

**QB-482 SUGGESTED FORMAT FOR A BRAZING PROCEDURE SPECIFICATION (BPS)**  
**(See QB-200.1, Section IX, ASME Boiler and Pressure Vessel Code)**

Company Name \_\_\_\_\_ By \_\_\_\_\_  
 BPS Number \_\_\_\_\_ Revision \_\_\_\_\_ Date Issued \_\_\_\_\_  
 Supporting PQRs \_\_\_\_\_  
 Brazing Process(es) \_\_\_\_\_ Type(s) \_\_\_\_\_  
(Automatic, Manual, Machine, or  
Semi-Automatic)

**Joint Design (QB-408)**

Joint Design: Type \_\_\_\_\_ Joint Clearance \_\_\_\_\_  
 Overlap: Minimum \_\_\_\_\_ Maximum \_\_\_\_\_

<p align="center"><b>Base Metal (QB-402)</b></p> <p>P/S-Number _____          to P/S-Number _____          Other _____</p> <p>Base Metal Thickness          Minimum _____          Maximum _____</p>	<p align="center"><b>Brazing Filler Metal (QB-403)</b></p> <p>Specification Number _____          AWS Classification _____          F-Number _____          Filler Metal Product Form _____</p>
<p align="center"><b>Postbrazing Heat Treatment (QB-409)</b></p> <p>Temperature Range _____          Time Range _____</p>	<p align="center"><b>Brazing Temperature (QB-404)</b></p> <p>Brazing Temperature Range _____</p>
<p align="center"><b>Flow Position (QB-407)</b></p> <p>Positions Permitted _____          Flow Direction _____</p>	<p align="center"><b>Brazing Flux, Fuel Gas, or Atmosphere (QB-406)</b></p> <p>Flux (AWS Class, Composition, or Trade Name) _____          Fuel Gas _____          Furnace Temperature _____          Atmosphere Type _____          Other _____</p>

**Technique (QB-410) and Other Information**

Initial Cleaning \_\_\_\_\_  
 \_\_\_\_\_

Flux Application \_\_\_\_\_

Nature of Flame (Oxidizing, Neutral, Reducing) \_\_\_\_\_

Torch Tip Sizes \_\_\_\_\_

Postbrazing Cleaning \_\_\_\_\_

Inspection \_\_\_\_\_  
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