Welding Position

Flat (Down hand) Horizontal (Side hand) Angular—degrees from normal Overhead

Shielding Gas

Shielding gas(es)/Composition _____
 Flow rate _____

Stud Base Sketch/Application Detail



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 _____ (Company) Date _____

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 7 of AWS D1.1/D1.1M, (_____) *Structural Welding Code—Steel*.
 (year)

Signed by _____ Title _____ Date _____
 (Contractor/Applicator/Other)

Form N-9 Company _____