

WeldOffice® printout sample - ASME WPO

C-spec

P.O. Box 27604, Concord, California 94527 (877) 977-7999
ASME Section IX - Welder Performance Qualification (WPQ)
 Created with WeldOffice® WPQ Module



| | | | |
|---------------|-----------|----------------------|-----------------|
| Welder's name | Rod Laver | Test date | 1/6/02 |
| ID Number | 5555 | WPQ record number | 500-5555 |
| Date of birth | 4/17/23 | Standard test number | Rev. |
| Stamp number | 500 | WPS record number | Rev. |
| Company name | C-spec | Qualification code | ASME Section IX |
| Division | Concord | | |

BASE METALS (QW-403)

| | Product form | Specification (type or grade) | P no. | Grp-no. | Size | Sch. | Thick. (in.) | Dia. (in.) |
|------------|--------------|-------------------------------|-------|---------|------|------|--------------|------------|
| Welded to: | Pipe | SA-106 (B) | 1 | 1 | 6 | XX | 0.864 | 6.625 |
| | Pipe | SA-106 (B) | 1 | 1 | 6 | XX | 0.864 | 6.625 |
| Joint type | Groove | | | | | | | |

VARIABLES

| | Actual values | RANGE QUALIFIED |
|--------------------|---------------|-------------------------------|
| Type of weld joint | Pipe - Groove | Groove and Fillet welds |
| Base metal | P1 to P1 | P-no./S-no. 1 thru 11, 34, 4X |

BASE METAL THICKNESS

| | Groove | Fillet | Overlay | Groove | Fillet | Overlay |
|---------------------------|--------|--------|---------|-----------|----------|---------|
| Plate thickness (in.) | - | - | - | no limit | no limit | - |
| Pipe/tube thickness (in.) | 0.864 | - | - | no limit | no limit | - |
| Pipe diameter (in.) | 6.625 | - | - | 2.875 min | no limit | - |

PROCESS VARIABLES

| | Actual values | | RANGE QUALIFIED | |
|--|---------------|----------------|-------------------|------------------------|
| Welding process | SMAW | FCAW | SMAW | FCAW |
| Type | Manual | Semi-automatic | Manual | Semi-automatic |
| Backing | Without | With | With, without | With |
| Filler metal specification | 5.1 | 5.20 | 5.xx | 5.xx |
| Filler metal classification | E6010 | E71T-12M | Any | Any |
| Filler metal F-number | 3 | 6 | 3(1..3 w/backing) | 6 |
| Number of layers deposited | 2 | 3 min | | |
| Weld deposit thickness (in.) | 0.250 | 0.614 | 0.5 max | no limit |
| Weld position (Actual position tested) | 6G | 6G | | |
| Groove - Plate & Pipe >24" | | | All | All |
| Groove - Pipe 2.875" to 24" | | | All | All |
| Groove - Pipe < 2.875" | | | - | - |
| Fillet - Plate & Pipe >24" | | | All | All |
| Fillet - Pipe 2.875" to 24" | | | All | All |
| Fillet - Pipe < 2.875" | | | All | All |
| Progression | Up | | Up | Up |
| Backing gas | - | Without | - | With, without |
| GMAW transfer mode (QW-409) | - | Globular | - | Spray, pulse, globular |

TESTS

| Type of test | Acceptance criteria | Result | Comments |
|---|---------------------|------------|-----------------------------------|
| 4 transverse side bends per QW-161.1 and QW-462.2 | QW-163 | Acceptable | see - ASME IX - QW-452.1 Note (4) |
| Visual examination per QW-302.4 | QW-194 | Acceptable | see - ASME IX - QW-452.1 Note (8) |
| Notes | | | |

CERTIFICATION

| | | | |
|---------------------|--------------|------------------------|-----|
| Tests conducted by | Nick Mossman | Laboratory test number | 001 |
| Mechanical tests by | Nick Mossman | Test file number | 001 |

We 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 Section IX of the ASME Code.

Welding Engineer

QA Manager

| Name | Signature | Name | Signature |
|--------------|-----------|-----------------|-----------|
| Nick Mossman | | Michal Bernasek | |
| Date | | Date | |
| 3/30/01 | | 3/30/01 | |

Signature 3

Signature 4

| Name | Signature | Name | Signature |
|-----------------|-----------|----------------|-----------|
| Michele Mossman | | Charles Foster | |
| Date | | Date | |
| 3/30/01 | | 3/30/01 | |