**WELDER, WELDING OPERATOR, OR TACK WELDER**

**PERFORMANCE QUALIFICATION RECORD – AWS D1.1**

|  |  |  |  |
| --- | --- | --- | --- |
| Name |  | Test Date |  |
| ID Number |  | Standard Test # | **WPQR-001** |
| Stamp |  | WPS # | **WPS-D1.1-001** |
| Company |  | Qualified to | **AWS D1.1-2015** |

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| **BASE METALS** | Specification | Type or Grade | AWS Group # | Size  (NPS) | Schedule | Thickness | Diameter |
| Base Material | A500 | B | I | NA | NA | 3/8” | NA |
| Welded To | A572 | 55 | II | NA | NA | 3/8” | NA |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **VARIABLES** | **ACTUAL VALUES** | | **RANGE QUALIFIED** | |
| **Type of Weld Joint** | 1G – Figure 4.20 | | Groove, Fillet, Plug and Slot Welds (T, Y, K Connections PJP ONLY) | |
| **Base Metal** | Group I to Group II | | Any AWS D1.1 Qualified Base Metal | |
|  | Groove | Fillet | Groove | Fillet |
| **Plate Thickness** | 3/8” | NA | 1/8” – 3/4" (PJP Unlimited) | Unlimited |
| **Pipe/Tube Thickness** | NA | NA | 1/8” – 3/4" (PJP Unlimited) | Unlimited |
| **Pipe Diameter** | NA | NA | 24” Diameter and up with restrictions – See Table 4.10 | Unlimited |
| **Welding Process** | GMAW | | GMAW | |
| Type (Manual, Semi-automatic, Mechanized, Automatic) | Semi-Automatic | | Semi-Automatic, Mechanized, Automatic | |
| Backing | With | | With | |
| **Filler Metal (AWS Spec)** | A5.18 | | A5.XX | |
| AWS Classification | ER70S-3 | | All | |
| F-Number | NA | | NA | |
| **Position** | 1G | |  | |
| Groove – Plate & Pipe **>** 24” |  | | F | |
| Groove – Pipe < 24” |  | | Not Qualified | |
| Fillet – Plate & Pipe > 24” |  | | F, H | |
| Fillet – Pipe < 24” |  | | F, H | |
| **Vertical Progression** | NA | | NA | |
| **GMAW Transfer Mode** | Spray | | Spray | |
| **Single or Multiple Electrodes** | Single | | Single | |
| **Gas/Flux Type** | A5.18 SG-AC-10 | | A5.XX Approved | |

**Test Results**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Type of Test** | | **Acceptance Criteria** | | **Results** | **Remarks** | |
| **Visual Examination Per 4.9.1** | | **4.9.1.1** | |  |  | |
| **1 Root Bend Per 4.9.3.1** | | **4.9.3.3** | |  |  | |
| **1 Face Bend Per 4.9.3.1** | | **4.9.3.3** | |  |  | |
|  | |  | |  |  | |
|  | |  | |  |  | |
| **Test Prepared By** | **Welding Witnessed By** | | **Non-destructive Testing By** | | | **Destructive Testing By** |
|  |  | | NA | | |  |

We, the undersigned, 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 *Clause 4 of* *AWS D1.1/D1.1M – 2015 Structural Welding Code – Steel.*

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| --- | --- | --- | --- |
| Examiner | **\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_** | On Behalf of |  |
|  |  | Date | \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ |