

Welder Performance Qualification (WPQ)

ASME Boiler and Pressure Vessel Code, Section IX, QW-301

Company Name: WPSAmerica.com
 Company Address: info@WPSAmerica.com, 1 (877) WPS-WELD

Welder Performance Qualification WPQ No. **DEMO-WPQ** Test Date: **12,12, 2005**
 Welding Procedure Specification WPS No. **DEMO-WPS** Rev. **0**

Welder's Name: **Elvis Tom Jones** Identification No: **ETJ-2005** Stamp No: **ETJ-05**

BASE METALS (QW-403)

P-No: 1	Group No: 1	Material Specification: SA-36	Type or Grade: UNS No. K02600
Welded to			
P-No: 1	Group No: 1	Material Specification: SA-36	Type or Grade: UNS No. K02600

Thickness in (mm): 1/2 in. (13 mm)

Test Coupon
 Production Weld
 Plate
 Pipe

Base Metals Thickness Qualified: No Limit

Welding Variables (QW-350) **Actual Values** **Range Qualified**

Diameter, if pipe or tube, in (mm)	Plate tested	2-7/8 in. (73 mm) OD and over
Backing	Without backing	With or without backing
Base Metals P-Number to P-Number	1 to 1	P-No. 1 thru 15F, 34, 41 thru 49

	1st Process	2nd Process	1st Process	2nd Process
Welding Process	GMAW	SMAW	GMAW	SMAW
Process Type	Semi-Automatic	Manual	Semi-Automatic	Manual
Testing Position	3G	3G		
Vertical Progression	Uphill	Uphill	Uphill	Uphill

Welding Positions Qualified:

(A) Groove, Plate and Pipe over 24 in. (610 mm) OD	F, V	F, V
(B) Groove, Pipe 2-7/8 in. (73 mm)* to 24 in. (610 mm) OD, incl. [*or Min. qualified diameter, if testing small pipe]	F	F
(C) Fillet, Plate and Pipe for all thicknesses, fillet sizes, and diameters [when testing Groove] OR		
(C) Fillet, Plate and Pipe 2-7/8 in. (73 mm) OD and over [when testing Plate Fillet] OR	F, H, V	F, H, V

(C) Fillet, Plate and Pipe within qualified diameter range [when testing Pipe Fillet]

Filler Metal Specification (SFA)	SFA 5.18	SFA 5.1		
Filler Metal Classification	ER70S-6	E7018		
Filler Metal F-Number	6	4	6	1 to 4
Filler Metal Product Type (GTAW, PAW)	n/a	n/a	n/a	n/a
Deposited Weld Thickness, in (mm)	1/8 in. (3 mm)	3/8 in. (10 mm)	1/4 in. (6 mm)	3/4 in. (20 mm)
Consumable Insert (GTAW, PAW)			n/a	n/a
GMAW Transfer Mode	Short Circuit	n/a	Short Circuit	n/a
GTAW Current Type/Polarity	n/a	n/a	n/a	n/a
Inert Gas Backing (GTAW, PAW, GMAW)	none	n/a	with or without	n/a
Type of Fuel Gas (OFW)	n/a	n/a	n/a	n/a

Results

Visual Examination of Completed Weld Result (QW-302.4): Acceptable criteria as per ASME QW-194

Guided-Bend Tests Type (QW-160): Transverse Side Bend Specimens (QW-462.2)

Alternative Volumetric Examination Results (QW-191): n/a RT or UT :

Result and Comments: Two side bend tests were examined as per ASME QW-462.2. Acceptable criteria as per ASME QW-163

Fillet-Weld Tests (QW-180): Plate [QW-462.4(b)]; Pipe-to-Plate or Pipe-to-Pipe [QW-462.4(c)]

Fracture Test (QW-182): n/a Length and Percent of Defects:

Macro-Examination (QW-184): n/a Fillet Size in (mm): X Concavity/Convexity in (mm):

Result and Comments: Groove weld test qualifies fillet weld test as well

Other tests and examinations: This Demo WPQ form has been prepared by WPSAmerica.com Online Welding Software

Film or specimens evaluated by: Tom Jones Company: Testing Lab Data, Inc.

Mechanical tests conducted by: Mechanical Group, Ltd. Laboratory Test No. 1012-MIG

Welding supervised by: WPSAmerica.com Certified Welding Inspector (CWI)

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.

Manufacturer/ Contractor
Welding Engineer

Name: Joe Smith
 Title: Welding Engineer
 Signature: J. S.
 Date: 14, 12, 2005

Authorized By:

Name: James Bond
 Title: QA Manager
 Signature: J. B.
 Date: 14, 12, 2005