Welding AND NDT

Purposed Format

FORM QW-484 A ASME IX- Welder Performance Qualification (WPQ)

Welders Name	Sandeep Anand		Test Date		
Stamp Number	WN-02		WPQ No.	WPQ-002	
Campany Name	Welding AND NDT		WPS No.	S-001	Rev. No.0
Division	Pressure Equipments		Qualification code	ASME Sec. IX	

BASE METALS (QW-403)

	Product Form	Specification (Type or Grade)	P. No.	Grp. No.	Size(l x w)	Thk(mm)	Dia(mm)
	Pipe	SA 106 Gr B	1	1	200	14.2	168
Welded to:	Pipe	SA 106 Gr B	1	1	200	14.2	168
Joint type	Groove						

VARIABLES	Actual Value	Range Qualified
Type of weld Joint	Pipe - Groove	Groove and Fillet welds
Base Metal	P1 to P1	P 1-P15F, P 34, P 41-P49

BASE METAL THICKNESS		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness	(mm)	-	-	-	No Limit	No Limit	-
Pipe/tube thickness	(mm)	14.2	-	-	No limit	No Limit	-
Pipe diameter	(mm)	168	-	-	73 min.	No Limit	-

VARIABLES	Actual Value	Range Qualified
Welding process	SMAW	SMAW
Type	MANUAL	MANUAL
Backing	with	with
Filler metal specification	5.1	-
Filler metal classification	E7018	-
Filler metal F-number	4	F4,F3,F2,F1
Filler metal variety (QW-404.23)	NA	NA
Consumable insert	-	-
layers deposited	More than 3 layers FOR SMAW	-
Weld deposit thickness (mm)	13	Max. to be welded
Weld position (Actual position	6G	
Groove - Plate & Pipe > 610mm		ALL
Groove - Pipe 73mm to 610mm		ALL
Groove - Pipe < 73mm		-
Fillet - Plate & Pipe > 610mm		ALL
Fillet - Pipe 73mm to 610mm		ALL
Fillet - Pipe < 73mm		ALL
Weld Progression	Vertical Up	Vertical Up
Backing gas	Not used	-
Welding current/polarity	DCEP	DCEP
Transfer mode	NA	NA

TESTS

Type of Test	Acceptance Criteria	Result	Comments
Visual examination	QW-194	Acceptable	-
Radiographic Examination	QW-191.2	To Be Recorded	see ASME IX- QW 142/3, QW 304/.5

CERTIFICATION

Tests conducted by	UT Request Number	Test Details
WELDING TECHNOLOGY		

We 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 Section IX of the ASME Code Edition 2017- Draft Statement

Test Witnessed By		LRA	Head Welding Technology- Welding and NDT	
Name / TPI	Signature		Name	Signature
Date			Date	