## Welder Performance Qualification (WPQ)

ASME Boiler and Pressure Vessel Code, Section IX, QW-301

Company Name: WPSAmerica					
Company runter of Drinelica	a.com				
Company Address: info@WPS	SAmerica.com, 1 (877) W	PS-WELD			
Welder Performance Qualifica	ation WPO No. DEMO-W	/PO	Test Date: 12,12	2, 2005	
Welding Procedure Specificati	•	•	Rev. 0	-, _ • • • -	
Welder's Name: Elvis Tom Jo		Identification No: ETJ	-2005	Stamp No: ETJ-	-05
				<b>F</b>	
BASE METALS (QW-403)					
No: 1 Group No: 1		Material Specification: SA-36		Type or Grade: UNS No. K02600	
Welded to	Crown No. 1	Matarial Spacification	SA 26	Trme on Cheder UNS	No. K02600
P-No: 1	Group No: 1	Material Specification:	5A-30	Type or Grade: UNS	NO. KU2000
hickness in (mm): 1/2 in. (13 n	mm)			*** • •	
ase Metals Thickness Qualifie	ed: No Limit	🗹 Test Coupo	on 🗆 Productio	n Weld	Plate 🗆 Pipe
-					
Welding Variables (QW-350) Diameter, if pipe or tube, in (mm)		Actual Values		Range Qualified	
Backing		Plate tested Without backing		2-7/8 in. (73 mm) OD and over With or without backing	
Base Metals P-Number to P-Number		1 to 1		P-No. 1 thru 15F, 34, 41 thru 49	
		1st Process	2nd Process	1st Process	2nd Process
Velding Process		GMAW	SMAW	GMAW	SMAW
rocess Type		Semi-Automatic	Manual	Semi-Automatic	Manual
esting Position		3G	3G	TT 1 11	** 1 ***
Vertical Progression Velding Positions Oualified:		Uphill	Uphill	Uphill	Uphill
A) Groove, Plate and Pipe ove	er 24 in. (610 mm) OD			F, V	F, V
		D, incl. [*or Min. qualified diameter, if testing small pipe]		F	F
C) Fillet, Plate and Pipe for al	ll thicknesses, fillet sizes, a	and diameters [when testing Groov	e] OR		
C) Fillet, Plate and Pipe 2-7/8	in. (73 mm) OD and over	[when testing Plate Fillet] OR		F, H, V	F, H, V
C) Fillet, Plate and Pipe withi	n qualified diameter rand	a [whon testing Pine Fillet]			
iller Metal Specification (SFA)		SFA 5.18	SFA 5.1		
	-,	01110110			
iller Metal Classification		ER70S-6	E7018		
		ER70S-6 6	E7018 4	6	1 to 4
`iller Metal F-Number `iller Metal Product Type (GT		6 n/a	4 n/a	n/a	n/a
'iller Metal F-Number 'iller Metal Product Type (GT )eposited Weld Thickness, in (	( <b>mm</b> )	6	4	n/a 1/4 in. (6 mm)	n/a 3/4 in. (20 mm)
iller Metal F-Number iller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P	( <b>mm</b> )	6 n/a 1/8 in. (3 mm)	4 n/a 3/8 in. (10 mm)	n/a 1/4 in. (6 mm) n/a	n/a 3/4 in. (20 mm) n/a
Tiller Metal F-Number Tiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode	(mm) AW)	6 n/a	4 n/a	n/a 1/4 in. (6 mm)	n/a 3/4 in. (20 mm)
Tiller Metal F-Number Tiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity	(mm) AW)	6 n/a 1/8 in. (3 mm) Short Circuit	4 n/a 3/8 in. (10 mm) n/a	n/a 1/4 in. (6 mm) n/a Short Circuit	n/a 3/4 in. (20 mm) n/a n/a
Yiller Metal F-Number Yiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity nert Gas Backing (GTAW, PA	(mm) AW)	6 n/a 1/8 in. (3 mm) Short Circuit n/a	4 n/a 3/8 in. (10 mm) n/a n/a	n/a 1/4 in. (6 mm) n/a Short Circuit n/a	n/a 3/4 in. (20 mm) n/a n/a n/a
Yiller Metal F-Number Yiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Ype of Fuel Gas (OFW)	(mm) AW) AW, GMAW)	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a Results	4 n/a 3/8 in. (10 mm) n/a n/a n/a n/a	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Yiller Metal F-Number Yiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Yupe of Fuel Gas (OFW)	(mm) AW) AW, GMAW) eted Weld Result (QW-30	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a Results 2.4): Acceptable criteria as per ASI	4 n/a 3/8 in. (10 mm) n/a n/a n/a n/a	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Yiller Metal F-Number Yiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Yupe of Fuel Gas (OFW) Yisual Examination of Comple Guided-Bend Tests Type (QW	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2)	4 n/a 3/8 in. (10 mm) n/a n/a n/a n/a	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Tiller Metal F-Number Tiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Type of Fuel Gas (OFW) Tisual Examination of Comple Guided-Bend Tests Type (OW Alternative Volumetric Examination	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Be nation Results (QW-191):	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2)	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT :	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Tiller Metal F-Number Tiller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Type of Fuel Gas (OFW) Tisual Examination of Comple Guided-Bend Tests Type (QW Alternative Volumetric Examinates)	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a Results 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT :	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
iller Metal F-Number iller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P SMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, P Ype of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (OW Iternative Volumetric Examination cesult and Comments: Two sid illet-Weld Tests (OW-180): P racture Test (OW-182): n/a	(mm) AW) eted Weld Result (QW-30 -160): Transverse Side Be nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe-	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Accepto-Plate or Pipe-to-Pipe [QW-462.2. L	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts:	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
iller Metal F-Number iller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P SMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) visual Examination of Comple Guided-Bend Tests Type (OW Iternative Volumetric Examination cesult and Comments: Two sid illet-Weld Tests (OW-180): P racture Test (OW-182): n/a facro-Examination (QW-184)	(mm) AW) eted Weld Result (QW-30 -160): Transverse Side Be nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- ): n/a F	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Accepto-Plate or Pipe-to-Pipe [QW-462.2. L L illet Size in (mm): X	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194 ME OW-194	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
iller Metal F-Number iller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P SMAW Transfer Mode TAW Current Type/Polarity nert Gas Backing (GTAW, P ype of Fuel Gas (OFW) 'isual Examination of Comple Guided-Bend Tests Type (OW Iternative Volumetric Examination cesult and Comments: Two sid illet-Weld Tests (OW-180): P 'racture Test (OW-182): n/a facro-Examination (QW-184) cesult and Comments: Groove	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]: Pipe- b): n/a F e weld test qualifies fillet v	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Accepto- to-Plate or Pipe-to-Pipe [OW-462.4 L illet Size in (mm): X weld test as well	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME QW-194 ME QW-194 table criteria as per ASM 4(c)] ength and Percent of Defe	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
iller Metal F-Number iller Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P SMAW Transfer Mode STAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (QW Iternative Volumetric Examination cesult and Comments: Two sid illet-Weld Tests (QW-180): P Vacture Test (QW-182): n/a facro-Examination (QW-184) cesult and Comments: Groove Other tests and examinations:	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- ): n/a F e weld test qualifies fillet y This Demo WPQ form ha	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Acceptor to-Plate or Pipe-to-Pipe [QW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica.	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194 ME OW-194 ME oW-194 (c)] ength and Percent of Defe	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
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Filler Metal F-Number Filler Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (QW Alternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (QW-180): P Fracture Test (QW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated by Mechanical tests conducted by	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]: Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Acceptor to-Plate or Pipe-to-Pipe [OW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C . L	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME OW-194 ME OW-194 ME oW-194 (c)] ength and Percent of Defe com Online Welding Softw ompany: Testing Lab Dat	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc.	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Filler Metal F-Number Filler Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (QW Alternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (QW-180): P Fracture Test (QW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated by Mechanical tests conducted by Welding supervised by: WPSA	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd America.com Certified Wo in this record are correct	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Acceptor to-Plate or Pipe-to-Pipe [OW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C . L elding Inspector (CWI) : and that the test coupons were pres-	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME QW-194 ME QW-194 ME QW-194 (c)] ength and Percent of Defe com Online Welding Softw ompany: Testing Lab Dat aboratory Test No. 1012-N	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc. MIG	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Filler Metal F-Number Filler Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (OW- Miternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (OW-180): P Fracture Test (OW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated by Mechanical tests conducted by Welding supervised by: WPSA We certify that the statements Section IX of the ASME Boiler Manufacturer/ Contractor	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd America.com Certified Wo in this record are correct	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a ned as per ASME QW-462.2. Acceptor to-Plate or Pipe-to-Pipe [OW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C . L elding Inspector (CWI) : and that the test coupons were pres-	4 n/a 3/8 in. (10 mm) n/a n/a n/a m/a ME QW-194 ME QW-194 ME QW-194 (c)] ength and Percent of Defe com Online Welding Softy ompany: Testing Lab Dat aboratory Test No. 1012-N pared, welded, and tested	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc. MIG	n/a 3/4 in. (20 mm) n/a n/a n/a n/a
Filler Metal F-Number Filler Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (OW- Miternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (OW-180): P Fracture Test (OW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated by Mechanical tests conducted by Welding supervised by: WPSA We certify that the statements Section IX of the ASME Boiler Manufacturer/ Contractor	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd America.com Certified Wo in this record are correct	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (OW-462.2) : n/a need as per ASME QW-462.2. Accept to-Plate or Pipe-to-Pipe [OW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C L elding Inspector (CWI) and that the test coupons were pre- le. Authoriz	4 n/a 3/8 in. (10 mm) n/a n/a n/a m/a ME QW-194 ME QW-194 ME QW-194 ME QW-194 ME QW-194 ctable criteria as per ASM 4(c)] ength and Percent of Defe com Online Welding Softy ompany: Testing Lab Dat aboratory Test No. 1012-N spared, welded, and tested	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc. MIG	n/a 3/4 in. (20 mm) n/a n/a n/a n/a n/a
Filler Metal F-Number Filler Metal Product Type (GT Deposited Weld Thickness, in ( Consumable Insert (GTAW, P GMAW Transfer Mode GTAW Current Type/Polarity (nert Gas Backing (GTAW, PA Type of Fuel Gas (OFW) Visual Examination of Comple Guided-Bend Tests Type (QW Alternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (QW-180): P Fracture Test (QW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated by Mechanical tests conducted by Welding supervised by: WPSA We certify that the statements Section IX of the ASME Boiler Manufacturer/ Contractor Welding Engineer Name: Joe Smith	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd America.com Certified Wo in this record are correct	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a need as per ASME QW-462.2. Accept to-Plate or Pipe-to-Pipe [QW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C L elding Inspector (CWI) and that the test coupons were pre- le.	4 n/a 3/8 in. (10 mm) n/a n/a n/a ME QW-194 ME QW-194 ME QW-194 ME QW-194 otable criteria as per ASM 4(c)] ength and Percent of Defe com Online Welding Softy ompany: Testing Lab Dat aboratory Test No. 1012-N pared, welded, and tested red By: ames Bond	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc. MIG	n/a 3/4 in. (20 mm) n/a n/a n/a n/a n/a
Guided-Bend Tests Type (QW Alternative Volumetric Examin Result and Comments: Two sid Fillet-Weld Tests (QW-180): P Fracture Test (QW-182): n/a Macro-Examination (QW-184) Result and Comments: Groove Other tests and examinations: Film or specimens evaluated b Mechanical tests conducted by Welding supervised by: WPSA	(mm) AW) AW, GMAW) eted Weld Result (QW-30 -160): Transverse Side Bo nation Results (QW-191): de bend tests were examin late [QW-462.4(b)]; Pipe- b): n/a F e weld test qualifies fillet y This Demo WPQ form ha y: Tom Jones : Mechanical Group, Ltd America.com Certified Wo in this record are correct	6 n/a 1/8 in. (3 mm) Short Circuit n/a none n/a 2.4): Acceptable criteria as per ASI end Specimens (QW-462.2) : n/a need as per ASME QW-462.2. Accept to-Plate or Pipe-to-Pipe [QW-462.4 L illet Size in (mm): X weld test as well as been prepared by WPSAmerica. C L elding Inspector (CWI) and that the test coupons were pre- le.	4 n/a 3/8 in. (10 mm) n/a n/a n/a m/a ME QW-194 ME QW-19	n/a 1/4 in. (6 mm) n/a Short Circuit n/a with or without n/a RT or UT : E QW-163 cts: Concavity/Convexity in ware a, Inc. MIG	n/a 3/4 in. (20 mm) n/a n/a n/a n/a n/a