

Warehouse 1

Welder Qualification Test Record

WH1 GMAW-3G Williams N

WQTR No. WH1 GMAW-3G Williams N Welder Name Norman D. Williams Welder Id 5327389
 WPS No. WH1-GMAW-1 Revision 0 Date 3/10/2017

Variables	Record Actual Values Used In Qualification
Process (Table 4.10, Item (1))	<u>GMAW</u>
Transfer Mode (GMAW): Short-Cir. <input type="checkbox"/> Globular <input checked="" type="checkbox"/> Spray <input type="checkbox"/>	
Type Manual <input type="checkbox"/> Machine <input type="checkbox"/> Semi-Auto <input checked="" type="checkbox"/> Auto <input type="checkbox"/>	
Number of Electrodes Single <input checked="" type="checkbox"/> Multiple <input type="checkbox"/>	
Current/Polarity AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>	
Position (Table 4.10, Item (4))	<u>3G</u>
Weld Progression: (Table 4.10, Item (6)) Up <input checked="" type="checkbox"/> Down <input type="checkbox"/>	
Backing [Table 4.10, Item (7)] Use Backing <input type="checkbox"/>	
Consumable Insert (GTAW) Use Insert <input type="checkbox"/>	
Material/Spec. <u>ASTM A36</u> to <u>ASTM A36</u>	
Thickness (Plate): Groove () <u>3/8"</u>	
Fillet () <u>NA</u>	
Thickness (Pipe/tube): Groove () <u>NA</u>	
Fillet () <u>NA</u>	
Diameter(Pipe): Groove () <u>NA</u>	
Fillet () <u>NA</u>	
Notes <u>NA</u>	
Filler Metal (Table 10, Item (2))	
Spec. <u>AWS A5.18</u>	
Class. <u>ER70S-6</u>	
F-No. <u>6</u>	
Gas/Flux Type (Table 4.10, Item (3)) <u>75Ar/25CO2</u>	
Other <u>.035" Diameter</u>	

Qualification Range	
<u>GMAW</u>	
Short-Circuiting <input type="checkbox"/> Globular <input checked="" type="checkbox"/> Spray <input checked="" type="checkbox"/>	
Manual <input type="checkbox"/> Machine <input type="checkbox"/> Semi-Auto <input checked="" type="checkbox"/> Auto <input type="checkbox"/>	
Single <input checked="" type="checkbox"/> Multiple <input type="checkbox"/>	
AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>	
<u>1F-G, 2F-G, 3F-G</u>	
Up <input checked="" type="checkbox"/> Down <input type="checkbox"/>	
With Backing <input checked="" type="checkbox"/> Without Backing <input checked="" type="checkbox"/>	
With Insert <input type="checkbox"/> Without Insert <input type="checkbox"/>	
Groups I & II	
<u>1/8"</u>	- <u>3/4"</u>
<u>1/8"</u>	- <u>Unlimited</u>
<u>1/8"</u>	- <u>Unlimited</u>
<u>1/8"</u>	- <u>Unlimited</u>
<u>24"</u>	- <u>Unlimited</u>
<u>1/8"</u>	- <u>Unlimited</u>
<u>NA</u>	
<u>NA</u>	
<u>All AWS A5.18</u>	
<u>NA</u>	

VISUAL INSPECTION (4.8.1) Acceptable Yes

GUIDED BEND TEST RESULTS (4.30.5)

Type	Result	Type	Result
NA	NA	NA	NA
NA	NA	NA	NA

Fillet Test Results (4.30.2.3 and 4.30.4.1)

Appearance NA Fillet Size NA Macroetch NA
 Fracture Test Root Penetration NA Description NA
 Inspected By Joseph M. Vincent Test No. 170324-1 Organization Olsson Associates Date 3/10/2017

RADIOGRAPHIC TEST RESULTS (4.30.3.1)

Film Identification	Remark	Interpreted By
<u>NW 5327389</u>	Porosity	<u>Jason Burnett</u>
<u>NA</u>	NA	Organization <u>Olsson Associates</u>
<u>NA</u>	NA	Test No. <u>NW 5327389</u>
<u>NA</u>	NA	Date <u>3/13/2017</u>

We, the undersigned, certify that the statements in this record are correct and that the test results were prepared, welded and tested in accordance with the requirements of section 4 of ANSI/AWS D1.1-2015 Structural Welding Code-Sheet Steel.

Manufacturer Warehouse 1 Authorized By Dennis Delantonas Date 3/10/2017