

Suggested Format A for Welder performance Qualification (WPQ)
(see QW-301 Section IX ASME Boiler and Pressure Vessel Code)

Welder's Name **Scott Gira** Identification no. **5843**
 Identification of WPS followed **GMAW-AL-01** Test Coupon Production Weld
 Specification of base material **P22 to P22** Thickness **0.25" Plate** Date Welded **July 30, 2019**

Testing conditions and Qualification Limits		
<i>Welding Variables (QW-350)</i>	<i>Actual Values</i>	<i>Range Qualified</i>
Welding process	GMAW	GMAW
Type (ie. manual, semi-automatic used)	Semi-Automatic	Semi-Automatic
Backing (with/without)	With Backing (Back-gouged)	With Backing
Plate or Pipe (enter diameter if pipe or tube)	0.25" Plate	1/16" to 0.5" Fillet - All thicknesses
Base metal P no. or S no. joined to P no. or S no.	P22	P21 through P26
Filler metal or electrode specification (SFA)	A5.10	A5.10
Filler metal or electrode classification (info. only)	ER5356	Any
Filler metal F no.	F22	F21 through F26
Consumable insert (GTAW or PAW)	N/A	N/A
Filler Metal Production Form	Solid Wire	Solid Wire
Deposit thickness for each process	~0.25 in	~0.5 in
Process 1 (GMAW) 3 layers minimum YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	—	—
Position qualified (2G, 6G, 3F etc.)	2G, 3G-U, 4G	Horizontal, Vertical(UP), Overhead
Vertical progression (uphill or downhill)	N/A	N/A
Type of Shielding gas (GMAW)	100% Argon	Any
Type of Backing gas	N/A	N/A
Transfer mode (spray / globular or pulse to short circuit)	Spray	Global, Spray or Pulsed
GTAW current type/polarity (AC, DCEP, DCEN)	N/A	N/A

Results		
Visual Examination of Welds	QW 302.4	Acceptable
Transverse Side bends	QW 462.2	N/A
Transverse Face and Root Bends	QW 462.3a	Acceptable
Longitudinal Bends	QW 462.3b	N/A
Pipe Bends Corrosion Resistant Overlay	QW 462.5c	N/A
Plate Bends Corrosion Resistant Overlay	QW 462.5d	N/A
Pipe Macro Test for Fusion	QW 462.5b	N/A
Plate Macro Test for Fusion	QW 462.5e	N/A

QW 302.4	Alternative Radiographic Examination	N/A
QW 180	Fillet Weld Fracture Test Fracture Test Length and % Defects	N/A
QW 184	Macro Examination fillet size & concavity and convexity	N/A
QW 304	Specimens Evaluated by	National Energy Equipment
	Welding Supervised by	Zanyar Farhadi
	Mechanical Tests Conducted by Lab	Industrial Technology Centre
	Lab Test No.	MT010-17920

We certify that the statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with the requirements Section IX of ASME Boiler and Pressure Vessel Code



Date of Issue: August 09, 2019

Certified by: Zanyar Farhadi
Organization: National Energy Equipment

Mechanical Test Laboratory Report

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Sample Description: Aluminum Welds – Welder 5843 in positions GMAW 2G, 3G, 4G
Parent Material: 5052 (1/4" Thick), Filler Metal: ER5356

Standard/Specification: ASME IX: ✓ QW-160 Guided Bend Tests

Tests accredited by the Standards Council of Canada to ISO/IEC 17025 indicated with ✓.

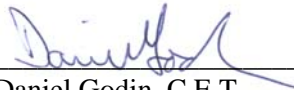
Note: Samples will be retained by ITC for 90 days from test date unless by other arrangement.


Test Results

Table 1: Weld Bend Test Results

Sample ID	Pass/Fail	Comments
5843-2G – Face	Pass	No Visible Cracks
5843-2G – Root	Pass	No Visible Cracks
5843-3G – Face	Pass	No Visible Cracks
5843-3G – Root	Pass	No Visible Cracks
5843-4G – Face	Pass	No Visible Cracks
5843-4G – Root	Pass	No Visible Cracks

End of Report

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Notes

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