



Welder Performance Qualification (WPQ)

ASME IX – Energy - Downstream, Power and Manufacturing

Welder's Name **Liekens M. (H05)** Identification No. **IP6CPKCP5**

Test Description

Identification no. of WPS followed **LAB 97-05 rev.0** Test coupon Production weld
 Specification type/grade or UNS of base **A106-GR.B** Thickness **7.1 mm**

Testing Conditions And Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es)	GTAW	GTAW
Type (i.e.; manual, semi-auto) used	Manual	Manual
Backing (with/without)	Without	With / Without
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter if pipe or tube)	48.3 mm	≥ 25 mm
Base Metal P-Number to P-Number	1	P1 through P15F, P34, P41 through P49
Filler metal or electrode specification(s) (SFA) (info. only)	5.18	For info only.
Filler metal or electrode classification(s) (info. only)	ER70S-3	For info only.
Filler metal F-Number(s)	6	6
Consumable insert (GTAW or PAW)	Without	Without
Filler metal product form (solid/metal or flux cored/powder) (GTAW or PAW)	Solid	Solid or Metal cored
Deposited thickness for each process		
Process 1: GTAW 3 layers minimum <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	7.1 mm	≤ 14.2 mm
Process 2: -- 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	--	--
Position qualified (2G, 6G, 3F, etc.)	6G	All
Vertical progression (uphill or downhill)	Uphill	Uphill
Type of fuel gas (OFW)	N.A.	N.A.
Inert gas backing (GTAW, PAW, GMAW)	Without	With / Without
Transfer mode (spray/globular or pulse to short circuit – GMAW)	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN)	DCEN	DCEN

Results

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

Transverse bends root and face [QW-462.3(a)]; Longitudinal bends root and face [QW-462.3(b)]; Side bends (QW-462.2);
 Pipe bend specimen, Macro test for fusion [QW-462.5(b)]; Plate bend specimen, Macro test for fusion [QW-462.5(e)]
 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) **Acceptable** RT UT (check one)
 Fillet weld – fracture test (QW 181.2) **--** Length and percent of defects **-- x --**
 Fillet welds in plate (QW-462.4(c)) Fillet welds in pipe (QW-462.4(c))
 Macro examination (QW-184) **--** Fillet size (in/mm) **-- x --** Concavity/convexity (in/mm.) **--**
 Other tests **None**

Film or specimens evaluated by **W.J. Cowan** Company **MME**
 Mechanical tests conducted by **--** Laboratory test no. **--**
 Welding supervised by **A. Verduyn (Lastechisch Advies Buro), Det Norske Veritas**

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 Code Ed. 2015 Add. --.

Date issued **15 August 2016**

Manufacturer's Representative
 Manufacturer **Holland Welding Support**

A.M.(Ton) Konings
 Surveyor to Lloyd's Inspection Services



A subsidiary of Lloyd's Register Group Limited

Lloyd's Register Group Limited, its affiliates and subsidiaries and their respective officers, employees or agents are, individually and collectively, referred to in this clause as 'Lloyd's Register'. Lloyd's Register assumes no responsibility and shall not be liable to any person for any loss, damage or expense caused by reliance on the information or advice in this document or howsoever provided, unless that person has signed a contract with the relevant Lloyd's Register entity for the provision of this information or advice and in that case any responsibility or liability is exclusively on the terms and conditions set out in that contract.