



QW-484A WELDER PERFORMANCE QUALIFICATION (WPQ)

Welder's name _____ Identification no. _____

Test Description

Identification of WPS followed _____ W-GMFCXX-031 ☒ Test coupon ☐ Production weld
Specification and type/grade or UNS Number of base metal(s) _____ P1, Gr2 Thickness _____ 0.552"

Testing Variables and Qualification Limits

Welding Variables (QW-350)

Welding process(es) _____
Type (i.e.; manual, semi-automatic) used _____
Backing (with/without) _____
☐ Plate ☒ Pipe (enter diameter if pipe or tube) _____
Base metal P-Number to P-Number _____
Filler metal or electrode specification(s) (SFA) (info. only) _____
Filler metal or electrode classification(s) (info. only) _____
Filler metal F-Number(s) _____
Consumable insert (GTAW or PAW) _____
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW) _____
Deposit thickness for each process
Process 1 _____ GMAW 3 layers minimum ☐ Yes ☒ No
Process 2 _____ FCAW 3 layers minimum ☒ Yes ☐ No
Position qualified (2G, 6G, 3F, etc.) _____
Vertical progression (uphill or downhill) _____
Type of fuel gas (OFW) _____
Inert gas backing (GTAW, PAW, GMAW) _____
Transfer mode (spray/globular or pulse to short circuit-GMAW) _____
GTAW current type/polarity (AC, DCEP, DCEN) _____

Actual Values GMAW - FCAW

Range Qualified GMAW - FCAW

| | |
|----------------------|----------------------------------|
| Semi-Automatic | Semi-Automatic |
| Without | With/Without |
| 2 7/8" | 2 1/2" to Unlimited |
| P1 to P1 | P-Number P15F, P34, P41 thru P49 |
| 5.28 - 5.29 | N/A |
| ER80S-GT1-T1-Ni1MJH8 | N/A |
| F-6 | F-6 |
| N/A | N/A |
| N/A | N/A |
| 0.185" | n0.206" |
| 150° | n0.900° |
| Uphill & Downhill | All Positions |
| N/A | Uphill & Downhill |
| Without | N/A |
| GMAW-S (STT) | With or Without |
| N/A | GMAW-S (STT) |
| N/A | N/A |

RESULTS

Visual examination of completed weld (QW-302.4) _____ Acceptable
☐ Transverse face and root bends [QW-462.3(a)] ☐ Longitudinal bends [QW-462.3(b)] ☒ Side bends (QW-462.2)
☐ Pipe bend specimen, corrosion-resistant weld metal overlay [QW-462.5(c)]
☐ Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5(d)]
☐ Pipe specimen, macro test for fusion [QW-462.5(b)] ☐ Plate specimen, macro test for fusion [QW-462.5(e)]

| Type | Result | Type | Result | Type | Result |
|---------------|----------|---------------|----------|------|--------|
| Side Bend - 1 | Accepted | Side Bend - 3 | Accepted | | |
| Side Bend - 2 | Accepted | Side Bend - 4 | Accepted | | |

Alternative Volumetric Examination Results (QW-191): _____ RT ☐ or UT ☐ (check one)

Fillet weld — fracture test (QW-181.2) _____ Length and percent of defects _____

☐ Fillet welds in plate [QW-462.4(b)] ☐ Fillet welds in pipe [QW-462.4(c)]

Macro examination (QW-184) _____ Fillet size (in.) _____ × _____ Concavity/convexity (in.) _____

Other tests _____

Film or specimens evaluated by _____ Company _____ Amron Testing

Mechanical tests conducted by _____ Laboratory test no. _____ A20160402-20161010

Welding supervised by _____

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME BOILER AND PRESSURE VESSEL CODE.

Organization _____ Steelcon

Date _____ 10/10/2016

Certified by _____



Justin C Inwood
QW 13101881
QC1 EXP. 10/1/2019





Welder



Welder ID



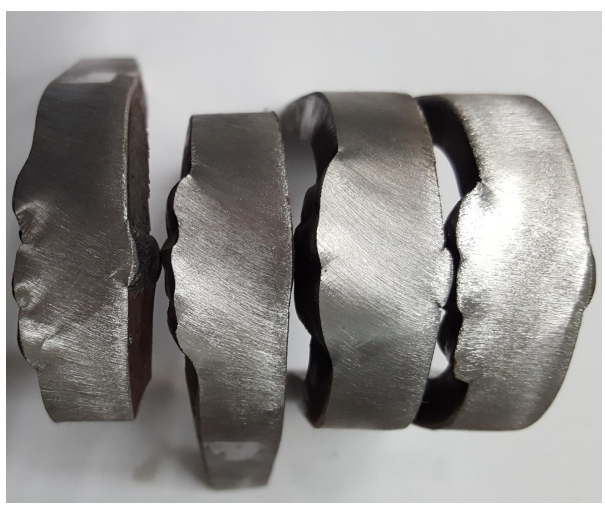
Completed Weld



Machined Samples



Coupon After Bend



Bent Samples