

Welding Performance Qualification Record (WPQR)

Welding Code: AWS D1.1

Company Name: WPSAmerica.com

Company Address: info@WPSAmerica.com, 1 (877) 977-9353

Welder's Name: **Elvis Tom Jones**

Identification No: **ETJ-2005**

Type of welder: **Welder**

Welding Performance Qualification Record WPQR No. **DEMO-SMAW-WPQR**

Qualification Date: **12, 12, 2005**

Welding Procedure Specification WPS No. **DEMO-SMAW-WPS**

Rev. **0**

BASE METALS USED

Material Specification, Type or Grade: ASTM A 36

Plate Pipe Box Tube Sheet

Welded to

Material Specification, Type or Grade: ASTM A 36

Plate Pipe Box Tube Sheet

| Variables | Actual Values Used | Qualification Range |
|---|--------------------|---------------------------------|
| Welding Process | SMAW | SMAW |
| Process Type | Manual | Manual |
| Electrode (Single or Multiple) | Single | Single |
| Current Type/Polarity | DCEP | |
| Backing (Yes or No) | Without backing | With or without |
| Welding Position : | | |
| Groove | 2G | F, H (Plate, Pipe, Box Tube) |
| Fillet | | F, H (Plate, Pipe, Box Tube) |
| Vertical Progression | n/a | n/a |
| Plug or Slot Welds | n/a | 2G (Plate) |
| Base Metals Thickness: | | |
| Groove | 3/8 in. (10 mm) | 1/8 in. (mm) to 3/4 in. (20 mm) |
| Fillet | n/a | any thickness |
| Plug or Slot Welds | n/a | any thickness |
| Base Metals Diameter (Pipe or Tube): | | |
| Groove | n/a | 24 in. (600 mm) OD and over |
| Fillet | n/a | 24 in. (600 mm) OD and over |
| Filler Metal Specification (SFA) | A5.1 | |
| Filler Metal Classification (AWS Classified) | E7018 | Any AWS A5 Class Approved |
| Filler Metal F-Number | 4 | 4, 3, 2, 1 |
| Gas/Flux (SAW) | n/a | n/a |
| Other Variable (coating type/thickness, etc.) | n/a | n/a |

Results

Visual Inspection of Completed Weld (D1.1, 4.8.1): Acceptable YES NO

Guided Bend Test Type and Results (D1.1, 4.30.5): One Root and One Face Bend Specimens

Result and Comments: Acceptable criteria based on AWS D1.1, Clause 4.8.3.3 measured values

Fillet-Weld Test Results (D1.1, 4.30.2.3 and 4.30.4.1):

Appearance: n/a Fillet Size in (mm): n/a

Fracture Test Root Penetration: n/a Macroetch: n/a

(Describe the location, nature, and size of any crack or tearing of the specimen.)

Result and Comments: Groove weld test qualifies fillet weld test as well

Inspected by: Tom Jones, AWS Certified Welding Inspector Test Number: 1012-G

Organization: Testing Lab Data, Inc. Date: 12, 12, 2005

Alternative * Radiographic Test Results (D1.1, 4.30.3.1) : * In lieu of Guided Bend Test, except for GMAW-S

| Film Identification No. | Results | Remarks | Film Identification No. | Results | Remarks |
|-------------------------|---------|---------|-------------------------|---------|---------|
| n/a | n/a | n/a | n/a | n/a | n/a |
| n/a | n/a | n/a | n/a | n/a | n/a |

Film interpreted by: n/a Test Number: n/a

Organization: n/a Date: n/a

Other information: Guide bend test conducted instead of RT. This WPQR demo form has been created by WPSAmerica.com Online Welding Software

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Section 4 of AWS D1.1/D1.1M, (2008) Structural Welding Code-Steel.

**Manufacturer/ Contractor
Welding Engineer**

Authorized By:

Name: Joe Smith
Title: Welding Engineer
Signature: J. S.
Date: 14, 12, 2005

Name: James Bond
Title: QA Manager
Signature: J. B.
Date: 14, 12, 2005