



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 752 rev.0** Test coupon Production weld
 Specification type/grade or UNS of base **A312-TP316L** Thickness **5.08 mm**

Testing Conditions And Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es) Type (i.e.; manual, semi-auto) used	GTAW Manual	GTAW Manual
Backing (with/without) <input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter if pipe or tube)	Without 48.3 mm	With / Without ≥ 25 mm
Base Metal P-Number to P-Number	8	P1 through P15F, P34, P41 through P49
Filler metal or electrode specification(s) (SFA) (info. only)	5.9	For info only.
Filler metal or electrode classification(s) (info. only)	ER316LSi	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 corded/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	5.08 mm	≤ 10.16 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)	With	With
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
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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-184) Fillet welds in pipe (QW-462.4(c))
 Macro **--** Fillet size (in/mm) **-- x --** Concavity/convexity (in/mm.) **--**
 Other tests **None**

NDE: RT report 13JC0241

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

Witnessed
 Reviewed
 Examined
 Ton Konings
 Lloyd's Register Nederland B.V.

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