

**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 Gary Frank Identification no. G

**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. T30911-3  
 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.

Date 3/25/2015 Organization American Boiler Company  
 Certified by 