


# WeldOffice® printout sample - ASME WPQ

## C-spec

P.O. Box 27604, Concord, California 94527 (877) 977-7999  
**ASME Section IX - Welder Performance Qualification (WPQ)**  
 Created with WeldOffice® WPQ Module



Welder's name	Rod Laver		Test date	1/6/02
ID Number	5555		WPQ record number	500-5555
Date of birth	4/17/23		Standard test number	Rev.
Stamp number	500		WPS record number	Rev.
Company name	C-spec		Qualification code	ASME Section IX
Division	Concord			

### BASE METALS (QW-403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick.	(in.)	Dia.	(in.)
Welded to:	Pipe	SA-106 (B)	1	1	6	XX	0.864		6.625	
	Pipe	SA-106 (B)	1	1	6	XX	0.864		6.625	
Joint type	Groove									

### VARIABLES

	Actual values	RANGE QUALIFIED
Type of weld joint	Pipe - Groove	Groove and Fillet welds
Base metal	P1 to P1	P-no./S-no. 1 thru 11, 34, 4X

### BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	-	-	-	no limit	no limit	-
Pipe/tube thickness (in.)	0.864	-	-	no limit	no limit	-
Pipe diameter (in.)	6.625	-	-	2.875 min	no limit	-

### PROCESS VARIABLES

	Actual values		RANGE QUALIFIED	
	SMAW	FCAW	SMAW	FCAW
Welding process	SMAW	FCAW	SMAW	FCAW
Type	Manual	Semi-automatic	Manual	Semi-automatic
Backing	Without	With	With, without	With
Filler metal specification	5.1	5.20	5.xx	5.xx
Filler metal classification	E6010	E71T-12M	Any	Any
Filler metal F-number	3	6	3(1..3 w/backing)	6
Number of layers deposited	2	3 min		
Weld deposit thickness (in.)	0.250	0.614	0.5 max	no limit
Weld position (Actual position tested)	6G	6G		
Groove - Plate & Pipe >24"			All	All
Groove - Pipe 2.875" to 24"			All	All
Groove - Pipe < 2.875"			-	-
Fillet - Plate & Pipe >24"			All	All
Fillet - Pipe 2.875" to 24"			All	All
Fillet - Pipe < 2.875"			All	All
Progression	Up		Up	Up
Backing gas	-	Without	-	With, without
GMAW transfer mode (QW-409)	-	Globular	-	Spray, pulse, globular

### TESTS


Type of test	Acceptance criteria	Result	Comments
4 transverse side bends per QW-161.1 and QW-462.2	QW-163	Acceptable	see - ASME IX - QW-452.1 Note (4)
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 Note (8)
Notes			

### CERTIFICATION


Tests conducted by	Nick Mossman	Laboratory test number	001
Mechanical tests by	Nick Mossman	Test file number	001

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.


### Welding Engineer

Name	Signature
Nick Mossman	
Date	
3/30/01	


### QA Manager

Name	Signature
Michal Bernasek	
Date	
3/30/01	

### Signature 3

Name	Signature
Michele Mossman	
Date	
3/30/01	

### Signature 4

Name	Signature
Charles Foster	
Date	
3/30/01	