

FORM QW-484B SUGGESTED FORMAT B FOR WELDING OPERATOR PERFORMANCE QUALIFICATIONS (WOPQ)
(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

Welding operator's name _____ Identification no. _____

Test Description (Information Only)

Identification of WPS followed _____ ☐ Test coupon ☐ Production weld

Specification and type/grade or UNS Number of base metal(s) _____ Thickness _____

Base metal P-Number _____ to P-Number _____ Position (2G, 6G, 3F, etc.) _____

☐ Plate ☐ Pipe (enter diameter, if pipe or tube) _____

Filler metal (SFA) specification _____ Filler metal or electrode classification _____

Testing Variables and Qualification Limits When Using Automatic Welding Equipment

Welding Variables (QW-361.1)	Actual Values	Range Qualified
Type of welding (automatic)	_____	_____
Welding process	_____	_____
Filler metal used (Yes/No) (EBW or LBW)	_____	_____
Type of laser for LBW (CO ₂ to YAG, etc.)	_____	_____
Continuous drive or inertia welding (FW)	_____	_____
Vacuum or out of vacuum (EBW)	_____	_____

Testing Variables and Qualification Limits When Using Machine Welding Equipment

Welding Variables (QW-361.2)	Actual Values	Range Qualified
Type of welding (Machine)	_____	_____
Welding process	_____	_____
Direct or remote visual control	_____	_____
Automatic arc voltage control (GTAW)	_____	_____
Automatic joint tracking	_____	_____
Position qualified (2G, 6G, 3F, etc.)	_____	_____
Consumable inserts (GTAW or PAW)	_____	_____
Backing (with/without)	_____	_____
Single or multiple passes per side	_____	_____

RESULTS

Visual examination of completed weld (QW-302.4) _____

☐ Transverse face and root bends [QW-462.3(a)] ☐ Longitudinal bends [QW-462.3(b)] ☐ Side bends (QW-462.2)

☐ Pipe bend specimen, corrosion-resistant weld metal overlay [QW-462.5(c)]

☐ Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5(d)]

☐ Pipe specimen, macro test for fusion [QW-462.5(b)] ☐ Plate specimen, macro test for fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result

Alternative Volumetric Examination Results (QW-191): _____ RT ☐ or UT ☐ (check one)

Fillet weld — fracture test (QW-181.2) _____ Length and percent of defects _____

☐ Fillet welds in plate [QW-462.4(b)] ☐ Fillet welds in pipe [QW-462.4(c)]

Macro examination (QW-184) _____ Fillet size (in.) _____ × _____ Concavity/convexity (in.) _____

Other tests _____

Film or specimens evaluated by _____ Company _____

Mechanical tests conducted by _____ Laboratory test no. _____

Welding supervised by _____

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Organization _____

Date _____

Certified by _____