Sample Single-Process WPQ Form

WELDER, WELDING OPERATOR, OR TACK WELDER QUALIFICATION TEST RECORD

Name	Z.W. Elder	OPTIONAL PHOTO ID	Test Date	12-12-2014	Rev.
ID Number	00-001-ZWE		Record No.	WPQ-001	0
Stamp No.	ZWE-01		Std. Test No.	ST-001	0
Company	RED Inc.		WPS No.	WPS-001	0
Division	-		Qualified To	AWS D1.1	

BASE METALS	Specification	Type or Grade	AWS Group No.	Size (NPS)	Schedule	Thickness	Diameter
Base Material	ASTM A36	UNS K02600	I	-	-	3/8”	-
Welded To	ASTM A36	UNS K02600	I	-	-	3/8”	-

VARIABLES	Actual Values		RANGE QUALIFIED
Type of weld joint	Plate – Groove (Fig 4.31) w/backing		Groove, Fillet, Plug & Slot welds (T-,Y-,K-Groove PJP only)
Base metal	Group I to Group I		Carbon and Low-Alloy Steel

	Groove	Fillet		Groove	Fillet
Plate Thickness	3/8”	-		1/8” – 3/4”	1/8” min.
Pipe/Tube Thickness	-	-		1/8” – 3/4”	unlimited
Pipe Diameter	-	-		24” min.	unlimited

Welding Process	**GMAW**		**GMAW**
Type (Manual/Mach./Auto./Semi.)	semiautomatic		semiautomatic, machine, automatic
Backing	with		with
AWS Filler Metal Spec.	5.18		A5.xx
AWS Classification	ER70S-6		All
F-Number	-		-
Position	2G, 3G and 4G		
Groove – Plate & Pipe >=24”			All
Groove – Pipe < 24”			-
Fillet – Plate & Pipe >=24”			All
Fillet – Pipe < 24”			All
Progression	Vertical up		Vertical up
GMAW Transfer Mode	Globular		Spray, pulse, globular
Single or Multiple Electrodes	Single		Single
Gas/Flux Type	A5.32 SG-C		A5.xx approved

TEST RESULTS

Type of Test	Acceptance Criteria	Result	Remarks
Visual examination per 4.31.1	4.9.1	Acceptable	-
1 transverse root bend per 4.9.3.1 and Fig. 4.12	4.9.3.3	Acceptable	-
1 transverse face bend per 4.9.3.1 and Fig. 4.12	4.9.3.3	Acceptable	Small (<1/16”) opening

CERTIFICATION

Test Conducted by	
Laboratory	WeldingForms Lab
Test number	Fictitious Test XYZ
File number	WeldingForms/Sample-WPQ-for-GMAW.pdf

We, the undersigned, 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 Clause 4 of AWS D1.1/D1.1M (___2015____) Structural Welding Code-Steel.

Manufacturer or Contractor **RED Inc.** Authorized By **E. M. Ployee (Q.C. Mgr.)**

Date **12/12/2014**

Sample Single-Process WPQ Form

WELDER, WELDING OPERATOR, OR TACK WELDER QUALIFICATION TEST RECORD

Name	Z.W. Elder	OPTIONAL PHOTO ID	Test Date	12-12-2014	Rev.
ID Number	00-001-ZWE		Record No.	WPQ-003	0
Stamp No.	ZWE-01		Std. Test No.	ST-003	0
Company	RED Inc		WPS No.	WPS-003	0
Division	-		Qualified To	AWS D1.1	

BASE METALS	Specification	Type or Grade	AWS Group No.	Size (NPS)	Schedule	Thickness	Diameter
Base Material	ASTM A36	UNS K02600	II	-	-	1”	-
Welded To	ASTM A36	UNS K02600	II	-	-	1”	-

VARIABLES	Actual Values		RANGE QUALIFIED
Type of weld joint	Plate – Groove (Fig 4.31) with backing		Groove, Fillet, Plug & Slot welds (T-,Y-,K-Groove PJP only)
Base metal	Group II to Group II		Carbon and Low-Alloy Steel

	Groove	Fillet		Groove	Fillet
Plate Thickness	1”	-		1/8” min.	1/8” min.
Pipe/Tube Thickness	-	-		1/8” min.	unlimited
Pipe Diameter	-	-		24” min.	unlimited

Welding Process	**GTAW**	**SMAW**	**FCAW**		**GTAW**	**SMAW**	**FCAW**
Type (Manual/Mach./Auto./Semi.)	Manual	Manual	Semi-auto		Man/Mach/Auto	Manual	Semi/Mach/Auto
Backing	With	With	With		With	With	With
Filler Metal AWS Spec.	5.18	5.1	5.20		A5.xx	A5.xx	A5.xx
AWS Classification	ER70S-2	E7018	E70T-6		All	All	All
F-Number	-	4	-		-	1 thru 4	-
Position	1G	1G	1G				
Groove–Plate & Pipe >=24”					F	F	F
Groove – Pipe < 24”					-	-	-
Fillet – Plate & Pipe >=24”					F,H	F,H	F,H
Fillet – Pipe < 24”					F,H	F,H	F,H
Progression	-	-	-		-	-	-
GMAW Transfer Mode	-	-	-		-	-	-
Single or Multiple Electrodes	Single	-	Single		Single	-	Single
Gas/Flux Type	A5.32 SG-A	-	None		A5.xx approved	-	A5.xx approved

TEST RESULTS

Type of Test	Acceptance Criteria	Result	Remarks
Visual examination per 4.31.1	4.9.1	Acceptable	-
2 transverse side bends per 4.9.3.1 and Fig. 4.13	4.9.3.3	Acceptable	-

CERTIFICATION

Test Conducted by	
Laboratory	WeldingForms Lab
Test number	Fictitious Test ZYX
File number	WeldingForms/Sample-WPQ-for-GTAW-SMAW-FCAW.pdf

We, the undersigned, 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 Clause 4 of AWS D1.1/D1.1M (__2015__) Structural Welding Code-Steel.

Manufacturer or Contractor **RED Inc.** Authorized By **E. M. Ployee (Q.C. Mgr.)**

Date **12/12/2014**