

WELDER QUALIFICATION RECORD

Last Name

[illegible]**Test Date**

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TESTING CONDITIONS

Weld Test Specification followed: UA-63 / NCPWB 1-32-1

Specification of Base Metal(s): SA 106 Thickness: 0.625"

QUALIFICATION LIMITS

Welding Variables	Actual Values		Ranges Qualified	
Process	GTAW	SMAW	GTAW	SMAW
Backing	none	weld metal	with or without	required
Use of Filler Metal	with	n/a	required	n/a
Filler Metal Product	solid	n/a	solid or metal	n/a
Filler Metal F-Number	6	4	6	4, 3, 2, 1
Consumable Inserts	none	n/a	without	n/a
Deposited Weld Thickness	0.125"	0.500" deposited over 3 layers	up to 0.250"	unlimited
Inert gas backing	none	n/a	with or without	n/a
Current / Polarity	DC/EN	n/a	DC/EN	n/a
Pipe Diameter	2.750" O.D.		1" O.D. & over	
Base Metal P-Number	P-1 to P-1		P-1 through P-11	
Position	6G		all	
Vertical Progression	upward		upward	

EXAMINATION RESULTS

ATR Visual Examination of Completed Weld (QW-302.4): Acceptable

Test Lab Radiographic Examination Results (QW-191): Acceptable

[illegible]

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with requirements of Section IX of the ASME Code.

Date:

Date:

Date: