

Welding Inspection Services

ASME Section IX - Welder Performance Qualification (WPQ)

Weldoffice WPQ

Welder's name	Bubba Gump		Test date	1/8/2009
ID Number	IDBG		WPQ record number	BG005
Date of birth			Standard test number	SM1-1.1
Stamp number	BG		WPS record number	SM1-1.1WPQ
Company name	Welding Inspection Services		Qualification code	ASME Section IX
Division	Weld test Lab Rangers			

BASE METALS (QW-403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick.	(in.)	Dia. (in.)
Welded to:	Pipe	A-106 (B)	S1	SG1	6	XS	0.432		6.625
	Pipe	A-106 (B)	S1	SG1	6	XS	0.432		6.625
Joint type	Groove								

VARIABLES

	Actual values	RANGE QUALIFIED
Type of weld joint	Pipe - Groove	Groove and Fillet welds (CRO for WPS w/o chem. specified)
Base metal	S1 to S1	P-no./S-no. 1 thru 11, 34, 41 thru 49

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	-	-	-	no limit	no limit	0.432 min
Pipe/tube thickness (in.)	0.432	-	-	no limit	no limit	0.432 min
Pipe diameter (in.)	6.625	-	-	2.875 min	no limit	no limit

PROCESS VARIABLES

	Actual values		RANGE QUALIFIED	
Welding process	SMAW	SMAW	SMAW	SMAW
Type	Manual	Manual	Manual	Manual
Backing	None	With	With, without	With
Filler metal specification	5.1	5.1	5.xx	5.xx
Filler metal classification	E6010	E7018	Any	Any
Filler metal F-number	3	4	3(1..3 w/backing)	1..4
Number of layers deposited	2	3		
Weld deposit thickness (in.)	0.132	.3	0.264 max	0.6 max
Weld position	6G	6G		
			All	All
(Actual position tested)			All	All
Groove - Plate & Pipe >24"			-	-
Groove - Pipe 2.875" to 24"			All	All
Groove - Pipe < 2.875"			All	All
Fillet - Plate & Pipe >24"			All	All
Fillet - Pipe 2.875" to 24"			All	All
Fillet - Pipe < 2.875"			All	All
Progression	Up	Up	Up	Up

TESTS

Type of test	Acceptance criteria	Result	Comments
4 transverse side bends per QW-161.1, QW-463.2(e) and QW-462.2	QW-163 (incl. CRO)	Acceptable	see - ASME IX - QW-452.1 (a) Note (1)
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 (a)

Notes

CERTIFICATION

Tests conducted by	Test Conducted By 1	Laboratory test number	OU812
Mechanical tests by	Mech Testing By 1	Test file number	IM1Ru

We certify that the special secret welderqual requirements agreed upon but the mighty welding gurus have been met or exceeded during the welding, inspection, preparation and documentation of this welder test.

Signature 1

Name	Signature
Gerald Austin	<i>Your Signature</i>
Date	
1/8/2009	

Signature 2

Name	Signature
Gerald Austin	<i>Your Signature</i>
Date	
1/8/2009	

Signature 3

Name	Signature
Gerald Austin	<i>Your Signature</i>
Date	
1/8/2009	

Signature 4

Name	Signature
Gerald Austin	<i>Your Signature</i>
Date	
1/8/2009	