

WELDING AND NDT
Purposed Format
ASME IX- Welder Performance Qualification (WPQ)

Welders Name	Sandeep Singh	Test Date	
Stamp Number	WN-01	WPQ No.	WPQ-001
Company Name	WELDING AND NDT	WPS No.	G-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)
Welded to:	Pipe	SA- 210 Gr-A1	1	1	200	5	54
Joint type	Pipe	SA- 210 Gr-A1	1	1	200	5	54
	Groove						

VARIABLES	Actual Value	Range Qualified
Type of weld Joint	Pipe - Groove	Groove and Fillet welds
Base Metal	P1 to P1	P 1-15F, P 34, P 41-49

BASE METAL THICKNESS	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (mm)	-	-	-	10	No Limit	-
Pipe/tube thickness (mm)	5	-	-	10	No Limit	-
Pipe diameter (mm)	54	-	-	25.4 min.	No Limit	-

VARIABLES	Actual Value	Range Qualified
Welding process	GTAW	GTAW
Type	Manual	Manual
Backing	Without	with/ Without
Filler metal specification	5.18	-
Filler metal classification	ER 70S-6	-
Filler metal F-number	6	6
Filler metal variety (QW-404.23)	Bare(Solid)	-
Consumable insert	-	-
layers deposited	3 (more than 3 layers)	-
Weld deposit thickness (mm)	5	10 (Max.)
Weld position (Actual position tested)	6G	-
Groove - Plate & Pipe > 610mm		ALL
Groove - Pipe 25 mm to 610mm		ALL
Groove - Pipe < 25 mm		-
Fillet - Plate & Pipe > 610mm		ALL
Fillet - Pipe 25 mm to 610mm		ALL
Fillet - Pipe < 25mm		ALL
Weld Progression	Vertical Up	Vertical Up
Backing gas	Not used	-
Welding current/polarity	DCEN	-

TESTS

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

CERTIFICATION

Tests conducted by	Laboratory Test number	Test Details
		Radiography Test

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
Date		Date