Abay Iron & Metal Works

Welder Qualification Test Record (WQTR)

Name Tilahun Wendafrash Clock No. N/A Stamp No. W-1 Retest N/A

Welding Process GMAW (MIG) Type Semi-Automatic

In accordance with welding procedure specification WPS No. AL-01 and PQR No. AL-01

Material Group 3XXX To Group 6XXX Alloy Mg To Si

Thickness of Test Material 3/8

Filler Metal F No. F4043 AWS Class A5.10 Diameter .035

Other

Position Horizontal & Vertical Backing Material Yes

Electrical Characteristics: Current 200-220 A Polarity DCEP

Shielding Gas 100% Argon Flow 25 CFH

For Information Only

Power Source Constant Voltage

(Make, model, type)

Wire Feeder Push-Pull Wire Feeder

Welding Torch Air-cooled

VISUAL INSPECTION (3.6)

Appearance Pass Undercut None observed Piping Porosity None observed

GUIDED BEND TEST RESULTS

Type of Bend	Specimen Thick., in	Bend Jig Fig. No.	Bend Diam., in	Result	Type of Bend	Specimen Thick., in	Bend Jig Fig. No.	Bend Diam., in	Result
2G(Face)	3/8"	4T	1.5	Pass	--	--	--	--	--
2G(Root)	3/8"	4T	1.5	Pass	--	--	--	--	--
3G(Face)	3/8"	4T	1.5	Pass	--	--	--	--	--
3G(Root)	3/8"	4T	1.5	Pass	--	--	--	--	--

Radiographic results: Alternative qualification of groove welds by radiography in accordance with 3.21.6.3 N/A

Test conducted by Laboratory: Test No.

per

FILLET WELD TEST RESULTS

Fracture test Pass/Acceptable

(Describe the location, nature, and size of any crack or tearing of specimen.)

Length and percent of defects N/A Inches N/A %

Appearance: Fillet Size 3/8 in X 3/8 in Convexity or Concavity 1/16 in

Test conducted by Michael Weldeanenia Laboratory: Test No. 2

per AWS D1.2

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of AWS D1.2/D1.2M, *Structural Welding Code—Aluminum.*

Signed Michael MS By Michael Weldeanenia

(Organization)

Date 06/03/2021 Title CWI

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QC1 EXP. 4/1/2023

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