C-spec

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Welder Performance Qualification (WPQ)

Created with C-spec software

Welder's name	El Z. W.		Test date	5/9/2000
ID Number	333-33-333		WPQ record number	PI-BT-V-EZW
Date of birth	1/25/1975		Standard test number	33 Rev. 0
Stamp number	EZW-02		WPS record number	P1-AT-Lh-CVN Rev. 0
Company name	C-spec		Qualification code	ASME Section IX
Division				

BASE METALS (QW -403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick. (in.)	Dia. (in.)
	Plate	SA-516 (60)	1	1	-	-	1	-
Welded to:	Plate	SA-516 (60)	1	1	-	-	1	-
Joint type	Groove							

VARIABLES

	Actual values	RANGE QUALIFIED
Type of weld joint	Plate - Groove	Groove and Fillet welds
Base metal	P1 to P1	P-no./S-no. 1 thru 11, 34, 41 thru 47

BASE METAL THICKNESS

	Actual values			RANGE QUALIFIED		
	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	1	-	-	no limit	no limit	-
Pipe/tube thickness (in.)	-	-	-	no limit	no limit	-
Pipe diameter (in.)	-	-	-	2.875 min	no limit	-

PROCESS VARIABLES

	Actual values			RANGE QUALIFIED		
Welding process	GTAW	SMAW	FCAW	GTAW	SMAW	FCAW
Type	Manual	Manual	Semi-automatic	Manual	Manual	Semi-automatic
Backing	None	Yes	Yes	With, without	With	With
Filler metal specification	5.18	5.1	5.20	5.xx	5.xx	5.xx
Filler metal classification	ER70S-2	E7018	E70T-2	Any	Any	Any
Filler metal F-number	6	4	6	6	1..4	6
Filler metal variety (QW-404.23)	Bare (solid)	-	-	Solid, metal cored	-	-
Consumable insert	None	-	-	Without	-	-
Number of layers deposited	3	3	3			
Weld deposit thickness (in.)	0.125	0.125	0.125	0.25 max	0.25 max	0.25 max
Weld position (Actual position tested)	3G	3G	3G			
Groove - Plate & Pipe >24"				F,V	F,V	F,V
Groove - Pipe 2.875" to 24"				F	F	F
Groove - Pipe < 2.875"				-	-	-
Fillet - Plate & Pipe >24"				F,H,V	F,H,V	F,H,V
Fillet - Pipe 2.875" to 24"				F,H,V	F,H,V	F,H,V
Fillet - Pipe < 2.875"				F,H,V	F,H,V	F,H,V
Progression	Up	Up	Up	Up	Up	Up
Backing gas	Without	-	Without	With, without	-	With, without
GMAW transfer mode (QW-409)	-	-	Spray	-	-	Spray, pulse, globular
GTAW welding current/polarity	DCSP	-	-	DCSP	-	-

TESTS

Type of test	Acceptance criteria	Result	Comments
2 transverse side bends per QW-161.1 and QW-462.2	QW-163	Acceptable	see - ASME IX - QW-452.1 (a)
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 (a)

Notes

CERTIFICATION

Tests conducted by	Test Lab	Laboratory test number	WPQ-100
Mechanical tests by	Test Lab2	Test file number	TL2-WPQ-100

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.

Welding Engineer		Q.A. Manager	
Name	Signature	Name	Signature
N.G. Neer	N. G. Neer	Q. M. Anager	Q.M. Anager
Date		Date	
5/16/2000		5/17/2000	

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