

Welder Performance Qualification Test Record

WPQR Database Registered to >>>DEMO
VERSION<<<

Name	Goldenarm, Ima	Test Date	2/4/2018
ID Number		Record Num	15
Stamp No	IG-3	Std. Test No.	ASME-1
Company	Gerald Real Fine Welding School and Haberdashery	WPS Used	GT1-1.1
Test Descrip.	ASME Sec. IX 2" Sch. 80 GTAW	Code(s)	ASME Sec. IX

BASE METAL	Spec/Type/Grade	Form	Group/M/P	Size/Sched	Thick.
Base Metal 1	SA106GRB	Pipe	1	2" Sch 80	0.218
Welded To	SA106GRB	Pipe	1	2" Sch 80	0.218

VARIABLES	Actual Variables	Range Qualified
Base Metal	P1 to P1	P1 thru 11, 15X, 3X, 4X
Weld Type	Groove	Grooves and Fillets

	Groove	Fillet	Groove	Fillet
Plate Thickness	N/A	N/A	All	All
Pipe/Tube Thick.	.218	N/A	All with .437 max "t"	All
Pipe Dia	2" NPS	N/A	1" Minimum	All

WELDING PROCESS	GTAW	GTAW
Process Type	Manual	Manual
Backing	None	With or without
Filler Metal (AWS Spec.)	SFA 5.18	All
AWS Classification	ER70S-2	All
F-Number	6	6
Deposited Weld Metal Thickness	.218"	.436"
Position	6G	See Below for Position Limitations
Groove, Plate & Pipe ≥ 24 in		All
Groove, Pipe < 24 in		All greater than 1" OD
Fillet, Plate and Pipe ≥ 24 in		All
Fillet, Pipe < 24 in		All
Progression	Uphill	Uphill
Current and Polarity	DCSP	DCSP
Transfer Mode	N/A	N/A
Single or Multiple Electrodes	Single	Single
Gas/Flux Type	Shielding Argon/Backing None	Shielding ANY/ Backing Optional

TEST RESULTS

Type of Test	Acceptance Criteria	Results	Remarks	Performed By
Visual	ASME IX	Meets Code		G. Austin-WITS
Guided Bend-Root- #1 and 2	ASME IX	Meets Code		G. Austin-WITS
Guided Bend-Face-#1 and 2	ASME IX	Meets Code		WITS-G. Austin
		N/A		
Comments				

INSPECTION and TEST SUPERVISION

Laboratory/Org	Welding Inspection and Testing Services, Greeneville TN	Lab. Test ID	15	File Number	15
Test Supervisor	C&C Millwright	Test ACC or REJ	ACC		
Test Supervisor Statement	I the undersigned, certify that the all operations referred to within this document were performed under my supervision and meet the requirements of the applicable code.				

Authorization Statement	We the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of ASME Sec. IX. WPQR Database Registered to >>>DEMO VERSION<<<
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Manufacturer or Contractor	Gerald Real Fine Welding School and Haberdashery				
Authorized By	Ima Supervisor	Date	8/19/2017		

Signature: _____