Welder Performance Qualification (WPQ)
ASME IX – Energy - Downstream, Power and Manufacturing

Welder's Name **M. Liekens** Identification No. **H5**

Test Description

Identification no. of WPS followed	**10 rev. 0**	☒	Test coupon	☐	Production weld
Specification of base metal(s)	**A333 Gr. 6**		Thickness		**14,0 mm**

Testing Conditions And Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es)	**GMAW**	**GMAW / FCAW**
Type (i.e.; manual, semi-auto) used	**Semi-auto**	**Semi-auto**
Backing (metal, weld metal, double-welded, etc.)	**Without**	**With or without**
☐ Plate ☒ Pipe (enter diameter if pipe or tube)	**168,3 mm**	**≥ 73,0 mm**
Base Metal P- or S-Number to P- or S-Number	**1**	**1 through 15F, 34, 41 through P-no. 49**
Filler metal or electrode specification(s) (SFA) (info. only)	**A5.18**	-
Filler metal or electrode classification(s) (info. only)	**E70C-3M H4**	-
Filler metal F-Number(s)	**6**	**All F-no. 6**
Consumable insert (GTAW or PAW)	**n.a.**	-
Filler type (solid/metal or flux cored/powder) GTAW or PAW	**n.a.**	-
Deposited thickness for each process		
Process 1: **GMAW** 3 layers minimum ☒ Yes ☐ No	**14,0 mm**	**Maximum to be welded**
Process 2: 3 layers minimum ☐ Yes ☐ No		
Position qualified (2G, 6G, 3F, etc.)	**6G**	**All**
Vertical progression (uphill or downhill)	**Up**	**Up**
Type of fuel gas (OFW)	**n.a.**	-
Inert gas backing (GTAW, PAW, GMAW)	**Without**	**With or without**
Transfer mode (spray/globular or pulse to short circuit – GMAW)	**Root: Short ciruit** **Filler: Spray**	**Root: Short circuit** **Filler: Globular - / spray arc**
Current type/polarity (AC, DCEP, DCEN)	**DCEP**	**DCEP**

Test Results

Visual Examination of Completed Weld (QW-302.4) **Acceptable**

☒ Bend Test; ☐ Transverse root and face [QW-462.3(a)]; ☒ Longitudinal root and face [QW-462.3(b)]; ☐ Side (QW-462.2);
☐ Pipe bend specimen, corrosion-resistant overlay [QW 462.5(c)] ☐ Plate bend specimen, corrosion-resistant overlay [QW-462.5(d)];
☐ Macro test for fusion [QW-462.5(b)]: ☐ Macro test for fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result
Face bend	**Acceptable**	**Root bend**	**Acceptable**		
Face bend	**Acceptable**	**Root bend**	**Acceptable**		

Alternative radiographic examination results (QW-191) -
Fillet weld – fracture test (QW-180) Length and percent of defects x
Macro examination (QW-184) Fillet size (in/mm) x Concavity/convexity (in/mm.)
Other tests **Macro, RT and MT tested**
Film or specimens evaluated by Company **RTD**
Mechanical tests conducted by Laboratory test no. **SL 2516/96**
Welding supervised by **A. van Klink (LR)**

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 and meets the requirements of the Pressure Equipment Directive 97/23EC

Date issued **04 Oct 2014**

Note: Rewritten from former WPQ 96.0626!

Manufacturer's Representative
Manufacturer **H.W.S.**

4 Nov 2014
Raymond ten Vaarwerk
Lloyd's Register Energy

A member of the Lloyd's Register Group

HATEK LASTECHNIEK BV

EXTENSION SHEET FOR WELDING

		Range of qualification	
Company	Holland Welding Support	Welding process(es):	GMAW, FCAW
Welder	M. Liekens	Transfer mode:	Root: short circuit
ID	H-05		Filler: Globular, Spray
Position	6Gu	Positions:	All
Certificate nr.	RET260344/RTV/067	Base metal:	1-15F, 34, 41-49
Weldproces	GMAW	Filler metal:	All F-no. 6
Material	A333 Gr. 6	Deposited thickness:	Maximum to be welded
Code	ASME IX	Outside pipe Ø:	≥ 73,0mm

Extension date	Based on	Filler metal	Weld positions	Signed & Stamped extension resposible department	Signed and stamped Authority
JUN. 2015	QWT-02 ISO 15614-1 RT 02	F6	6Gu	Hatek Lastechniek BV Welding department Training and Certification L. Hill RWC	Witnessed / Reviewed A.M. Konings Rotterdam Office Lloyd's Register Nederland B.V. 06 AUG 2015
DEC. 2015					
JUN. 2016					
DEC. 2016					
JUN. 2017					2 years extension dd
DEC. 2017					
JUN. 2018					
DEC. 2018					
JUN. 2019					2 years extension dd
DEC. 2019					