

Welder	's Nar	ne (pr	int)			- 4		Weld	ers	ID Stamp			est Loc	ation. F	Project and/o	or Sn	read	No				
Mathew K. Linehan (DL#082143627 Ok.))k \	3177			Test Location, Project and/or Spread No. Livingston West Pipe Yard											
Maule										Gulf Coast - Spread 3 ST CONDITIONS												
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							Te: Single	e Qual					Multip	Test 2 le Qualif	ication							
Weld Ty	pe					Butt					Butt					ranci	1	********				
Pipe Spe		on & G	ade					L X70														
Diamete								6"					10.00									
Wall Thi							and the second second	55"							···							
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Welding	Proced	ure Sp				\	. 624		EF	ON DES	TPLICT	WE TE	AA TO	ID PES	III TS			· · · · · · · · · · · · · · · · · · ·				
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							Weld ID		R	adiographic				X-	Ray Film No.'s	3,						
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NDT	_					1	Weld II			Ultrasonic Report No.			Ultraso	nic Data file name or No. (if applicab			ole)					
Method Ultrasonic Testin			sting																			
Visual A	Accep	table	\boxtimes		NDE A	CCE	eptable [X		Welder	Velder Qualified ⊠ Welder Disqualified □											
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		Weld	ding F	roce	ess .				П			API Filler			Qualification							
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			T			T				Comet		Group			Multi-Qua		Single					
			w saw		074144		mo asaz	Manua	al	Semi- Automatic	Automatio	No. (1,2,3)			(All diamete wall thickne			Additional Itations				
SMAW	GI	WAN			SAW		N SAW	.vv	GTAW		FCAW					(1,2,3)	Up	Down	and position			elow)
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Χ							4.27 s 2	X				1,3	F/ C	R	N/A			Χ				
						<u></u>	ADDITIO	ONAL L	MI	ATIONS	(Mark wit	h an 'X	")	<u> </u>	····							
					ONLY	CO		E THIS	SEC	TION FO	R SINGLE	QUAL	IFICAT	ION								
							Pipe				r	<u> </u>	J ,	Butt Weld		Fillet Weld						
Outside Diameter Inches Wal			all Thick	nes	s Inches	Center		rline of Pipe (Axis		Pos	Position			<u> </u>	i illet weld							
<2.375	≥2.375 ≤12.75		12.75	<.18		188 750		Vertic 2G		Horizontal 5G	All Pipe Axis Positions	Fixed	Rolled	Deg Beve	. GMAW		nch liet	Lap Fillet				
			Х			X		[2	92	7 X		Х		Х			-	-				
Welding Inspector's Name (Please Print) Welding Inspector's Variature									ture .		Date C	of Test		Date of 0	Qualif	ication	Expiry					
Allen Le Blanc						llon	Van John American			Nov. 10,2012			1	6 mts of Last Accepted weld								
							7 /			Z,	5°, C;											



		WEL	D PARAMET	TER DETAI	LS	······································				
Welding Consum	ables:									
Welding Position:	5 Ģ		Welding E	Direction:	Root Down /Fill and Cap UP					
Welding Procedure:	KXL-SMAW-	V-RP								
Weld pass#:	Root	Hot Pass	Fill/Strip	Сар						
Electrode Size:	1/8" E6010	3/32" E8018-C3	1/8" E8018-C3	1/8" E8018-C3						
Weld current:	DCRP	DCRP	DCRP	DCRP						
Weld voltage:	A=60-120 V=21-35	A=70-110 V=20-27	A=110-160 V=19-26	A=110-160 V=19-26						
Travel Speed:	3"-7" IPM 11.8-90.0 KJ/IN	2"-6" IPM 22.7-68.5 KJ/IN	3"-8" IPM 44.7-92.4 KJ/IN	3"-8" IPM 23.7-92.4 KJ/IN						
A			u feri	a ya dan						
Welding Consum	ables:									
Welding Position:			Welding D	lrection:						
Welding Procedure:			- · · · · · · · · · · · · · · · · · · ·				· · · · · · · · · · · · · · · · · · ·			
Weld pass # :										
Electrode Size:				<u> </u>						
Weld current:				· · · · · · · · · · · · · · · · · · ·						
Weld voltage:										
Travel Speed:	(Plans a Patri)		I Molding Income	odorlo Qianata						
Welding Inspector's Nar	ne (Please Print)		vveiding inspe	ector's Signature			:			
Allen Le Blanc				A Was	J. J. Bl	one N	lov. 10,2012			
				7	0.7					



Welde	r's Na	me (print)				Welde	r's ID Stamp)		Fest Loc	ation, F	Project and/o	r Sprea	d No.	
Larry J. Guilbeaux (DL#009297642 La.)									Livingston West Pipe Yard							
Larry	J. Gui	IDCC	iux (DL	#00928	7042 L	a.,	1	da d	Gulf Coast Spread 3							
					- 23 %	-		ST CONDIT	IONS	<u> </u>	1.81314	T1.5				
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Weld Ty	/pe						utt .		Butt					Branch		
Pipe Sp		tion 8	k Grade				L X70		4 4 4 4 4 4							
Diamete			pe			3(<u></u>					
Wall Thickness							55"						~~			
			xis 2G, 5			A.5.1				·	<u> </u>					
			entification Specifica		+	KXL-SN										
vveiding	Proces	uure			QUALI	interior and the second		ED ON DE	STRUCT	IVE TE	STAN	DRES	III TS			
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Numbe	r of Te	st	Face		Acc		-									
Compl		er	Root	2	Acc		 								···	
Te	est	F	Side	 N/A	7.00	<u> </u>										
Vis	sual A	cce	ptable [sual No	t Accept	able 🔲	We	lder Qual	ified 🗵]		Welder D	isqualif	ied 🗌	
				WELL	DEP O	IALIEIC	ATION	BASED OF	I NDF O	F TES	r BIITT	MEL	<u> </u>			
				AALL	DEN Q	Weld ID		Radiographic		123	DUII	X-	Ray Film No.'s	<u> </u>		
		Radiographic Tes		sting			radiograpino report no.									
Method Ultrasonic Testing				g	Weld ID	No.	Ultrasonic Report No.			Ultrasonic Data file			e name or No. (if applicable)			
Visual Acceptable ☐ NDE Acceptable ☐ Welder Qualified ☐ Welder Disqualified ☐																
	ESSENTIAL VARIABLES FOR WELDER QUALIFICATION (Mark With an 'X')															
			<u>:</u>		WELD	NG.			7		/ Wel	ding				
					***************************************		Wel	ding Equipr	nent		Elec	trode				
		W	elding F	Process						API Filler Metal		ction of avel	f		alification	
	\top							0		Group			Multi-Qua		Single	
SMAW	G	MAV	v sA	w G	TAW	FCAW	Manual	Semi- Automatic	Automatic	No. (1,2,3)	Up	Down	(All diamete wall thickne and position	ss, `L	e Additional imitations Below)	
Х										1,2		Х	N/A		X	
				0	NLY CO	ADDITIO	NAL LI	MITATIONS ECTION FO	(Mark wit	h an 'X E QUAL	') .ificat	ION		<u></u>		
						Pipe								14.1		
Outside Diameter Inches Wall Th				Thicknes	s Inches	Cen	terline of Pip	e (Axis)	Pos	sition	Βι	ıtt Weld	Fille	t Weld		
<2.375	≥2.37 ≤12.7		>12.75	<.188	≥.188 ≤.750		Vertica 2G	Horizontal 5G	All Pipe Axis Positions	Fixed	Rolled	60-70 Deg Beve	GMAW	Branch Fillet	Lap Fillet	
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vveiding	ınspec	IOF'S	ivame (P	icase Pf	iii) V	N N N N N N N N N N N N N N N N N N N	DECICI S S	rigi iaiui E		Date C	/ 1 COL					
Allen Le Blanc							Leth l	onc	Ja	Jan. 30,2013			6 Months of Last Accepted Weld			
20 ₁₅																



		WELI	D PARAME	TER DETAIL	S						
Welding Consum	ables:										
Welding Position:	5G		Welding I	Direction:	Down						
Welding Procedure:	KXL-SMAW	-ML									
Weld pass # :	Root	Hot Pass	Fill	Cap			,				
Electrode Size:	5/32" E6010	5/32" E8010G/P1	3/16" E8010G/P1	3/16" E8010G/P1							
Weld current:	DCRP	DCRP	DCRP	DCRP							
Weld voltage:	A=108-171 V=19-27	A=149-216 V=20.7-32.0	A-140-220 VV=20.7-32	A=126-198 V=22.5-34			·				
Travel Speed:	10.8"-16.5" Kj 9-19.1	14.5"-18.7" kj 12.0-23.2	5.1"-12.4" kj 20.0-64.4	8.6"-16.2" kj 12.8-44.7							
WFS (GMAW only):	N/A	N/A	N/A	N/A							
Welding Consuma	ables:										
Welding Position:			Welding D	Direction:							
Malding			<u> </u>								
Welding Procedure:			· . · · · · · · · · · · · · · · · · · ·		_						
Weld pass # :				-							
Electrode Size:			**************************************								
Weld current:							op anglikkist s				
Weld voltage:		(A.)									
Travel Speed:											
WFS (GMAW only):											
Remarks:				• .			l				
			<u> </u>	Quantity of							
Welding Inspector's Nam			Welding Inspe	Welding Inspector's Signature, 7.							
Allen J. Le Bland				A Slaw / Le Besance 1-30-13							