

## WELDING PROCEDURE AND WELDER'S QUALIFICATION TESTS

WELDING CODE: AWS D1.1

COMPANY	<u>YOUR MOM</u>	DATE	<u>April 20, 2009</u>
PROCEDURE NO.	<u>PREQUALIFIED</u>	MANUAL	<u>MANUAL</u>
WELDING PROCESS	<u>SMAW</u>	MATERIAL SPEC	<u>A-53 GRADE B</u>
THICKNESS (IF PIPE, DIA. & WALL)	<u>4" NPS X SCH 40 (0.237")</u>	TRADE NAME	<u>Hobart</u>
FILLER METAL	<u>E7018</u>	TYPE OF BACKING	<u>Steel</u>
FILLER WIRE-DIAMETER	<u>1/8"</u>	UPHILL OR DOWNHILL	<u>Uphill</u>

WELDING PROCEDURE		WELDING TECHNIQUES			
SINGLE/MULTIPLE PASS	<u>Multiple</u>	AMPS	<u>90-150</u>	VOLTS	<u>19-24</u>
SINGLE/MULTIPLE ARC	<u>Single</u>	CURRENT	<u>DC</u>	POLARITY	<u>REV</u>
POSITION OF GROOVE	<u>6G</u>	Wire Speed	<u>N/A</u>	INCHES PER MIN.	<u>6-10</u>
WELDERS NAME	<u>Zon</u>	STAMP	<u>XXX-XX-3584</u>		
WITNESSED BY	<u>Mrs Zon</u>	DATE	<u>April 17, 2009</u>		

### REDUCED SECTION TENSILE TEST

SPECIMEN NO.	DIMENSIONS		AREA	ULTIMATE TOTAL LOAD, LB	ULTIMATE UNIT STRESS, PSI	CHARACTER OR FAILURE AND LOCATION
	WIDTH	THICKNESS				

### GUIDED BEND TEST

TYPE AND FIGURE NO.	RESULT	TYPE AND FIGURE NO.	RESULT

### FILLET TEST RESULTS

Weld Appearance:	Fillet Size:
Macro Etch Test Results:	Position:
Fracture Test Results:	

### RADIOGRAPHIC INSPECTION TEST

FILM I.D.	RESULTS	REMARKS	FILM I.D.	RESULTS	REMARKS
0-1	<b>REJECT</b>	<b>POROSITY</b>	2-0	Acceptable	
1-2	Acceptable				

The above Welder who by virtue of these tests **DOES NOT** meet welder performance requirements in accordance with AWS D1.1.

Tests Conducted By: nobody Level: III Date: April 20, 2009 Laboratory Test No. CTL-0238R