

FORM QW-484A SUGGESTED FORMAT A FOR WELDER PERFORMANCE QUALIFICATIONS (WPO)
(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

Welder's name Vincent Kerr Identification no. V

Test Description

Identification of WPS followed WPS 001 Test coupon Production weld
 Specification and type/grade or UNS Number of base metal(s) SA106 Grade B NPS2 Sch. 80 Thickness 0.218

Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
	SMAW	SMAW
Type (i.e.; manual, semi-automatic) used	Manual	Manual
Backing (with/without)	F-3 No Backing F-4 Backing	F-3 No Backing F-4 Backing
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube)	NPS2	1" - Unlimited
Base metal P-Number to P-Number	P-1	QW-423.1
Filler metal or electrode specification(s) (SFA) (info. only)	SFA5.1	SFA5.1
Filler metal or electrode classification(s) (info. only)	E6010/E7018	QW-433
Filler metal F-Number(s)	F-3/F4	
Consumable insert (GTAW or PAW)	N/A	N/A
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW)	N/A	N/A
Deposit thickness for each process		
Process 1 <u>0.100</u> 3 layers minimum <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	0.100"	0.200"
Process 2 <u>0.118</u> 3 layers minimum <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	0.118"	0.236"
Position qualified (2G, 6G, 3F, etc.)	6G	All Positions
Vertical progression (uphill or downhill)	Uphill	Uphill
Type of fuel gas (OFW)	N/A	N/A
Inert gas backing (GTAW, PAW, GMAW)	None	None
Transfer mode (spray/globular or pulse to short circuit-GMAW)	N/A	N/A
GTAW current type/polarity (AC, DCEP, DCEN)	N/A	N/A

RESULTS

Visual examination of completed weld (QW-302.4) Satisfactory
 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
FB: 1 Face Bend	Satisfactory	FB: 3 Face Bend	Satisfactory		
RB: 2 Root Bend	Satisfactory	RB: 4 Root Bend	Satisfactory		

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 _____

Mechanical tests conducted by Triangle Engineering Laboratory test no. T30911-1

Welding supervised by Gary Frank, QCM

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 American Boiler Company

Date 3/25/2015

Certified by 