Warehouse 1

WQTR No. 170324 Welder Name Norman D. Williams Welder Id 5327389

WPS No. AWS B2-1-1-004:2002 Revision 0 Date 03/10/17

Variables	Record Actual Values Used In Qualification	Qualification Range
Process	GMAW	GMAW
Transfer Mode (GMAW):	Short-Cir. ☒ Globular ☐ Spray ☐	Short-Circuiting ☒ Globular ☐ Spray ☐
Type	Manual ☐ Machine ☐ Semi-Auto ☒ Auto ☐	Manual ☐ Machine ☐ Semi-Auto ☒ Auto ☐
Number of Electrodes	Single ☒ Multiple ☐	Single ☒ Multiple ☐
Current/Polarity	AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐	AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐
Position	3G	1, 2, & 3G
Weld Progression:	Up ☒ Down ☐	Up ☒ Down ☐
Backing	Use Backing ☐	With Backing ☐ Without Backing ☒
Consumable Insert (GTAW)	Use Insert ☐	With Insert ☐ Without Insert ☐
Material/Spec.	ASTM A653 to ASTM A653	AWS D1.1 Table 3.1 Base Metals
Thickness (Plate): Groove (☒)	12 Ga. .104"	.052" - .187"
Fillet (☒)	NA	NA - NA
Thickness (Pipe/tube): Groove (☐)	NA	.052" - .187"
Fillet (☐)	NA	NA - NA
Diameter(Pipe): Groove (☐)	NA	Unlimited - Unlimited
Fillet (☐)	NA	Unlimited - Unlimited
Notes	NA	NA
Filler Metal		not to exceed 70 Tensile Strength
Spec.	AWS A5.18	A5.18
Class.	ER70S-6	FB&V = Flare Bevel and Flare V
F-No.	F6	UH = Uphill progression
		DH - Downhill Progression
Gas/Flux Type	90%Argon / 10%CO2	All Tests performed "Sheet to Sheet", also qualify
Other	Wire diameter not limited	"Sheet to Supporting Member".

VISUAL INSPECTION **Acceptable** Yes

GUIDED BEND TEST RESULTS

Type	Result	Type	Result
1 - Butt J 3G UH	Acceptable	NA	NA
NA	NA	NA	NA

Test Results

Appearance Acceptable Fillet Size NA Macroetch NA

Fracture Test Root Penetration Acceptable Description no rejectable flaws observed

Inspected By Joseph M. Vincent Test No. 170310-2 Organization Olsson Associates Date 03/10/17

RADIOGRAPHIC TEST RESULTS

Film Identification	Result	Remark
NA	NA	NA
NA	NA	NA
NA	NA	NA
NA	NA	NA

Interpreted By NA
Organization NA
Test No. NA
Date NA

AWS Joseph M. Vincent SCWI 07110018 QC1 EXP. 11/1/2019

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 section 4 of ANSI/AWS D1.3, (2008) Structural Welding Code Sheet Steel

Manufacturer Warehouse 1 Authorized By Dennis Delantonas Date 3/10/17