



XYZ Fabrications Ltd
44 High St, Weldtown, Australia
ASME IX - Welder Performance Qualification (WPQ)
Welderqual software by TWI Ltd

Welder's name	Philip Collis		Test date	12/08/2003
ID Number	PSC		WPQ record number	TWI-WPQ-46
Date of birth	13/1/1957		Standard test number	Rev.
Stamp number			pWPS record number	Rev.
Company name	XYZ Fabrications Ltd		Qualification code	ASME Section IX
Division	Welding Shop #1			

BASE METALS (QW-403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick(mm)	Di(mm)
Welded to:	Pipe	SA-106 (B)	1	1	152.40	Standard	7.11	168.28
	Pipe	SA-106 (B)	1	1	152.40	Standard	7.11	168.28
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, 41 thru 49

BASE METAL THICKNESS

Groove

Fillet

Overlay

Groove

Fillet

Overlay

Plate thickness (mm)	-	-	-	no limit	no limit	-
Pipe/tube thickness (mm)	7.11	-	-	no limit	no limit	-
Pipe diameter (mm)	168.28	-	-	73 min	no limit	-

VARIABLES

Actual values

RANGE QUALIFIED

Welding process	GTAW	SMAW	GTAW	SMAW
Type	Manual	Manual	Manual	Manual
Backing	None	With	With, without	With
Filler metal specification	5.18	5.1	5.xx	5.xx
Filler metal classification	ER70S-2	E7018	Any	Any
Filler metal F-number	6	4	6	1..4
Filler metal variety (QW-404.23)	Bare (solid)	-	Solid, metal cored	-
Consumable insert	None	-	Without	-
Number of layers deposited	1	3		
Weld deposit thickness (mm)	3	4.5	6.0 max	9.0 max
Weld position (Actual position tested)	6G	6G		
Groove - Plate & Pipe > 610mm			All	All
Groove - Pipe 73mm to 610mm			All	All
Groove - Pipe 73mm			All	All
Fillet - Plate & Pipe > 610mm			All	All
Fillet - Pipe 73mm to 610mm			All	All
Fillet - Pipe < 73mm			All	All
Progression	Up	Up	Up	Up
Backing gas	Without	-	With, without	-
GTAW welding current/polarity	DCSP	-	DCSP	-

TESTS

Type of test	Acceptance criteria	Result	Comments
2 transverse face bends per QW-161.2, QW-463.2(d) and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-452.1 (a) Note (1)
2 transverse root bends per QW-161.3, QW-463.2(d) and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-452.1 (a) Note (1)
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 (a)

Notes

CERTIFICATION

Tests conducted by	John Black	Laboratory test number	ABC-0021-9-06-132
Mechanical tests by	ABC Testing Ltd	Test file number	

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.

Manufacturer

Inspection Authority

Name	Signature	Name	Signature
Andy Brightmore			
Date		Date	
10/05/2006			