WELDING AND NDT

WELDING PROCEDURE/WELDER'S PERFORMANCE QUALIFICATION TEST RECORD

Welders Name :_____ Stamp No :_____

(P) WPS No :_____ Welding Process(es) : _____

Base Metal :_____ Thickness/Dia (mm) : _____

Product Type(Pipe/Plate) :_____ Type of Weld(Butt/Fillet) :_____

Length of test Coupon(mm) :_____ Position: _____

Current Type & Polarity: _____

Shielding Gas Mixture & Flow Rate (lpm) : _____

Purging Gas Mixture & Flow Rate (lpm) : _____

Dia (mm) and Type of Tungsten : _____

EN/AWS Class of Filler Metal & Size (mm): _____

Joint Fit Up Details :

Root Face(mm) : _____

Root Gap (mm) : _____

Included angle : _____

A) PARENT METAL DATA :

Material Specification		
Plate No. / Tube No.		
Heat No.		
Certificate No.		
Size of test Coupon (mm)		

B) CONSUMABLE DATA :

Process	AWS Class	F No/ F Group No	Filler Metal Type (S/M/P)	Brand Name	Size (mm)	Batch No

C) WELD DEPOSIT THICKNESS & WELD DETAILS :

Process	Thickness (mm)	Single/Double Side	Backing(nb,mb, gb, ci, fb)	Single/Multi Layer	Type of Transfer mode

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D) WELDING PARAMETER'S :

Layer(s) No.	Pass(s) No	Current (Amp)	Voltage (V)	WFS (m/min)	Preheating Temp (°C)	Interpass Temp(° C)	Time (sec)	Travel Speed (mm/min)	Heat Input (J/mm)	Depth (mm)	Width (mm)

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E) ACTUAL WELD BEAD SEQUENCE SKETCH:

F) OTHERS :

Test Coupon Identification :_____

Test Witnessed By(TPI Name) :_____of : _____

Date: _____

_____

Welding Engg Name & Sign