

Keystone - API-1104 Welder Qualification Form

Form W8 Rev 0



Welder's Name (print)	Welder's ID Stamp	Test Location, Project and/or Spread No.
Mathew K. Linehan (DL#082143627 Ok.)	3177	Livingston West Pipe Yard Gulf Coast - Spread 3

TEST CONDITIONS

	Test 1	Test 2
	Single Qual	Multiple Qualification
Weld Type	Butt	Butt Branch
Pipe Specification & Grade	API 5L X70	
Diameter of Test Pipe	36"	
Wall Thickness	.465"	
Centerline of Pipe Axis 2G, 5G, 6G	5G	
AWS Filler Metal Identification	A.5.1/A.5.5	
Welding Procedure Specification No.	KXL-SMAW-RP	

WELDER QUALIFICATION BASED ON DESTRUCTIVE TEST AND RESULTS

Number of Test Completed Per Test	Nick	N/A		
	Face	N/A		
	Root	N/A		
	Side	N/A		

Visual Acceptable ☐ Visual Not Acceptable ☐ Welder Qualified ☐ Welder Disqualified ☐

WELDER QUALIFICATION BASED ON NDE OF TEST BUTT WELD

NDT Method	<input checked="" type="checkbox"/> Radiographic Testing	Weld ID No. 3177	Radiographic Report No. Shaw D/67	X-Ray Film No.'s. 1
	<input type="checkbox"/> Ultrasonic Testing	Weld ID No.	Ultrasonic Report No.	Ultrasonic Data file name or No. (if applicable)

Visual Acceptable ☒ NDE Acceptable ☒ Welder Qualified ☒ Welder Disqualified ☐

ESSENTIAL VARIABLES FOR WELDER QUALIFICATION (Mark With an 'X')

WELDING					Welding Equipment			API Filler Metal Group No. (1,2,3)	Welding Electrode Direction of Travel		Qualification	
SMAW	GMAW	SAW	GTAW	FCAW	Manual	Semi-Automatic	Automatic		Up	Down	Multi-Qual (All diameters, wall thickness, and positions)	Single (See Additional Limitations Below)
X					X			1,3	F/C	R	N/A	X

ADDITIONAL LIMITATIONS (Mark with an 'X') ONLY COMPLETE THIS SECTION FOR SINGLE QUALIFICATION

Pipe									Butt Weld		Fillet Weld			
Outside Diameter Inches			Wall Thickness Inches			Centerline of Pipe (Axis)			Position		60-70 Deg. Bevel	Mech. GMAW Welding Bevel	Branch Fillet	Lap Fillet
<2.375	≥2.375 ≤12.75	>12.75	<.188	≥.188 ≤.750	>.750	Vertical 2G	Horizontal 5G	All Pipe Axis Positions	Fixed	Rolled				
		X		X			X		X		X			

Welding Inspector's Name (Please Print)	Welding Inspector's Signature	Date Of Test	Date of Qualification Expiry
Allen Le Blanc		Nov. 10, 2012	6 mts of Last Accepted weld

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**TransCanada**
In business to deliver**WELD PARAMETER DETAILS**

Welding Consumables:

Welding
Position:

5 G

Welding Direction:

Root Down /Fill and Cap UP

Welding
Procedure:

KXL-SMAW-RP

Weld pass # :

Root

Hot Pass

Fill/Strip

Cap

Electrode Size:

1/8" E6010

3/32"
E8018-C31/8"
E8018-C31/8"
E8018-C3

Weld current:

DCRP

DCRP

DCRP

DCRP

Weld voltage:

A=60-120
V=21-35A=70-110
V=20-27A=110-160
V=19-26A=110-160
V=19-26

Travel Speed:

3"-7" IPM
11.8-90.0
KJ/IN2"-6" IPM
22.7-68.5
KJ/IN3"-8" IPM
44.7-92.4
KJ/IN3"-8" IPM
23.7-92.4
KJ/IN

Welding Consumables:

Welding
Position:

Welding Direction:

Welding
Procedure:

Weld pass # :

Electrode Size:

Weld current:

Weld voltage:

Travel Speed:

Welding Inspector's Name (Please Print)

Welding Inspector's Signature

Allen Le Blanc

Nov. 10, 2012

Allen Le Blanc
97040651
EXP. 4/1/2015

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Welder's Name (print) Larry J. Guilbeaux (DL#009297642 La.)	Welder's ID Stamp 3224	Test Location, Project and/or Spread No. Livingston West Pipe Yard Gulf Coast Spread 3
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TEST CONDITIONS

	Test 1 Single Qual	Test 2 Multiple Qualification
Weld Type	Butt	Butt Branch
Pipe Specification & Grade	API 5L X70	
Diameter of Test Pipe	36"	
Wall Thickness	.465"	
Centerline of Pipe Axis 2G, 5G, 6G	5G	
AWS Filler Metal Identification	A.5.1/A.5.5	
Welding Procedure Specification No.	KXL-SMAW-ML	

WELDER QUALIFICATION BASED ON DESTRUCTIVE TEST AND RESULTS

Number of Test Completed Per Test	Nick	8	Accept
	Face	2	Accept
	Root	2	Accept
	Side	N/A	

Visual Acceptable ☒ Visual Not Acceptable ☐ Welder Qualified ☒ Welder Disqualified ☐

WELDER QUALIFICATION BASED ON NDE OF TEST BUTT WELD

NDT Method	<input type="checkbox"/> Radiographic Testing	Weld ID No.	Radiographic Report No.	X-Ray Film No.'s.
	<input type="checkbox"/> Ultrasonic Testing	Weld ID No.	Ultrasonic Report No.	Ultrasonic Data file name or No. (if applicable)

Visual Acceptable ☐ NDE Acceptable ☐ Welder Qualified ☐ Welder Disqualified ☐

ESSENTIAL VARIABLES FOR WELDER QUALIFICATION (Mark With an 'X')

WELDING					Welding Equipment			API Filler Metal Group No. (1,2,3)	Welding Electrode Direction of Travel		Qualification	
Welding Process					Manual	Semi-Automatic	Automatic		Up	Down	Multi-Qual (All diameters, wall thickness, and positions)	Single (See Additional Limitations Below)
SMAW	GMAW	SAW	GTAW	FCAW								
X					X			1,2	X		N/A	X

ADDITIONAL LIMITATIONS (Mark with an 'X') ONLY COMPLETE THIS SECTION FOR SINGLE QUALIFICATION

Pipe									Position		Butt Weld		Fillet Weld	
Outside Diameter Inches			Wall Thickness Inches			Centerline of Pipe (Axis)			Fixed	Rolled	60-70 Deg. Bevel	Mech. GMAW Welding Bevel	Branch Fillet	Lap Fillet
<2.375	≥2.375 ≤12.75	>12.75	<.188	≥.188 ≤.750	>.750	Vertical 2G	Horizontal 5G	All Pipe Axis Positions						
		X		X			X		X		X			

Welding Inspector's Name (Please Print) Allen Le Blanc	Welding Inspector's Signature 	Date Of Test Jan. 30, 2013	Date of Qualification Expiry 6 Months of Last Accepted Weld
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**TransCanada**
In business to deliver**WELD PARAMETER DETAILS**

Welding Consumables:

Welding
Position:

5G

Welding Direction:

Down

Welding
Procedure:

KXL-SMAW-ML

Weld pass # :

Root

Hot Pass

Fill

Cap

Electrode Size:

5/32"

5/32"

3/16"

3/16"

E6010

E8010G/P1

E8010G/P1

E8010G/P1

Weld current:

DCRP

DCRP

DCRP

DCRP

Weld voltage:

A=108-171

A=149-216

A=140-220

A=126-198

V=19-27

V=20.7-32.0

VV=20.7-32

V=22.5-34

Travel Speed:

10.8"-16.5"

14.5"-18.7"

5.1"-12.4"

8.6"-16.2"

Kj 9-19.1

kj 12.0-23.2

kj 20.0-64.4

kj 12.8-44.7

WFS (GMAW only):

N/A

N/A

N/A

N/A

Welding Consumables:

Welding
Position:

Welding Direction:

Welding
Procedure:

Weld pass # :

Electrode Size:

Weld current:

Weld voltage:

Travel Speed:

WFS (GMAW only):

Remarks:

Welding Inspector's Name (Please Print)

Allen J. Le Blanc

Welding Inspector's Signature

 1-30-13