# **Welding Qualification**

#### Introduction:

This Bulletin contains requirements for the qualification of welders regarding B620 program and the material joining processes they use during welding. All B620 welders who did not pass the welding performance qualification after April 24, 2016 or did not weld and record weld reports for more than 6 months, should prepare test plates and send it to qualifying.

### **Procedure Qualification Record (PQR):**

PQR is what occurred in the section fifteen (15) of Quality Control Manual and the related forms.

The PQR shall be accessible to the authorized Inspector at any time. A procedure specification may be supported by one or more PQR(s).

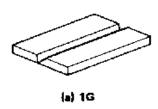
# Welder Performance Qualification (WPQ):

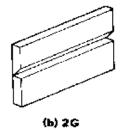
The purpose of qualifying the person who will use a welding process, proposed for repair, modification or assembly of B620 tanks, is to demonstrate that person's ability to produce an acceptable joint when using a procedure specification.

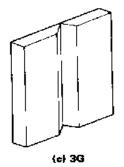
As a minimum, the WPQ document the essential variables for each process used to produce the test plates, the ranges of variables qualified, and the results of the required testing.

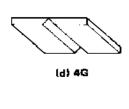
In order to get the qualification, each welder need to send four (4) different plates for each material, which are welded, in four (4) different positions:

1.	Flat	(1G)
2.	Horizontal	(2G)
3.	Vertical	(3G)
4.	Overhead	(4G)









The requirements are four (4) plates with the following specification for material 1 and material 2 = eight (8) plates:

- Material 1:5454 (5052 could be used also)
- Material 2:6061
- Size: 6" long, 6" wide, 1/8"-5/16" thickness

# Setup for weld:

- Clean all pieces,
- Bevel weld sides, and tack them together,



- Mark/ engrave required information including position,ID number, which side, and material.
- Then, weld in all different 4 positions



### Notes:

Do Not Grind, Clean, Cut, or Bend the plates.





After the plates are prepared, ship all eight (8) plates along with filled NEE-FRM-019 (WPQ), related Mill test reports, and provide PO# for \$175 to Chris Gerullis in the following address:

1431 Church Avenue, Winnipeg, MB, R2X 1G5

There is a two (2) weeks time to check the plates and send back the result.

After the qualification, the test coupons along with the related documents including NEE-FRM-013 (Welding inspection report) and NEE-FRM-016 (Welding continuity log) should be kept and available in the shop by welder.

	L ENERGY NT INC.	Welding Performance Qualification (WPQ
orm Number:NEE-FRM-019	Page 1 of 1	Revision: 0
Welders Name:		Identification Number:
WPS Used:		Test Coupon:
Date (richar)		THE STATE OF THE S
	Actual Values	Range Values
Welding process		2
Type of Welder	_	-
Plate or Pipe Base Metal		-
Filler Metal Spec		-
Filler Metal Class		
Filler Metal	_	-
Consumable Insert		
Filler Type		
Position Qualified		
Inert Gas Used		
Voltage		
Amperage		-
Transfer Mode		
Welder Polarity		
Cleaning Type	1	
Welder and Welding Supervisor a	are responsible for the test co	opons being prepared and welded in
accordance with requirements of		
Welding Supervisor:		Signature:
Location:		Signature:
	Deserte of Res	AT-
Visual Exam	Results of Ber instion of Complete Weld:	
Type of Test: Code:		Root or Face Result:
	CD - 27 - 20 - 40 - 40 - 40 - 40 - 40 - 40 - 40	-
Type of Test:	ination of Complete Weld:	Root or Face
Code:		Result:
Mechanical Test Preformed by:		Signature:
Location: :		
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