

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) 977-9353

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: _

Welded to

P-No: 1 Group No: 1 Material Specification: SA-36 Type or Grade: _

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

Test Coupon

Production Weld

Plate

Pipe

Welding Variables (QW-350)

Actual Values

Range Qualified

	Actual Values		Range Qualified	
Diameter if pipe or tube, in (mm)	n/a		2-7/8 (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 to 15F, 34, 41 to 49	
	1st Process	2nd Process	1st Process	2nd Process
Welding Process	GMAW	SMAW	GMAW	SMAW
Process Type	Semi-Automatic	Manual	Semi-Automatic	Manual
Welding Position Tested	3G	3G		
Vertical Progression	Uphill	Uphill	Uphill	Uphill
Position 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.			F	F
(C) Fillet, Plate and Pipe 2-7/8 in. (73 mm) OD and over			F, H, V	F, H, V
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)
*3 layers minimum of weld metal for each process				
Consumable Insert (GTAW, PAW)	n/a	n/a	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 Radiographic Examination Results (QW-191): n/a

RT Report No. _

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): _ 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's 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-MGL

Welding supervised by: WPSAmerica.com's Certified Welding Inspector

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