Welder Performance Qualification
Sheet Metal Test Requirements

Developed by
AWS Qualification and Certification Committee

Under the Direction of
AWS Education and Certification Council

Approved by
AWS Board of Directors
April 4, 1994

Abstract
This Supplement C to AWS Standard QC7, Standard for AWS Certified Welder Program, describes testing administered by Accredited Test Facilities to the requirements of AWS QC4-89, Standard for Accreditation of Test Facilities for AWS Certified Welder Program. The welder performance testing for this Supplement was developed using ANSI/AWS D9.1, Sheet Metal Welding Code, as reference.
Statement on Use of AWS Standards

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This standard is subject to revision at any time by the AWS Qualification and Certification Committee. It must be reviewed every five years and if not revised, it must be either reapproved or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are requested and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS Qualification and Certification Committee and the author of the comments will be informed of the Committee's response to the comments. Guests are invited to attend all meetings of the AWS Qualification and Certification Committee to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Qualification and Certification Committee. A copy of these Rules can be obtained from the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126.
## Personnel

**AWS Committee on Qualification and Certification**

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<th>Organization/Company</th>
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<tbody>
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<td>C. E. Pepper, Chairman</td>
<td>Oak Ridge Nat'l Laboratory</td>
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<td>Moraine Valley Community College</td>
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<td>M. L. Houle*</td>
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<td>W. H. Kennedy</td>
<td>Canadian Welding Bureau</td>
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<td>F. G. DeLaurier, Ex-Officio</td>
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<td>L. G. Kvidahl, Ex-Officio</td>
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<td>R. J. Dybas, Ex-Officio</td>
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<tr>
<td>J. C. Paprian, Ex-Officio</td>
<td>Ohio State University</td>
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*Advisor
**AWS Subcommittee on Certification of Welders/Welding Operators**

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<td>Beloit Corporation/Paper Machinery Division</td>
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<td>Strate Welding Supply Company</td>
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<tr>
<td>W. F. Urbick</td>
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*Advisor*
Foreword

(This Foreword is not a part of Supplement C to AWS QC7-93, Standard for AWS Certified Welders, but is included only for information.)

The American Welding Society (AWS) Certified Welder Program is established to identify all elements necessary to implement a National Registry of Certified Welders. Four key elements are identified:

1. Welder performance qualification standards
2. Standard welding procedure specifications
3. Accredited performance qualification test facilities
4. AWS welder certification requirements

Supplement C, Welder Performance Qualification Sheet Metal Test Requirements and AWS QC7-93, Standard for AWS Certified Welders, contain the criteria for AWS Certified Welder Program and the AWS National Registry of Welders. Public listing or disclosure is at the option of the individual welder. It is expected that all four elements outlined above will allow the transfer of welder qualification from employer to employer. This potential transfer of welder qualification can affect financial savings to the welding industry.

The purpose of the QC7-93 is to document the ability of welders to deposit sound welds in accordance with standardized requirements and to impose sufficient controls on the documentation and maintenance of certification to allow transfer between employers without requalification, where allowed by Standard or Contract documents.

Supplement C shall be used in conjunction with AWS QC7-93. This Supplement C is not a standard unto itself and shall be considered only as a supplementary part of AWS QC7-93. The intent of this supplement is to provide welder performance test data to the industry that all employers may use without retesting each welder.

This supplement does not apply to employers that conduct welder qualification tests for their own employees in accordance with ANSI/AWS D9.1, Sheet Metal Welding Code. Supplement C to AWS QC7-93 specifies requirements intended to provide an alternative welders certification method to comply with the requirements of ANSI/AWS D9.1.
# Table of Contents

<table>
<thead>
<tr>
<th>Personnel</th>
<th>iii</th>
</tr>
</thead>
<tbody>
<tr>
<td>Foreword</td>
<td>v</td>
</tr>
</tbody>
</table>

C1. Scope
- C1.1 Program ................................................................. 1
- C1.2 Exclusion ................................................................. 1
- C1.3 Limitation ................................................................. 1
- C1.4 Safety Precautions ...................................................... 1

C2. Definitions ........................................................................ 1

C3. Responsibilities Regarding AWS Certified Welders ............ 1
- C3.1 Employer Responsibility .................................................. 1
- C3.2 Employer Obligation ....................................................... 1
- C3.3 Qualification & Certification Department Responsibilities .................................................................................................................. 2
- C3.4 Test Facility Responsibilities ............................................. 2

C4. Provisions for Testing ....................................................... 2
- C4.1 Welding Procedure Specification (WPS) ............................. 2
- C4.2 Test Facilities ..................................................................... 2

C5. Certification Requisites ..................................................... 2
- C5.1 Test Control ....................................................................... 2
- C5.2 Test Supervisor ................................................................... 2
- C5.3 Test Facility ........................................................................ 2

C6. Performance Test ............................................................... 2
- C6.1 Identification ..................................................................... 2
- C6.2 Verification ......................................................................... 2
- C6.3 Safety Equipment .............................................................. 2
- C6.4 Machine Adjustment ......................................................... 2
- C6.5 Material Check .................................................................. 2
- C6.6 Fit-Up ................................................................................. 2
- C6.7 Assembly Control ............................................................. 2
- C6.8 Positioning ......................................................................... 2
- C6.9 Eye Correction ................................................................... 3
- C6.10 Power Tools ..................................................................... 3

C7. Examination Methods and Acceptance Standards ............. 3

C8. Retests ................................................................................. 3
- C8.1 Immediate Retest .............................................................. 3
- C8.2 Retest After Further Training or Practice .......................... 3

C9. Documentation of Welder Performance Qualification ....... 3

C10. Period of Effectiveness ...................................................... 3
C11. Identification/Certification Documents ................................................................. 3
C12. Maintenance of Certification .............................................................................. 3
C13. Renewal of Certification .................................................................................... 3
C14. Revocation ......................................................................................................... 3

Forms

QC-WF1C — Welder Qualification Test Record ................................................................. 4
QC-WF3A — Maintenance of Certification ................................................................... 5

List of Performance Test Descriptions

C-1 GMAW — 18 Gauge Coated Steel ........................................................................ 6
C-2 GMAW — 18 Gauge Coated Steel ....................................................................... 8
C-3 GMAW — 18 Gauge Coated Steel .......................................................................10
C-4 GMAW — 10 Gauge Coated Steel ......................................................................12
C-5 GMAW — 10 Gauge Coated Steel ......................................................................14
C-6 GMAW — 10 Gauge Coated Steel ......................................................................16
C-7 GMAW — 18 Gauge Stainless Steel ...................................................................18
C-8 GMAW — 18 Gauge Stainless Steel ...................................................................20
C-9 GMAW — 18 Gauge Stainless Steel ...................................................................22
C-10 GMAW — 10 Gauge Stainless Steel ..................................................................24
C-11 GMAW — 10 Gauge Stainless Steel ..................................................................26
C-12 GMAW — 10 Gauge Stainless Steel ..................................................................28
Supplement C
Welder Performance Qualification
Sheet Metal Test Requirements

C1. Scope

This Supplement C to AWS QC7-93, Standard for AWS Certified Welders, specifies requirements intended to provide an alternative welders certification method. The rules for performance qualification are defined in ANSI/AWS D9.1, Sheet Metal Welding Code. When the term certified welder is used it shall also denote "welding operator."

C1.1 Program. The administrative rules for the American Welding Society (AWS) Certified Welder Program and the requirements for maintenance of certification are provided in AWS QC7-93, Standard for AWS Certified Welders. Test facilities participating in the program are required to meet AWS QC4, Standard for Accreditation of Test Facilities for AWS Certified Welder Program.

C1.2 Exclusion. Neither AWS QC7-93 nor this Supplement C prevents or supersedes a Contractor from continuing to qualify welders in accordance with ANSI/AWS D9.1 or other standards. Employers may impose supplementary requirements in addition to this standard.

C1.3 Limitation. Welders participating in the AWS Certified Welder Program shall be limited to those welding essential variables defined in the applicable Performance Tests Descriptions.

C1.4 Safety Precautions. This document is not intended to address safety and health matters regarding the training of certified welders. This document only covers the rules of certification of welders to AWS QC7-93.

C2. Definitions

The terms used in this Supplement C are defined in AWS QC7-93 and ANSI/AWS A3.0, Standard Welding Terms and Definitions, except as follows:

Employer. The term is used collectively to mean contractor, fabricator, erector or manufacturer.

C3. Responsibilities Regarding AWS Certified Welders

C3.1 Employer Responsibility. The employers of AWS Certified Welders are responsible for the work performed by their employees. The employers may accept the AWS certification without additional testing or may add requirements as deemed necessary to meet their particular need.

C3.2 Employer Obligation. Companies who employ AWS certified welders should be fully aware of the provisions of the AWS QC7-93 standard and of this Supplement C.

C3.2.1 Employers should specifically note the extent of qualification as stated on the AWS welder certification card.

C3.2.2 The employer shall obtain a copy of the Performance Qualification Test Record from the AWS Qualification and Certification Department.
C3.2.3 The welder's current status shall be checked with the Qualification and Certification Department.

C3.2.4 The employer shall maintain a record of performance for all welders during their periods of employment. The backup record to be filed with the employer's certification shall be the completed Performance Test Description and Limitation of Variables form prepared by the Accredited Test Facilities. A suggested certification record is shown in Form QC-WFC1, Welder Qualification Test Record.

C3.2.5 The Employer is responsible for all work performed by their employees; and therefore, should verify that the qualification(s) apply to each employee's work.

C3.2.6 The use of these qualifications may require the approval of the Engineer or Owner. The employer shall obtain such approval when required.

C3.3 Qualification and Certification Department Responsibilities. The Qualification and Certification Department shall complete the responsibilities defined in AWS QC7-93, 3.3.

C3.4 Test Facility Responsibilities. The Test Facility is responsible for safety and health matters during testing at that location in addition to other requirements stated herein.

C4. Provisions for Testing

C4.1 Welding Procedure Specification (WPS). The WPSs incorporated in this Supplement C shall be used to qualify welders to this standard. The WPSs in this supplement are for qualification of welders. Production welding procedures shall be provided by employers in accordance with AWS D9.1.

C4.2 Test Facilities. The Test Facilities for this AWS Welder Certification program shall comply with the requirements of AWS QC7-93, 4, Provisions for Testing. The Test Facility shall have been accredited according to AWS QC4, Standard for Accreditation of Test Facilities for AWS Certified Welder Program.

C5. Certification Requisites

C5.1 Test Control

C5.1.1 Performance qualification test coupons shall be welded in accordance with a written WPS and the Performance Test Description.

C5.1.2 Performance Test Descriptions include welding variables and define the limits of qualification for each test.

C5.2 Test Supervisor

C5.2.1 Qualification testing shall be performed under the direction of a person designated as the Test Supervisor in accordance with AWS QC4, Standard for Accreditation of Test Facilities for AWS Certified Welder Program.

C5.2.2 The Test Supervisor shall be responsible for the performance qualification in accordance with this Supplement C.

C5.2.3 If during qualification testing, the Test Supervisor determines that the welder does not exhibit the skill to perform the test satisfactorily, the test may be terminated.

C5.2.4 The Test Supervisor may allow a welder to retest immediately or may require additional training or practice prior to retesting in accordance with AWS QC7, Retests.

C5.2.5 The Test Supervisor shall be responsible for enforcement of test shop safety rules, procedures, and cleanliness, as established by the Test Facility QA Manual.

C5.3 Test Facility. The Test Facility conducts the qualification tests and prepares the test reports. The American Welding Society issues the certification.

C6. Performance Test

C6.1 Identification. The applicant shall be assigned an identification letter, symbol or number, and this identifier shall be marked on the test materials and records.

C6.2 Verification. Prior to the initiation of welding, the applicant's photographic identification shall be verified by the Test Supervisor.

C6.3 Safety Equipment. The applicant shall use personal safety equipment applicable for the welding process. The safety requirements of the Accredited Test Facility shall conform to the requirements of ANSI/ASC Z49.1.

C6.4 Machine Adjustment. Before starting the qualification test, the welder shall adjust the machine settings to meet those of the WPS.

C6.5 Material Check. The base material and filler metal identifications shall be verified by the Test Supervisor prior to tack welding.

C6.6 Fit-Up. The applicant shall assemble the specified test assembly(ies) for welding in accordance with the WPS. The test assembly shall be verified by the Test Supervisor. The Test Supervisor shall inspect each test assembly prior to welding in accordance with AWS D9.1.

C6.7 Assembly Control. The Test Supervisor shall witness the placing of each test assembly in the specified welding position and shall mark the test assembly, or secure it, so that it remains in the specified position until welding has been completed.

C6.8 Positioning. All cleaning, grinding, chipping of slag or other in-process operations shall be performed
with the test assembly in the specified welding position. Evidence of removal of the test assembly or movement from the original location, except by accidental means (subject to concurrence by the Test Supervisor), shall be cause for test termination.

C6.9 Eye Correction. The Test Supervisor shall note the use of and type of eye correction on the Welder Qualification Test Record. The welder’s certification card shall also reflect eye correction use.

C6.10 Power Tools. Any use, or lack of use, of power tools shall be noted on the Welding Qualification Test Record by the Test Supervisor.

C7. Examination Methods and Acceptance Standards

C7.1 All additional tests required by ANSI/AWS D9.1 shall be conducted under the supervision of the Test Supervisor.

C7.2 Visual Examination. The test plates shall meet the visual acceptance criteria for performance testing as defined in ANSI/AWS D9.1. The visual examination shall be performed by a current CWI without aid of magnification.

C8. Retests

If the welder performance test fails to meet the requirements a retest of each test failed may be allowed under the following conditions:

C8.1 Immediate Retest. No more than three immediate retests shall be permitted. The retest specimens shall meet all of the specified requirements.

C8.2 Retest after Further Training or Practice. A retest may be made, provided there is evidence that the welder has had further training or practice. A complete retest of the types and positions failed shall be made.

C9. Documentation of Welder Performance Qualification

The performance qualification data and results of the examination and testing shall be recorded on QC-WF1C. Records of applicants that meet the requirements shall be processed in accordance with AWS QC7-93.

C10. Period of Effectiveness

C10.1 The period of certification is twelve months. The period begins on the date of completion of the examination results and signature by the Test Supervisor. Thereafter, the certification shall be considered as remaining in effect indefinitely unless:

1) the welder is not engaged in a given welding process for which the welder is certified for a period exceeding twelve months unless otherwise specified by ANSI/AWS D9.1, or

2) there is some specific reason to question the welder’s ability.

C10.2 Indefinite certification in accordance with C10 may be maintained by documenting the use of the welding process in accordance with C12, Maintenance of Certification.

C11. Identification/Certification Documents

The welder certification card is issued by AWS in accordance with AWS QC7-93.

C12. Maintenance of Certification

Welders may maintain their certification indefinitely by verifying the use of the welding process(es). The use of the process(es) shall be verified by the welder submitting completed forms required in AWS QC7-93, 11, Maintenance and Certification each year as a minimum. Such forms shall be postmarked prior to the expiration of certification. The certification expiration date is extended for a period of 12 months, as defined in ANSI/AWS D9.1 from the date of the last use of the process(es), as documented on Form QC-WF3A, received and accepted by the AWS Qualification and Certification Department. After the certification period has expired, without the welder using the process, a single test need be made only in any thickness for each process in which the welder is qualified. Successful completion of such test restores all of the previous qualifications for the process tested.

C13. Renewal of Certification

Renewal of certifications shall be in accordance with AWS QC7-93, 12, Renewal of Certification.

C14. Revocation

The AWS Certification of a welder may be revoked in accordance with the administrative procedures defined in AWS QC7-93, 13, Revocation.
## WELDER AND WELDING OPERATOR PERFORMANCE QUALIFICATION TEST RECORD

### Qualification Test Performed

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<tr>
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### Essential Variables Qualified by Test

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<th>Complete fusion</th>
<th>Acceptable</th>
<th>Unacceptable</th>
</tr>
</thead>
<tbody>
<tr>
<td>Complete joint penetration</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maximum face and root reinforcement — 1/8 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>No more than one visible pore per in. of weld</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maximum pore or inclusion size — 0.25 t</td>
<td></td>
<td></td>
</tr>
<tr>
<td>where t = base metal thickness</td>
<td></td>
<td></td>
</tr>
<tr>
<td>No undercut exceeding 0.15 t for t less than or equal to 0.187 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>No undercut exceeding 0.25 t for t greater than 0.187 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>No cracks</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Date Tested</th>
<th>Signed By</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Test Supervisor</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Test Facility</th>
<th>AWS CWI No.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Test Facility No.</th>
<th>Date Signed</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Form QC-WF1C
MAINTENANCE OF CERTIFICATION

Name ____________________________ I.D. # ____________________________

Enter date of last use of each of the following process(es):

SMAW ____________________ FCAW ____________________ GTAW ____________
GMAW ____________________ SAW ____________________ Other ____________

CERTIFICATION IS EXTENDED FROM DATE INDICATED ABOVE

Employer/Test Supervisor/Customer (circle one) Verification: We certify that the above named welder used the processes on the dates indicated.

Print Name __________________________________________________________________________ Title ____________________________

Company Name ________________________________________________________________________ Phone __________________________

Signature ___________________________________________________________________________ Date ___________________________

WE RECOMMEND SENDING "U.S. MAIL, RETURN RECEIPT REQUESTED."

Form QC-WF3A—Maintenance of Certification
AWS QC7-93 Supplement C
Performance Test Description C-1
GMAW 18 Gauge Coated Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A526 CQ G90 or A527 LFQ G90  Coating Type: Galvanized
Material Form: Sheet — 3" x 6"  Thickness: 18 Gauge
Filler Metal: ANSI/AWS A5.18, Class ER-70S-X (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 - 1/2 t. Where t = base metal thickness
Back ing: None
Welding Position(s): 4G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-1-O
Welding Technique: Single pass
Current: dcep
Electrode Extension: 1/4 to 1/2 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Material: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)
Material Form: Sheet
Groove Weld Thickness: 16 Gauge and thinner
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.18, (F Number 6)
Current: dcep
Positions: All groove and fillet
Back ing: With or without
Fillet Weld Size: Unlimited
Shielding Gas: 75% Argon, 25% Carbon dioxide
Vertical Welding Progression: Up or down
Welding Procedure Specification (WPS)

WPS Number C-1 Supported by PQR No.(s) WRC', 047A, 050A, 051B, 052B²
WPS Rev. No. Original WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A526CQ G9Q or A527LFQ G9Q, galvanized
Metal thickness 18 Gauge (0.0516 in., 1.31 mm)
Coating type Galvanized G90
Joint preparation Shall be free of loose scale, rust, grease or foreign matter
Backing material None
Position of welding 4G Overhead Welding Progression: N/A
Welding process GMAW
Manual, semiautomatic, or automatic Semiautomatic
Filler metal spec. ANSI/AWS A5.18
Filler metal class ER70S-X (F Number 6)
Electrical Characteristics deep Electrode Extension 1/4 to 1/2 in.
Mode of transfer Short circuit
Shielding gas/combination 75% Argon, 25% Carbon dioxide
Gas flow (CFH) 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td>0.035</td>
<td>50–130</td>
<td>100–230</td>
</tr>
</tbody>
</table>

Note: Root Opening = 0-1/2t

¹Welding Research Council, 345 East 47th Street, New York, New York 10017.
²Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-2
GMAW 18 Gauge Coated Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A526 CQ G90 or A527 LFQ G90  Coating Type: Galvanized
Material Form: Sheet — 3" x 6"  Thickness: 18 Gauge
Filler Metal: ANSI/AWS A5.18, Class ER-70S-X (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 3G
Vertical Welding Progression: Down
Welding Procedure Specification (WPS) No.: QC7-93, C-2-V
Welding Technique: Single pass
Current: deep  Shielding Gas: 75% Argon, 25% Carbon dioxide
Electrode Extension: 1/4 to 1/2 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)
Material Form: Sheet  Backing: With or without
Groove Weld Thickness: 16 Gauge and thinner  Fillet Weld Size: Unlimited
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.18, (F Number 6)
Current: deep  Shielding Gas: 75% Argon, 25% Carbon dioxide
Positions: Flat, horizontal and vertical groove and fillet  Vertical Welding Progression: Up or down
Welding Procedure Specification (WPS)

WPS Number C-2

Supported by PQR No.(s) WRC\(^1\), 047A, 050A, 051B, 052B\(^2\)

WPS Rev. No. Original

WPS Rev. Date January 1994


Variables

**Base metal** ANSI/ASTM A526CQ G90 or A527LFQ G90, galvanized

**Metal thickness** 18 Gauge (0.0516 in., 1.31 mm)

**Coating type** Galvanized G90

**Joint preparation** Shall be free of loose scale, rust, grease or foreign matter

**Backing material** None

**Position of welding** 3G Vertical

**Welding Progression:** Down

**Welding process** GMAW

Manua1, semiautomatic, or automatic Semiautomatic

**Filler metal spec.** ANSI/AWS A5.18

**Filler metal class** deep

**Electrical Characteristics** deep

**Electrode Extension** 1/4 to 1/2 in.

**Mode of transfer** Short circuit

**Shielding gas/combination** 75% Argon, 25% Carbon dioxide

**Gas flow (CFH)** 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Speed of Travel</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
<td>Voltage Range</td>
</tr>
<tr>
<td>0.035</td>
<td>50–130</td>
<td>100–230</td>
<td>15–17</td>
</tr>
</tbody>
</table>

Note: Root Opening = 0–1/2t

\(^1\)Welding Research Counci1. 345 East 47th Street, New York, New York 10017.

\(^2\)Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-3
GMAW Coated Steel

Code: ANSI/AWS D9.1  
Welding Process: Semiautomatic gas metal arc welding (GMAW)  
Transfer Mode: Short circuiting  
Base Material: ASTM A526 CQ G90 or A527 LFQ G90  
Coating Type: Galvanized  
Material Form: Sheet — 3" x 6"  
Thickness: 18 Gauge  
Filler Metal: ANSI/AWS A5.18, (F Number 6)  
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness  
Backing: None  
Welding Position(s): 1G  
Vertical Welding Progression: Not applicable  
Welding Procedure Specification (WPS) No.: QC7-93, C-3-F  
Welding Technique: Single pass  
Current: deep  
Electrode Extension: 1/4 to 1/2 in.  
Shielding Gas: 75% Argon, 25% Carbon dioxide  
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1  
Welding Process: Gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting  
Base Metal: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)  
Material Form: Sheet  
Groove Weld Thickness: 16 Gauge and thinner  
Pipe and Tubing: Not applicable  
Filler Metal: ANSI/AWS A5.18, (F Number 6)  
Current: deep  
Positions: Flat groove and fillet  
Shielding Gas: 75% Argon, 25% Carbon dioxide  
Vertical Welding Progression: Not applicable  
Backing: With or without  
Fillet Weld Size: Unlimited
Welding Procedure Specification (WPS)

WPS Number C-3 Supports by PQR No. (s) WRC*, 047A, 050A, 051B, 052B
WPS Rev. No. Original WPS Rev. Date January 1994

Variables

- **Base metal**: ANSI/ASTM A526CQ G90 or A527LFQ G90, galvanized
- **Metal thickness**: 18 Gauge (0.0516 in., 1.31 mm)
- **Coating type**: Galvanized G90
- **Joint preparation**: Shall be free of loose scale, rust, grease or foreign matter
- **Backer material**: None
- **Position of welding**: 1G Flat
- **Welding process**: GMAW
- **Manual, semiautomatic, or automatic**: Semiautomatic
- **Filler metal spec.**: ANSI/AWS A5.18
- **Filler metal class**: ER70S-X
- **Electrical Characteristics**: 25% Argon, 75% Carbon dioxide
- **Mode of transfer**: Short circuit
- **Gas flow (CFH)**: 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Voltage Range</th>
<th>Speed of Travel</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
<td>Ampere</td>
<td>ipm</td>
</tr>
<tr>
<td>0.035</td>
<td>50–130</td>
<td>100–230</td>
<td>15–17</td>
<td>As Required</td>
</tr>
</tbody>
</table>

**Note**: Root Opening = 0–1/2t

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*Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-4
GMAW Coated Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A526 CQ G90 or A527 LFQ G90  Coating Type: Galvanized
Material Form: Sheet — 3" x 6"  Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.18, Class ER-70S-X (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 4G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-4-0
Welding Technique: Single pass
Current: deep
Shielding Gas: 75% Argon, 25% Carbon dioxide
Electrode Extension: 1/4 to 1/2 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)
Material Form: Sheet
Groove Weld Thickness: 16 Gauge to 0.276 in.
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.18, (F Number 6)
Current: deep
Positions: All groove and fillet
Backing: With or without
Fillet Weld Size: Unlimited
Shielding Gas: 75% Argon, 25% Carbon dioxide
Vertical Welding Progression: Up or down
Welding Procedure Specification (WPS)

WPS Number C-4  
WPS Rev. No. Original  
Supported by PQR No.(s) WRC', 048A, 049A, 053A, 054B, 055B*  
WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A526CQ G90 or A527LFQ G90, galvanized

Metal thickness 10 Gauge (0.1382 in., 3.51 mm)

Coating type Galvanized G90

Joint preparation Shall be free of loose scale, rust, grease or foreign matter

Backing material None

Position of welding 4G Overhead  
Weiding Progression: N/A

Weiding process GMAW

Manual, semiautomatic, or automatic Semiautomatic

Filler metal spec. ANSI/AWS A5.18

Filler metal class ER70S-X

Electrical Characteristics deep Electrode Extension 1/4 to 1/2 in.

Mode of transfer Short circuit

Shielding gas/combination 75% Argon, 25% Carbon dioxide

Gas flow (CFH) 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td>0.035</td>
<td>75–150</td>
<td>120–280</td>
</tr>
</tbody>
</table>

*Solder Research Council, 345 East 47th Street, New York, New York 10017.
*Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-5
GMAW Coated Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A526 CQ G90 or A527 LFQ G90  Coating Type: Galvanized
Material Form: Sheet — 3" x 6"  Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.18, Class ER-70S-X (F Number 6)
Weld Joint Detail: square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 3G
Vertical Welding Progression: Down
Welding Procedure Specification (WPS) No.: QC7-93, C-5-V
Welding Technique: Single pass
Current: ddeep
Electrode Extension: 1/4 to 1/2 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas metal arc welding (GMAW) — semiautomatic/Automatic transfer mode — short circuiting
Base Metal: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)
Material Form: Sheet  Backing: With or without
Groove Weld Thickness: 16 Gauge to 0.276 in.  Fillet Weld Size: Unlimited
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.18, (F Number 6)
Current: ddeep
Positions: Flat, horizontal and vertical groove and fillet
Shielding Gas: 75% Argon, 25% Carbon dioxide
Vertical Welding Progression: Up or down
Welding Procedure Specification (WPS)

WPS Number C-5 Supported by PQR No.(s) WRC', 048A, 049A, 053A, 054B, 055B

WPS Rev. No. Original WPS Rev. Date January 1994


Variables

- **Base metal**: ANSI/ASTM A526CQ G90 or A527LFQ G90, galvanized
- **Metal thickness**: 10 Gauge (0.1382 in., 1.31 mm)
- **Coating type**: Galvanized G90
- **Joint preparation**: Shall be free of loose scale, rust, grease or foreign matter
- **Backing material**: None
- **Position of welding**: 3G Vertical
- **Welding Progression**: Down
- **Welding process**: GMAW
- **Mode of transfer**: Short circuit
- **Electrode Extension**: 1/4 to 1/2 in
- **Shielding gas/combination**: 75% Argon, 25% Carbon dioxide
- **Gas flow (CFH)**: 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size in.</th>
<th>Welding Power</th>
<th>Speed of Travel</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.035</td>
<td>Current Range</td>
<td>Ampere, 120–280</td>
<td>18–20</td>
</tr>
<tr>
<td></td>
<td>Wire Feed Speed (Reference)</td>
<td>Volts</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Voltage Range</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Voltage Range</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Note: Root Opening = 0-1/2t

1Welding Research Council, 345 East 47th Street, New York, New York 10017.
2Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-6
GMAW Coated Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW) Transfer Mode: Short circuiting
Base Material: ASTM A526 CQ G90 or A527 LFQ G90 Coating Type: Galvanized
Material Form: Sheet — 3" x 6" Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.18, Class ER-70S-X (F Number 6)
Weld Joint Detail: square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 1G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-6-F
Welding Technique: Single pass
Current: deep Shielding Gas: 75% Argon, 25% Carbon dioxide
Electrode Extension: 1/4 to 1/2 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas Metal Arc Welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Galvanized or uncoated carbon steel (See ANSI/AWS D9.1)
Material Form: Sheet Backing: With or Without
Groove Weld Thickness: 16 Gauge to 0.276 in. Fillet Weld Size: Unlimited
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.18, (F Number 6)
Current: deep Shielding Gas: 75% Argon, 25% Carbon dioxide
Positions: Flat groove and fillet Vertical Welding Progression: Not applicable
**Welding Procedure Specification (WPS)**

WPS Number C-6 Supported by PQR No.(s) WRC: 048A, 049A, 053A, 054B, 055B*

WPS Rev. No. Original WPS Rev. Date January 1994


**Variables**

**Base metal** ANSI/ASTM A526CQ G90 or A527LFQ G90, galvanized

**Metal thickness** 10 Gauge (0.1382 in., 3.51 mm)

**Coating type** Galvanized G90

**Joint preparation** Shall be free of loose scale, rust, grease or foreign matter

**Backin material** None

**Position of welding** 1G Flat  **Welding Progression:** N/A

**Welding process** GMAW

**Manual, semiautomatic, or automatic** Semiautomatic

**Filler metal spec.** ANSI/AWS A5.18

**Filler metal class** ER70S-X

**Electrical Characteristics** deep  **Electrode Extension** 1/4 to 1/2 in.

**Mode of transfer** Short circuit

**Shielding gas/combination** 75% Argon, 25% Carbon dioxide

**Gas flow (CFH)** 20–40 CFH

**Joining Procedure**

<table>
<thead>
<tr>
<th>Filler Metal Size (in.)</th>
<th>Welding Power</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Current Range</td>
</tr>
<tr>
<td>0.035</td>
<td>75–150</td>
</tr>
</tbody>
</table>

**Note:** Root Opening = 0-1/2t

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*Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-7
GMAW Stainless Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A167 or A240, Type 3xx  Coating Type: None
Material Form: Sheet — 3" x 6"  Thickness: 18 Gauge
Filler Metal: ANSI/AWS A5.9, Class ER-3xx (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 4G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-7-0
Welding Technique: Single pass
Current: deep  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Electrode Extension: 1/4 to 3/8 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Chromium and chromium nickel steel (uncoated) (See ANSI/AWS D9.1)
Material Form: Sheet  Backing: With or without
Groove Weld Thickness: 16 Gauge and thinner  Fillet Weld Size: Unlimited
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.9, (F Number 6)  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Current: deep
Positions: All groove and fillet
Vertical Welding Progression: Up or down
Welding Procedure Specification (WPS)

WPS Number C-7

Supported by PQR No.(s) WRC*, 068A, 070A, 074A, 075B, 076A

WPS Rev. No. Original

WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A167 or A240 type 3XX

Metal thickness 18 Gauge (0.0500 in., 1.27 mm)

Coating type None

Joint preparation Shall be free of loose scale, rust, grease or foreign matter

Backing material None

Position of welding 4G Overhead Welding Progression: N/A

Welding process GMAW

Manual, semiautomatic, or automatic Semiautomatic

Filler metal spec. ANSI/AWS A5.9

Filler metal class ER-3XX

Electrical Characteristics deep Electrode Extension 1/4 to 3/8 in.

Mode of transfer Short circuit

Shielding gas/combo 90% Helium, 7.5% Argon, 2.5% Carbon dioxide

Gas flow (CFH) 20-40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Current Range</th>
<th>Wire Feed Speed (Reference)</th>
<th>Voltage Range</th>
<th>Speed of Travel</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Ampere</td>
<td>ipm</td>
<td>Volts</td>
<td></td>
<td></td>
</tr>
<tr>
<td>0.035</td>
<td>60–100</td>
<td>120–210</td>
<td>16–19</td>
<td>As Required</td>
<td></td>
</tr>
</tbody>
</table>

Note: Root Opening = 0-1/2t


*Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C  
Performance Test Description C-8  
GMAW Stainless Steel

**Code:** ANSI/AWS D9.1  
**Welding Process:** Semiautomatic gas metal arc welding (GMAW)  
**Transfer Mode:** Short circuiting  
**Base Material:** ASTM A167 or A240, Type 3XX  
**Coating Type:** None  
**Material Form:** Sheet — 3" x 6"  
**Thickness:** 18 Gauge  
**Filler Metal:** ANSI/AWS A5.9, Class ER-3XX (F Number 6)  
**Weld Joint Detail:** Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness  
**Backing:** None  
**Welding Position(s):** 2G  
**Vertical Welding Progression:** Down  
**Welding Procedure Specification (WPS) No.:** QC7-93, C-8-V  
**Welding Technique:** Single pass  
**Current:** deep  
**Shielding Gas:** 90% Helium, 7.5% Argon, 2.5% Carbon dioxide  
**Electrode Extension:** 1/4 to 3/8 in.  
**Test Required:** Visual inspection per ANSI/AWS D9.1

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**Limits of Welder Qualification**

**Code:** ANSI/AWS D9.1  
**Welding Process:** gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — Short circuiting  
**Base Metal:** Chromium and chromium nickel steel (See ANSI/AWS D9.1)  
**Material Form:** Sheet  
**Groove Weld Thickness:** 16 Gauge and thinner  
**Backing:** With or without  
**Pipe and Tubing:** Not applicable  
**Fillet Weld Size:** Unlimited  
**Filler Metal:** ANSI/AWS A5.9, (F Number 6)  
**Current:** deep  
**Shielding Gas:** 90% Helium, 7.5% Argon, 2.5% Carbon dioxide  
**Positions:** Flat, horizontal and vertical groove and fillet  
**Vertical Welding Progression:** Up or Down
Welding Procedure Specification (WPS)

WPS Number C-8 Supported by PQR No.(s) WRC', 068A, 070A, 074A, 075A, 076A'
WPS Rev. No. Original WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A167 or A240 Type 3XX
Metal thickness 18 Gauge (0.0500 in., 1.27 mm)
Coating type None
Joint preparation Shall be free of loose scale, rust, grease or foreign matter
Back ing material None
Position of welding 3G Vertical Welding Progression: Down
Welding process GMAW
Manual, semiautomatic, or automatic Semiautomatic
Filler metal spec. ANSI/AWS A5.9
Filler metal class ER-3XX
Electrical Characteristics dcep Electrode Extension 1/4 to 3/8 in.
Mode of transfer Short circuit
Shielding gas/combination 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Gas flow (CFH) 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size in.</th>
<th>Welding Power</th>
<th>Junction Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td>0.035</td>
<td>60–100</td>
<td>120–210</td>
</tr>
</tbody>
</table>

Note: Root Opening = 0-1/2t

\(^1\)Welding Research Council, 345 East 47th Street, New York, New York 10017.
\(^2\)Also on file at AWS Headquarters (Qualification and Certification Dept.)
AWS QC7-93 Supplement C
Performance Test Description C-9
GMAW Stainless Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW) Transfer Mode: Short circuiting
Base Material: ASTM A167 or A240 Type 3XX Coating Type: None
Material Form: Sheet — 3" x 6" Thickness: 18 Gauge
Filler Metal: ANSI/AWS A5.9, Class ER-3XX (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 1G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-9-F
Welding Technique: Single pass
Current: dcep Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Electrode Extension: 1/4 to 3/8 in.
Test Required: Visual inspection per ANSI/AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Chromium to chromium nickel steel (uncoated) (See ANSI/AWS D9.1)
Material Form: Sheet
Groove Weld Thickness: 16 Gauge and thinner Backing: With or without
Pipe and Tubing: Not applicable Fillet Weld Size: Unlimited
Filler Metal: ANSI/AWS A5.9, (F Number 6)
Current: dcep Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Positions: Flat groove and fillet Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS)

WPS Number: C-9  Supported by PQR No.(s) WRC1, 068A, 070A, 074A, 075A, 076A2
WPS Rev. No. Original  WPS Rev. Date: January 1994


Variables

Base metal: ANSI/ASTM A167 or A240 Type 3XX
Metal thickness: 18 Gauge (0.0500 in., 1.27 mm)
Coating type: None
Joint preparation: Shall be free of loose scale, rust, grease or foreign matter
Backing material: None
Position of welding: 1G Flat  Welding Progression: N/A
Welding process: GMAW
Manual, semiautomatic, or automatic: Semiautomatic
Filler metal spec.: ANSI/AWS A5.9
Filler metal class: ER-3XX
Electrical Characteristics: deep
Mode of transfer: Short circuit
Shielding gas/combination: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Gas flow (CFH): 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td>0.035 in.</td>
<td>60–100</td>
<td>120–210</td>
</tr>
</tbody>
</table>

Note: Root Opening = 0–1/2t

2Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7 Supplement C
Performance Test Description C-10
GMAW Stainless Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A167 or A240 Type 3XX  Coating Type: None
Material Form: Sheet — 3" x 6"  Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.9, Class ER-3XX (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 4G
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-10-O
Welding Technique: Single pass
Current: deep  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Electrode Extension: 1/4 to 3/8 in.
Test Required: Visual inspection per AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: Gas metal arc welding (GMAW) — Semiautomatic/automatic transfer mode — short circuiting
Base Metal: Chromium and chromium nickel steel (See ANSI/AWS D9.1)
Material Form: Sheet  Backing: With or without
Groove Weld Thickness: 16 Gauge to 0.281 in.  Fillet Weld Size: Unlimited
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.9, (F Number 6)
Current: deep  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Positions: All groove and fillet  Vertical Welding Progression: Up or Down
Welding Procedure Specification (WPS)

WPS Number C-10
Supported by PQR No(s) WRC'071B, 072B, 073A, 077A, 078A, 079A'
WPS Rev. No. Original
WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A167 or A240, Type 3XX
Metal thickness 10 Gauge (0.1406 in., 2.57 mm)
Coating type None
Joint preparation Shall be free of loose scale, rust, grease or foreign matter
Backing material None
Position of welding 4G Overhead Welding Progression: N/A
We ding process GMAW Manual, semiautomatic, or automatic Semiautomatic
Filler metal spec. ANSI/AWS A5.9 Filler metal class ER3XX
Electrical Characteristics deep Electrode Extension 1/4 to 3/8 in.
Mode of transfer Short circuit
Shielding gas/combination 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Gas flow (CFH) 20–40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Welding Power</th>
<th>Welding Power</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td></td>
<td>Ampere</td>
<td>ipm</td>
</tr>
<tr>
<td>0.035</td>
<td>100–150</td>
<td>210–330</td>
</tr>
</tbody>
</table>

![Root Opening Diagram]

- Root Opening = 0-1/2t

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2. Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C
Performance Test Description C-11
GMAW Stainless Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  Transfer Mode: Short circuiting
Base Material: ASTM A167 or A240 Type 3XX  Coating Type: None
Material Form: Sheet — 3" x 6"  Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.9, Class ER-3XX (F Number 6)
Weld Joint Detail: Square butt, root opening (R) = 0 - 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 3G
Vertical Welding Progression: Down
Welding Procedure Specification (WPS) No.: QC7-93, C-11-V
Welding Technique: Single pass
Current: deep  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Electrode Extension: 1/4 to 3/8 in.
Test Required: Visual inspection per AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Chromium and chromium nickel steel (See ANSI/AWS D9.1)
Material Form: Sheet
Groove Weld Thickness: 16 Gauge to 0.281 in.
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.9, (F Number 6)
Current: deep  Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Positions: Flat, horizontal and vertical groove and fillet  Vertical Welding Progression: Up or Down
Back: With or without  Fillet Weld Size: Unlimited
Welding Procedure Specification (WPS)

WPS Number C-11

Supported by PQR No.(s) WRC .071B, 072B, 073A, 077A, 078A, 079A

WPS Rev. No. Original

WPS Rev. Date January 1994


Variables

Base metal ANSI/ASTM A167 or A240, Type 3XX

Metal thickness 10 Gauge (0.1406 in., 2.57 mm)

Coating type None

Joint preparation Shall be free of loose scale, rust, grease or foreign matter

Backing material None

Position of welding 3G Vertical Welding Progression: Down

Welding process GMAW

Manual, semi-automatic, or automatic Semi-automatic

Filler metal spec. ANSI/AWS A5.9

Filler metal class ER3XX

Electrical Characteristics deep Electrode Extension 1/4 to 3/8 in.

Mode of transfer Short circuit

Shielding gas/combination 90% Helium, 7.5% Argon, 2.5% Carbon dioxide

Gas flow (CFH) 20-40 CFH

Joining Procedure

<table>
<thead>
<tr>
<th>Filler Metal Size</th>
<th>Filler Metal</th>
<th>Welding Power</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>Current Range</td>
<td>Wire Feed Speed (Reference)</td>
</tr>
<tr>
<td>in.</td>
<td>Ampere</td>
<td>ipm</td>
</tr>
<tr>
<td>0.035</td>
<td>100-150</td>
<td>210-330</td>
</tr>
</tbody>
</table>

Note: Root Opening = 0-1/2t


*Also on file at AWS Headquarters (Qualification and Certification Dept.).
AWS QC7-93 Supplement C  
Performance Test Description C-12  
GMAW Stainless Steel

Code: ANSI/AWS D9.1
Welding Process: Semiautomatic gas metal arc welding (GMAW)  
Transfer Mode: Short circuiting
Base Material: ASTM A167 or A240 Type 3XX  
Coating Type: None
Material Form: Sheet — 3" x 6"  
Thickness: 10 Gauge
Filler Metal: ANSI/AWS A5.9, Class ER-3XX (F Number 6)
Weld Joint Detail: square butt, root opening (R) = 0 – 1/2 t. Where t = base metal thickness
Backing: None
Welding Position(s): 1G (Flat, See AWS D9.1, Fig 2 (A))
Vertical Welding Progression: Not applicable
Welding Procedure Specification (WPS) No.: QC7-93, C-12-F
Welding Technique: Single pass
Current: deep  
Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Electrode Extension: 1/4 to 3/8 in.
Test Required: Visual inspection per AWS D9.1

Limits of Welder Qualification

Code: ANSI/AWS D9.1
Welding Process: gas metal arc welding (GMAW) — semiautomatic/automatic transfer mode — short circuiting
Base Metal: Chromium and chromium nickel steel (See ANSI/AWS D9.1)
Material Form: Sheet
Groove Weld Thickness: 16 Gauge to 0.281
Pipe and Tubing: Not applicable
Filler Metal: ANSI/AWS A5.9, (F Number 6)
Current: deep  
Shielding Gas: 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Positions: Flat groove and fillet

Backng: With or without
Fillet Weld Size: Unlimited

Vertical Welding Progression: Not applicable
WPS Number C-12
WPS Rev. No. Original

Variables

Base metal ANSI/ASTM A167 or A240, Type 3XX
Metal thickness 10 Gauge (0.1406 in., 2.57 mm)
Coating type None
Joint preparation Shall be free of loose scale, rust, grease or foreign matter
Backing material None
Position of welding 1G Flat
Welding Progression: N/A
Welding process GMAW
Manual, semiautomatic, or automatic Semiautomatic
Filler metal spec. ANSI/AWS A5.9
Filler metal class ER3XX

Electrical Characteristics
Mode of transfer Short circuit
Shielding gas/combination 90% Helium, 7.5% Argon, 2.5% Carbon dioxide
Gas flow (CFH) 20–40 CFH

Joining Procedure

| Filler Metal Size | Welding Power | | | |
|------------------|---------------|---------------|---------------|---------------|---------------|
| in.              | Current Range | Wire Feed Speed (Reference) | Voltage Range | Speed of Travel | Joint Detail |
|                  | Ampere       | ipm           | Volts         |               |               |
| 0.035            | 100–150      | 210–330       | 16–20         | As Required   |               |

Note: Root Opening = 0–1/2t

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1Welding Research Council, 345 East 47th Street, New York, New York 10017
2Also on file at AWS Headquarters (Qualification and Certification Dept.)