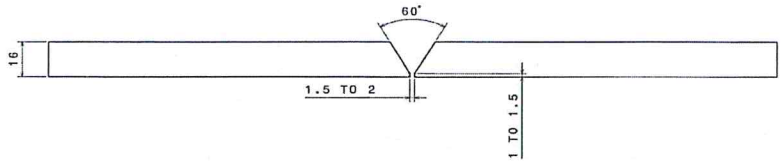
PROCEDUE QUALIFICATION RECORD (PQR)

See QW-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name :	M/s JAYPEE INDIA LIMITED	By	Mr. Prasanta Sardar
Procedure Qualification Record No.	JILD/PQR/GMAW/SV-01	Date	02.03.3036
WPS No.	JILD/WPS/GMAW/SV-01	Date :	
Welding Process (es) :	GMAW		
Type (Manual, Semi-Auto, Machine, Automatic)	MANUAL		

JOINTS (QW-402)



Groove Design of Test Coupon (**Plate thk : 16mm**)

(For combination qualifications, the desposited weld metal thickness shall be recorded for each filler metal or process used)

BASE METALS (QW-403)

Material Spec	IS2062 Gr E 250 BR		
Type or Grade	IS2062 Gr E 250 BR		
P. No.	8 to	P.No.	1
Thickness of Test Coupn	16mm THK		
Thickness of Test Coupn	NA		
Other			

POST WELD HEAT TREATMENT (QW-407)

Temperature	NA
Time	
Other	

GAS (QW-408)

	Gas(es)	(Mixture)	Percent Composition Flow Rate
Shielding	ARGON	99.95%	15 to 20 L/MIN
Trailing	NA		
Backing			

FILLER METALS (QW-404) GMAW

SFA Specification	5.18
AWS Specification	ER 70S-6
Filler Metal F. No.	6
Weld Metal Analysis A No.	1
Size of Filler Metal	Ø 1.2 mm
Other	
Weld Metal Thickness	16 MM

ELECTRICAL CHARACTERISTICS (QW-409)

Current	DC		
Polarity	DCEP (GMAW)		
Amps	100 - 140	Volts	16 - 22
Tungsten Electrode Size	1.2 mm		
Other			

POSITION (QW-405)

Position of Groove	3G
Weld Progression (Uphill / Downhill)	Uphill
Other	

TECHNIQUE (QW-410)

Travel Speed	60 - 70mm /min
String or Weave	STRING & WAVE
Bead	
Oscillation	
Multipass or Single Pass (per side)	MULTIPASS
Single or Multiple Electrodes	Single
Other	

PREHEAT (QW-406)

Preheat Temp.	
Interpass Temp.	
Other	

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06/04/21

PROCEDUE QUALIFICATION RECORD (PQR)

See QW-200.1, Section IX, ASME Boiler and Pressure Vessel Code)

QW-483 (BACK)

PQR No. JILD/PQR/GMAW/SV-01

Tensile Test (QW-150)

Specimen No.	Width mm	Thickness mm	Area (mm²)	Ultimate Total Load K Newtons	Ultimate Unit Stress Mpa	Type of Failure & Location
1	19.60 mm	16 mm	313.6 mm²	140640 N	448 Mpa	Outside the weld
2	19.30 mm	16 mm	308.8 mm²	140216 N	454 Mpa	Outside the weld

Guided Bend Tests (QW-160)

Type and Figure No.	Result
A. Side Bend 4t at 180°	No open weld discontinuity was observed
B. Side Bend 4t at 180°	No open weld discontinuity was observed
C. Side Bend 4t at 180°	No open weld discontinuity was observed
D. Side Bend 4t at 180°	No open weld discontinuity was observed

Tooughness Tests (QW-170)

Specimen No.	Notch Location	Specimen Size	Total Temp.	Impact Values			Drop Weight Break (Y/N)
				Joules	% Shear	Mils	
NA	NA	NA	NA	NA	NA	NA	

Comments

Fillet Weld Test (QW-180)

Result-Satisfactory : Yes No. Penetration into Parent Metal : Yes No.

Macro Results

Type of Test
Deposit Analysis
Other

Welder's Name Mr. Prasanta Sardar Clock No. Stamp No.

Tests Conducted by IRC INDUTRIALRESEARCH & CONSULTANCY PVT . LTD Laboratory Test No. IRC/M6402/2025-26 Dated-04.03.2026

We certify that the statements in this record are correct and the test welds were prepared, welded, and tested in accordance with the Requirements of Section IX of ASME code

Manufacturer M/s JAYPEE INDIA LIMITED

Date : 04.03.2026

by Mr. Raqteem Das (9874454777).

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