

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

Welder's name Alex Adams Identification no. 02, 02

Test Description

Identification of WPS followed GTAW_1205_1 Test coupon Production weld Date welded August 26, 2021

Specification and type/grade or UNS Number of base metal(s) SA-1008 CS-A to SB-171 70 Thickness (in) [Tested] .0625
[Qualified] No Min - No Max

Welding Variables (QW-350)

Welding process(es)
Type (i.e.; manual, semi-automatic) used
Backing (with/without)
 Plate Pipe (enter diameter if pipe or tube)
Base metal P-Number to P-Number
Filler metal or electrode specification(s) (SFA) (info. only)
Filler metal or electrode classification(s) (info. only)
Filler metal F-Number(s)
Consumable insert (GTAW or PAW)
Filler Metal Product Form (QW-404.23) (GTAW or PAW)
Deposit thickness for each process
Process 1 GTAW 3 layers minimum Yes No
Position(s)
Vertical progression (uphill or downhill)
Comments
Type of fuel gas (OFW)
Use of backing gas (GTAW, PAW, GMAW)
Transfer mode (spray, globular, or pulse to short circuit-GMAW)
GTAW current type and polarity (AC, DCEP, DCEN)

Testing Variables and Qualification Limits

	Actual Values	Range Qualified
	[1]GTAW	[1]GTAW
	[1]Manual	[1]Manual
	Without Backing	Optional
(in)		Minimum: 2.875 [Groove]
	8 to 8	1-15F, 34, 41-49 to 1-15F, 34, 41-49
	[1]6	[1]6
	None	Not Permitted
	[1]Bare	[1]Bare
(in)	[1].308	[1]No Min - 0.616
	[1]1G	[1]F
	[1]N/A	[1]Downhill, Uphill
		(OD >= 2.875 in) [Pipe <= 24 in]
	None	None
	[1]Yes	[1]Required
	None	None
	[1]DCEN	[1]DCEN

NOTE: Bracketed [] numbers indicate process

RESULTS

Visual examination of completed weld (QW-302.4) _____

- 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
Face Bend - Longitudinal	Acceptable				
Root Bend - Longitudinal	Acceptable				

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) _____ x _____ Concavity or convexity (in) _____

Other tests _____
Film or specimens evaluated by _____ Company _____
Mechanical Tests conducted by _____ Laboratory test no. _____
Welding supervised by _____

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 _____ Codeware _____

Date August 27, 2019 Certified by 