

Common Arc Corporation



Welder Performance Qualification Maintenance Program Manual

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COMMON ARC CORPORATION
WELDER PERFORMANCE QUALIFICATION MAINTENANCE
PROGRAM MANUAL - EDITION 2

Manual Number: _____

Assigned to: _____

Company: _____


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Approved by:



 Chairman, Operating Committee

1/1/07
 Date

The use of the pronoun "he" shall, for the purpose of this Manual, be considered to include and also mean the pronoun "she".

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The Common Arc Corporation (Common Arc) was created by the National Association of Construction Boilermaker Employers (NACBE) in January, 1988. Common Arc is a not-for-profit corporation established with the following purposes:

- foster and advance the interests of construction boilermaker employers;
- promote and further high standards of quality and performance for welders in the construction industry;
- develop a voluntary system for certifying welders employed by construction boilermaker employers;
- collect and distribute information concerning the industry including, but not limited to, the certification and employment status of welders;
- study and report on the benefits of welder qualification and performance certification; and
- perform and do any and all such other acts as are necessary, convenient and proper to the attainment of these objectives.

The affairs of Common Arc are managed by its Board of Directors. Execution of administrative and day-to-day operation of Common Arc has been delegated to the Executive Administrator who reports directly to the Board of Directors. The Executive Administrator shall retain and direct the staffing necessary to effectuate the purposes of Common Arc.

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The Common Arc Board of Directors has established two Committees to assist the Board of Directors, and the Executive Administrator, in the technical/operational and administrative aspects of fulfilling Common Arc's purpose.

- The Operating Committee maintains review of ASME Section IX and NBIC welder and welding operator performance qualification requirements.
- The Executive Committee oversees the day-to-day administrative operation of Common Arc to assure that necessary staffing and equipment are in place and effectively and efficiently operating to meet the purposes of Common Arc.

J. F. Erickson
Executive Administrator

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PURPOSE AND SCOPE

PURPOSE

The purpose of this program is to reduce costs to contractors and the industry while maintaining the current standards of quality and performance. The Program described herein provides a system for the maintenance of a welder's performance qualification among a community of contractors and for the welders' performance qualification testing by a group of contractors.

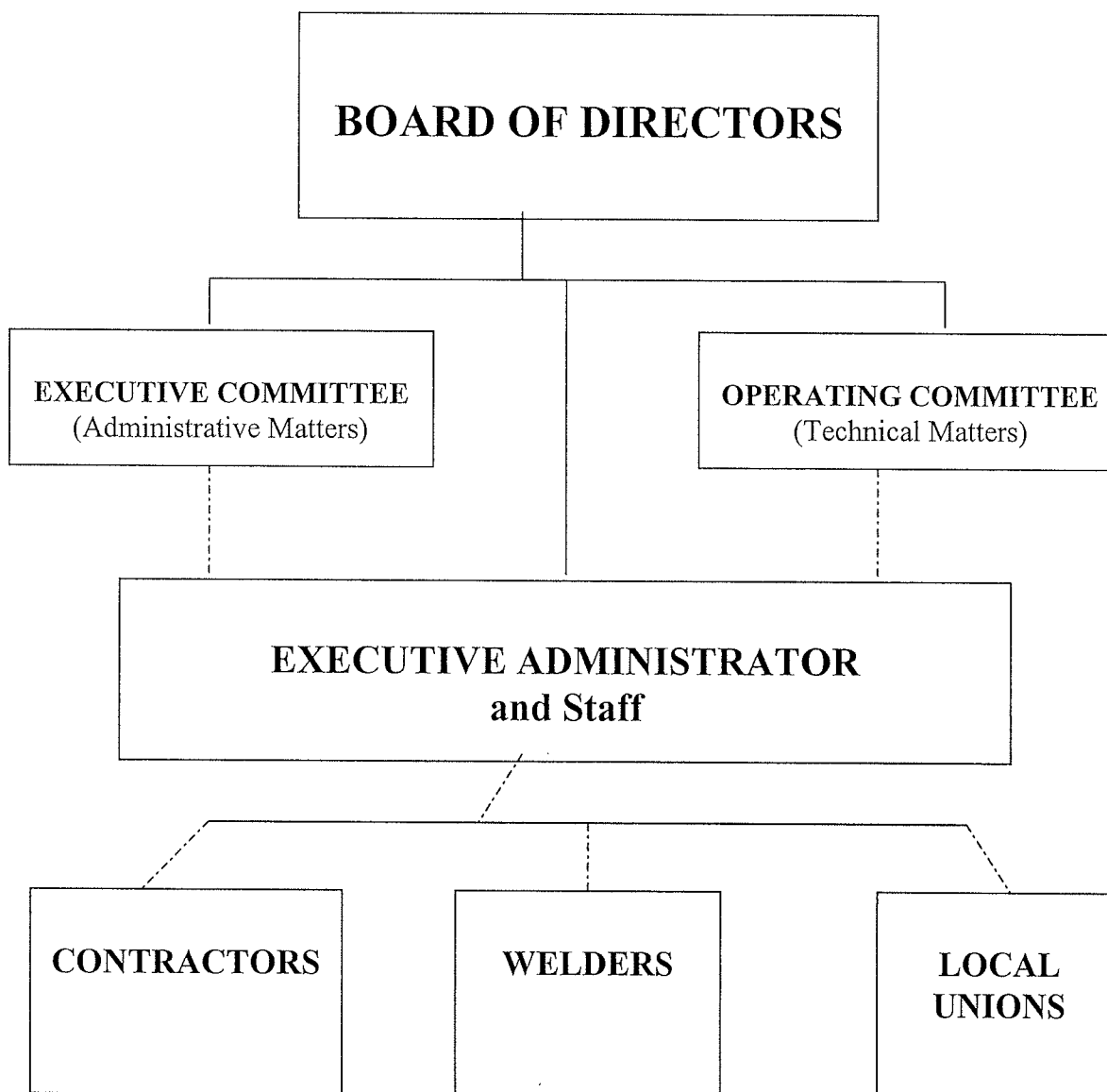
PROGRAM SCOPE

This Program has been developed to assist participating contractors to qualify welders in accordance with the current edition and addenda of Section IX of the ASME Code, and provide all participants with a system that will document, distribute and maintain a current welding history for each participating welder.

The Program is not intended to provide review, certification or endorsement of welding documents as meeting the applicable code requirements for welding and does not relieve the contractor of those responsibilities specified by the ASME Code, the National Board Inspection Code or Authorized Inspection Agency. Each participating contractor shall be responsible for conducting the welder performance qualification test in accordance with his own quality control program and qualified welding procedure specifications. Participating in the Program is subject to the concurrence and acceptance of the participating contractor's Authorized Inspection Agency when required.

This Manual is written to provide all participants with guidelines for compliance and implementation of the Welder Performance Qualification Maintenance Program.

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1.0 ORGANIZATION AND RESPONSIBILITY

1.1 Operating Committee

1.1.1 The Welder Performance Qualification Maintenance Program, hereinafter referred to as the Program, shall be managed by the National Association of Construction Boilermaker Employers (NACBE) with the assistance and support of the International Brotherhood of Boilermakers.

1.1.2 The operational responsibility for the Program shall be delegated to an Operating Committee which shall consist of five (5) or more persons, one of whom shall be designated as Chairman. The Committee shall be appointed by, responsible to, and serve under the direction of and at the pleasure of a Board of Directors appointed by the National Association of Construction Boilermaker Employers (NACBE). The Operating Committee shall administer the Program under the direction of the Directors.

1.1.3 The Chairman, Operating Committee, shall be responsible for Program compliance with the American Society of Mechanical Engineers (ASME) Code and the National Board Inspection Code (NBIC) and for the resolution of administrative matters.

1.1.4 The Operating Committee shall be responsible for providing technical assistance to the Executive Administrator. The Executive Administrator shall be independent of the signatory participants of the Program.

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1.1.5 The Operating Committee shall review for acceptance any proposed revisions to the Program in accordance with Section V of this Manual. All revisions shall meet ASME, NBIC and Authorized Inspection Agency requirements.

1.2 The Participating Contractors

1.2.1 Each participating contractor shall be responsible for his required activities, including record and document distribution as written in this Manual and applicable administrative procedures. Any contractor not fulfilling these responsibilities is subject to suspension from the Program. Documentation of suspension shall be maintained in the contractor's file.

1.2.2 The participating contractor must be a contractor signatory to a continuing collective bargaining agreement with the International Brotherhood of Boilermakers Union or a subordinate construction lodge thereof.

1.2.3 Each participating contractor shall have a written quality control system which includes provisions for assuring that welder qualification and maintenance conforms to requirements of the ASME Code, Section IX.

1.2.4 Each participating contractor shall sign and have on file with the Executive Administrator a Participation Agreement (Exhibit #1).

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- 1.2.5 (A) Except as permitted by (B) or (C) below, participating contractors shall hold either a Certificate of Authorization issued by ASME or the National Board of Boiler and Pressure Vessel Inspectors and/or jurisdictional authorities.
- (B) In lieu of accreditation of (A) above, contractors with ISO or contractors having a 10CFR50 Appendix B program covering welding control may participate in this program. Such quality programs shall be certified by a registrar recognized by the Registrar Accreditation Board.
- (C) To participate, in lieu of (A) or (B) above, contractors shall be surveyed by an accredited ASME Authorized Inspection Agency as directed and selected by the Operating Committee to assure that they have a welding control program meeting the requirements of this program. These contractors shall be audited by the Authorized Inspection Agency for compliance to this program once every three years.
- (D) For options (A) and (B) above, the contractor shall file copies of its Certificate(s) with the Executive Administrator. For option (C), the auditing inspection agency shall issue a report verifying that the contractor meets the requirements of this program. The audit report and contractor certification (Exhibit #5) shall be sent to the Executive Administrator for record and file.

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1.2.6 Each participating contractor shall be responsible for determining the welders ability to deposit sound weld metal and shall complete and sign a Welder Performance Qualification Test Record (WPQT Exhibit Series #10) for each welder tested and certified by the contractor in accordance with this Program and the contractor's quality control program. The completed and signed WPQT shall be submitted to Common Arc for the purpose of maintenance of performance qualification of the welder or welding operator.

1.2.7 For all welders employed by one of the participating contractors, it shall be the responsibility of the participating contractor to complete a Welder History Record (WHR Exhibit #3). The form provides a means of documenting information about a welder, indicating the last date on which the welder welded in a process(es). The completed WHR shall be submitted to Common Arc upon completion of the project, termination of a welder, or on the last calendar working day of the month prior to the welder's expiration date, whichever comes first.

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1.3 Executive Administrator

- 1.3.1 The Executive Administrator shall be responsible for preparing, maintaining, and distributing the Welder Qualification Maintenance Report (WQMR Exhibit #2). The WQMR shall be updated using the information provided on each contractor's Welder Performance Qualification Test Record (WPQT) and the Welder History Record (WHR). The WQMR for each participating contractor and Local Lodge shall be issued on a monthly basis.
- 1.3.2 The Executive Administrator shall be responsible for issuing the Qualification Expiration Notice (QEN Exhibit #4) to the Local Lodge in accordance with Section II of this Manual.
- 1.3.3 The Executive Administrator shall establish and maintain record files as outlined in Section III of this Manual.
- 1.3.4 The Executive Administrator shall assign an individual(s) as Proctor to act as a Common Arc representative during simultaneous testing sessions. The Proctor shall, along with other activities, assure that all participants adhere to the requirements of the Common Arc program manual.

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1.4 Local Lodge

- 1.4.1 The Local Lodge, upon receipt of a Qualification Expiration Notice (QEN) announcing the pending expiration of a welder's qualification, will, before the date stated, instruct the welder as to the steps necessary to maintain his qualification.
- 1.4.2 When welder performance qualification tests are to take place at a location selected by the Executive Administrator, the Executive Administrator and the Local Lodge shall be responsible for coordinating and scheduling the testing and notifying all participating parties of the scheduled testing date.

1.5 Welders

- 1.5.1 Welders who participate in the Welder Performance Qualification Maintenance program shall be responsible to complete the test welds as directed by the contractors.
- 1.5.2 Welders who participate in simultaneous test sessions shall be subject to inspections from all participating contractors present at the session at the contractor's discretion.

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1.5.3 The contractor's decision on the test acceptance or rejection is final. In situations wherein a dispute not relating to test acceptance or rejection occurs, the dispute shall be resolved between the contractor, Local Lodge and Proctor. If unresolvable, the Executive Administrator shall be appraised of the details and make the final decision with the acceptance of test results remaining solely the contractor's responsibility.

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2.0 EXPIRATION AND RENEWAL OF QUALIFICATIONS

2.1 A welder performance qualification for a particular process shall be considered to have expired if any of the following have occurred:

2.1.1 When a welder has not welded with a process during a period of six (6) months or more, his qualification for that process shall be expired.

2.1.2 If a participating contractor reports the welding quality of a welder as unsatisfactory, that contractor may require in writing on the Welder History Record (WHR) that the welder be removed from the participating contractor's list, stating the reason why. On a periodic basis, the Executive Administrator shall distribute a notice to all participating contractors advising them of those welders who have been removed by a participating contractor.

2.1.3 When a welder's performance qualification has expired for reasons outlined in paragraph 2.1.1, renewal of a qualification of a specific welding process may be made by welding a single test coupon of either plate or pipe, of any material, thickness or diameter, and in any position. That coupon shall be tested as required by ASME Section IX. This renews, for each participating contractor witnessing and accepting the test, the welder's previous qualifications for that process for those materials, thicknesses, diameters, positions, and other variables for which he was previously qualified.

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Each participating contractor is responsible for completing and signing a Welder Performance Qualification Test Record (WPQT) for each welder successfully completing the renewal qualification test. A copy of the WPQT, marked to indicate “renewal”, is to be submitted to the Executive Administrator within the time frame identified in Paragraph 1.2.7.

2.1.4 When a welder’s performance qualification has been terminated by a participating contractor for reasons outlined in paragraph 2.1.2, the welder may be reinstated by that participating contractor after successfully completing a welder performance qualification test in accordance with ASME Section IX and the participating contractor’s quality control program. The coupon shall be tested in accordance with ASME Section IX and the contractor’s quality control program. The participating contractor shall complete and sign a Welder Performance Qualification Test Record (WPQT) for each welder successfully completing the qualification test. A copy of the WPQT is to be submitted to the Executive Administrator.

2.2 To provide notice of imminent loss of a welder’s qualification, the Qualification Expiration Notice (QEN) shall be sent by the Executive Administrator to the Local Lodge prior to the welder’s qualification expiration date.

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- 2.3 A non-production weld may be made to prevent the expiration of a welder's qualification provided the following is accomplished:
- 2.3.1 The weld is administered by a participating contractor.
 - 2.3.2 The weld is made on plate or pipe in any position.
 - 2.3.3 The weld is witnessed, visually inspected, and accepted by a participating contractor.
 - 2.3.4 Upon satisfactory completion of the weld specimen, a Welder History Record (WHR) shall be completed and submitted to the Executive Administrator. The Executive Administrator shall update the welder's maintenance records upon receipt of the WHR.
 - 2.3.5 A welder who has maintained his welder performance qualification by performing only non-productions welds may, at the option of the participating contractor, be required to perform one or more of the following:
 - A. A non-production weld as described in paragraphs 2.3.2 and 2.3.3.
 - B. A qualification renewal test as described in paragraph 2.1.3.
 - C. A welder performance qualification test in accordance with the contractor's Quality Control Program.
- 2.4 Upon expiration of a welder's qualification, the Executive Administrator shall remove the welder from the Welder Qualification Maintenance Report (WQMR).

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3.0 RECORDS

3.1 The Executive Administrator shall maintain the records listed below for the time periods indicated. The records may be hard copy, electronic, or a combination of both.

3.1.1 Welder

- A. Each participating contractor's Welder Performance Qualification Test Record (including renewal test records); five (5) years after date of expiration.
- B. The Performance Qualification Test Check Off Sheet (PQTC Exhibit #8); five (5) years after date of expiration.
- C. Welder qualification withdrawal notice; five (5) years after date of withdrawal.
- D. All welders whose qualifications have expired shall have their records maintained by the Executive Administrator in a separate computer file for a period of one (1) year from the date of expiration, after which they may be removed.

3.1.2 Participating Contractor

- A. Participation Agreement.
- B. ASME/NB Certificate of Authorization/10CFR50 Appendix B Program (if applicable); current.
- C. ISO Quality System Certificate of Registration (if applicable); current.
- D. Authorized Inspection Agency audit report and Contractor Certification (Exhibit #5) (if applicable); current.
- E. Each Welder History Record (WHR) (as applicable); one year minimum.

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3.1.3 General

- A. Program audit reports; permanent.
- B. Simultaneous Testing Sign-In Roster; five (5) years after date of testing.
- C. Hard copy Program Manual distribution log; current.

3.2 No welder shall be placed into the Program until after receipt by the Executive Administrator of the appropriate Welder Performance Qualification Test Record and Performance Qualification Test Check Off Sheet (if applicable).

3.3 Services provided by Common Arc may be suspended for any contractor not submitting the required documentation as required in Section I.

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4.0 AUDITING

- 4.1 The Program shall be subject to audit reviews. The audit reviews may be conducted, as deemed necessary, by the participating contractors, the Authorized Inspection Agencies, and/or representatives of the ASME, the National Board and State and Local jurisdictions.
- 4.2 The Program shall be audited at least annually by an Audit Team selected by the Operating Committee. The Audit Team may consist of representatives of participating contractors, Authorized Inspection Agencies, International Brotherhood of Boilermakers, or other organizations, societies, agencies or boards as deemed appropriate by the Operating Committee. In some cases, the Audit Team may consist of only one person. Members of the Operating Committee and the Executive Administrator shall not participate as Audit Team members.
- 4.3 An Audit Team Leader will be selected by the Operating Committee. The Team Leader should have auditing experience to provide assurance that the selected individual is knowledgeable of the auditing techniques of examining, questioning, evaluating and reporting.
- 4.4 Audit results shall be documented by the Audit Team and maintained on file by the Executive Administrator. Participating contractors and Local Lodges will be provided a copy of the audit results upon request to the Executive Administrator. Copies of the audit results may be provided to other interested parties as deemed appropriate by the Executive Administrator.

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4.5 The Executive Administrator shall respond to the Audit Team in writing, documenting any remedial and/or corrective actions taken or to be taken to address deficiencies noted during the audit. When actions by participating contractors are necessary, the applicable contractors shall be advised in writing of the deficiencies noted and the actions required to correct the deficiencies. Documentation of remedial and/or corrective action shall be maintained on file by the Executive Administrator and will be made available for review by interested parties as deemed appropriate by the Executive Administrator.

4.6 In order to close the audit, the Audit Team Leader should respond to the Executive Administrator that he agrees or concurs with the audit response thereby completing the audit process.

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5.0 Program Manual Control

- 5.1 All revisions to the Program Manual shall be approved by the Operating Committee. Approval will be indicated by the signature of the Operating Committee Chairman on the Table of Contents of the Program Manual.
- 5.2 When a revision to all or part of a Section is necessary, the entire Section shall be re-issued.
- 5.2.1 Except when the revision is major, the revised Section(s) or paragraph(s) shall be indicated in such a way (e.g., an asterisk next to the revision, a vertical line in the left margin, different colored text, etc.) that it will be clear to the reader which portions have been revised.
- 5.2.2 If the revision is major, the words “MAJOR REVISION” will appear in the title block.
- 5.2.3 A revision to the Appendix shall be by exhibit. A revised list of sample forms shall be issued with each revision to the Appendix.
- 5.2.4 After five revisions, the manual shall evolve to the next edition (1, 2, 3, etc.) with all revisions starting with “0” for the new edition.
- 5.3 All revisions shall, as a minimum, meet ASME and NBIC requirements. The Chairman of the Operating Committee shall be responsible for the review of new Code editions and addenda for effects on the Program and incorporation in to the Manual as necessary (Exhibit #9). Addenda reviews shall be documented even if no Manual revisions are required. After Program revisions are approved by the Chairman, Operating Committee, revisions shall become effective when issued. All revisions made because of ASME or NBIC code changes shall be mandatory on the code effective date.

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- 5.4 The Executive Administrator is responsible for the control of and revisions to the Program Manual. The manual shall be made available to the Participating Contractors via the Common Arc website. The latest approved revision of the Manual shall be made available to the participating contractors via the website. The Executive Administrator shall notify the participating contracts that revisions have been made to the Program Manual. The access control features of the website shall be used to prevent unauthorized modification to the manual.
- 5.5 Issuance of any controlled hard copies of the Program Manual shall be controlled as described below. Uncontrolled hard copies of the manual may be distributed at the discretion of the Executive Administrator
- 5.5.1 Controlled Program Manuals shall be transmitted with a Controlled Manual Transmittal Form (Exhibit #6). The transmittal shall identify the recipient, Controlled Manual Number, and provide for a recipient signature acknowledging receipt. This form shall be completed by the recipient and returned to the Executive Administrator for file and record.
- 5.5.2 The Executive Administrator shall record the distribution of controlled manuals. The receipt of the transmittal form shall also be recorded.
- 5.5.3 Program manual recipients who do not return the receipt document properly signed shall receive a second notice. If this second notice does not cause the proper receipt to be returned, their manuals shall be declared uncontrolled.

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6.0 WELDER PERFORMANCE QUALIFICATION TEST

6.1 General

- 6.1.1 Each participating contractor shall have a written quality control system including provisions for assuring that welding conforms to requirements of the current edition and addenda of the ASME Code Section IX.
- 6.1.2 Each participating contractor shall be responsible for his required activities as written in his Quality Control Program and this Manual for welder performance qualification tests.
- 6.1.3 Contractors are advised that individual contracts by the clients may contain special welder qualification requirements in addition to those required by the Code and those outlined in this Manual.
- 6.1.4 Each welder shall use his social security number as an identification number for the purpose of traceability within the records of the Executive Administrator's files for welder performance qualification maintenance.

6.2 Simultaneous Welder Qualification Testing

- 6.2.1 A briefing shall be conducted by a Common Arc Proctor prior to any welder performance qualification tests at each scheduled test session. The purpose of the briefing is to familiarize each participating welder and contractor with the testing procedure and their role within the Program. Prior to the briefing, a Sign In Roster (Exhibit #7) shall be completed by each participating welder.

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Each welder shall provide formal identification. This identification shall consist of photographic identification such as a driver's license. In lieu of photographic identification, the identity of the welder shall be verified by a Local Lodge or contractor representative.

- 6.2.2 During the briefing, each welder shall receive a form containing a list of all contractors participating in the test session and a description of the four (4) inspection hold points required during the performance qualification test, as shown on the Performance Qualification Test Check off (Exhibit #8). It shall be the responsibility of each participating welder to obtain the signature or initials of each contractor for each of the required inspection hold points as they occur. Each contractor shall have completed his inspection and initialed the appropriate box for each inspection hold point before the welder can proceed with the next portion of the test. **No contractor shall be permitted to sign for another contractor.**
- 6.2.3 A participating contractor may terminate an individual welder's performance qualification test whenever the contractor has determined that the welder does not have the ability to deposit sound weld metal within the requirements of the contractor's Welding Procedure Specifications (WPS). When a participating welder has been terminated by one of the participating contractors, the welder shall continue the test for the remaining participating contractors.
- 6.2.4 Each participating welder shall be qualified using each process or combination of processes the welder may be required to use in production. Each participating welder may be qualified to weld with a combination of processes

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on one performance qualification test utilizing a combination of processes on a single test coupon.

- 6.2.5 Any pre-heat or post-weld heat treatment required on the contractor's WPS shall be omitted for performance qualification testing.
- 6.2.6 The following hand tools will be permitted for use by the participating welder during the prescribed test. Use of additional hand tools as permitted by the contractors may be used.
 - A. Slag pick.
 - B. Hand wire brush.
 - C. File.

6.3 Individual Contractor Qualification Testing

- 6.3.1 Welders may be qualified by a participating contractor at other than simultaneous welder test sessions. When this is done, the welder performance qualification test shall be in accordance with the contractor's Quality Control Program for welder qualification. If the welders are to be included in the Program, i.e., listed on the contractor's Welder Qualification Maintenance Report (WQMR), copies of the Welder Performance Qualification Test Record (WPQT) must be submitted by the contractor to the Executive Administrator for retention. It is recommended that the contractor also send a copy of the Welder Performance Qualification Test Records (WPQT) to the Local Lodge for their retention.
- 6.3.2 Welders should be instructed by the contractor about the Program prior to the qualification test.

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7.0 VARIABLES FOR SIMULTANEOUS WELDER QUALIFICATION TESTING

For the purpose of uniformity and consistency, each participating welder shall be qualified during simultaneous welder qualification testing in accordance with the participating contractor's welding procedure specifications and the variables described in the Welder Performance Qualification Test Records shown in Exhibit #10.

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8.0 COUPON TESTING FOR SIMULTANEOUS WELDER QUALIFICATION TESTING

8.1 The coupon test positions are shown in Exhibit #11. For pipe and plate coupons, bend specimens shall be removed from the test coupons in accordance with the locations illustrated in Exhibit #12.

8.2 Testing of the coupons shall be in accordance with the requirement of Section IX.

8.3 Welder identification number stamping for pipe and plate coupons shall be per Exhibit #14.

8.4 The individual contractor's quality control program requirements for welder qualifications may exceed the above criteria and may be implemented as required by the contractors.

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9.0 RETESTS DURING SIMULTANEOUS WELDER QUALIFICATION TESTING

When a participating welder fails to meet the performance qualification test requirements of the Program, the welder may be offered the option of an immediate retest or further training under the following conditions.

9.1 Immediate Retest:

For the purpose of simultaneous welder qualification testing, immediate retest shall be considered as an additional test taken the same day as that of the failed test. When an immediate retest is made, the welder shall make two (2) consecutive test welds for each position in which the welder failed, both of which shall pass the test requirements of ASME Section IX. For plate tests, a failure of one position fails for all positions; therefore, a retest shall consist of all three positions, all of which must pass.

9.2 Further Training:

When the participating welder is given further training or practice, the welder shall take a single complete performance qualification retest for each position in which the welder failed to meet the prescribed test requirements of the original test. A single retest may be given the following day after a failed test. For plate tests, a failure of one position fails for all positions; therefore, a retest shall consist of all three positions, all of which must pass.

9.3 Examination:

When the initial performance qualification test specimen has failed the examination, the retest shall be by the same examination method used for the initial test.

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APPENDIX

Note that the forms on the following pages are samples. Forms in use may be a different revision or format, but they will contain similar information as indicated by these samples.

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COMMON ARC CORPORATION

PARTICIPATION AGREEMENT

1. This Agreement, entered into on the date set forth below, describes the terms and conditions upon which

(name of participating company)

(the “Employer” will participate in the Common Arc Welder Performance Qualification Maintenance Program (the “Program”).

2. The Employer will participate in such welder qualification examinations sponsored by the Program as it chooses, and will maintain with the Program such welder qualification records for which the Program offers retention as it chooses. The Employer agrees that records maintained by the Program shall be under the operational control of the Employer.
3. During its participation in the Program, the Employer agrees to be bound and abide by the procedures and regulations established by the Common Arc Board of Directors and Executive Committee in their present form and as they may be amended from time to time.
4. The Employer has reviewed Exhibit #10 in the Appendix of the Common Arc Welder Qualification Maintenance Program Manual. The Employer attests that its Welding Procedure Specifications are identical with the essential variables shown in Exhibit #10 and is qualified in accordance with Section IX of the ASME Code.
5. The Employer understands and agrees that it alone shall be entitled to and responsible for determining the qualifications of any and all welders which it may enter into or maintain in the Program. The initial testing of welders, with respect to their qualifications and criteria by which welders will be deemed to have maintained their qualifications, shall be conducted and applied solely by the Employer in accordance with the Employer’s own requirements and standards. The Employer agrees to indemnify and hold harmless Common Arc and MOST, and their respective officers, directors, agents, employees and members against any claim regarding the qualifications of any welder entered into or maintained in the Program by the Employer.

In agreement with the foregoing, and in consideration of the similar Agreements entered into and to be entered into by other employers and the benefits to it of the Program, the Employer has caused this Agreement to be executed by its representative authorized to do so.

Participating Employer Date

Common Arc Administrator Date

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Exhibit No. 2 – Welder Qualification Maintenance Report (WQMR)	Page 33

Sample Company Report

Enerfab, Inc.
Welder Qualification Maintenance Report
For Local 744, Cleveland, OH

April 15, 2006

Welders			-----Last Welded-----				
SS#/Name	Expires	Qual.Date	Process	Test Dia.	Date	Description	Contractor
269-40-7185							
Brown J	8/4/06	7/23/01	GTAW	2.75	2/3/06	Production	APComPower
	8/4/06	7/23/01	SMAW	2.75	2/3/06	Production	APComPower
356-43-9307							
Davis E	10/8/06	8/20/00	GTAW	2.75	4/8/06	Production	Enerfab Inc.
	10/8/06	8/20/00	SMAW	2.75	4/8/06	Production	Enerfab Inc.


Sample Local Report

I.B.B. Local 154
Pittsburgh, PA
Welder Qualification Maintenance Report

April 15, 2006

Welders			-----Last Welded-----				
SS#/Name	Expires	Qual.Date	Process	Test Dia.	Date	Description	Contractor
331-92-4782							
Baily V	8/4/06	7/23/02	GTAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	SMAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	GTAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	SMAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	GTAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	SMAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	GTAW	2.75	2/3/06	Production	Williams Power
	8/4/06	7/23/02	SMAW	2.75	2/3/06	Production	Williams Power

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Welding Process <input type="checkbox"/> SMAW <input type="checkbox"/> GTAW <input type="checkbox"/> _____ <small>Other Processes</small> <input type="checkbox"/> NON-PRODUCTION WELD _____	Date First Used on Current Job _____ _____ _____	Date Last Used _____ _____ _____
Welding Performance Quality (If unsatisfactory or Remove, explain below) <input type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory <input type="checkbox"/> Remove from Contractor List		
Authorized Cont. Rep. Sign Here _____		
Common Arc PO Box 190 Geneva, IL 60134 Phone 630-232-8378 Fax 630-232-9643		
COMMON ARC	Form WHR 1	

COMMON ARC
WELDER HISTORY RECORD MULTIPLE LISTING FORM

ORIGINAL

CONTRACTOR _____

PROJECT _____

(PROJECT NAME, LOCATION, CLIENT/OWNER, ETC)

WELDER'S NAME	SS NUMBER	LOCAL	PROCESS(ES)						NON PROD FACTORY WELD	SATIS- FACTORY		REMOVE FROM LIST
			SMAW		GTAW		OTHER (Name Process)			YES	NO	
			Date First Used on Current Job	Date Last Used	Date First Used on Current Job	Date Last Used	Date First Used on Current Job	Date Last Used				
1												
2												
3												
4												
5												
6												
7												
8												
9												
10												
11												
12												
13												
14												
15												
16												
17												
18												
19												
20												

COMMENTS: (If removing from list give name, SS# and reason)

WE CERTIFY THE ABOVE IS IN COMPLIANCE WITH OUR CONSTRUCTION RECORDS.

CONTRACTOR REPRESENTATIVE: _____
PRINT NAME AND TITLE

SIGNATURE _____ DATE _____

Common Arc
 P.O. Box 190, Geneva, IL 60134
 (630) 232-8378 FAX (630) 232-9643
 Instructions
CONTRACTOR – Mail or fax to
 Common Arc. Retain a copy for
 your records and provide a copy
 to the Local Union.

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Exhibit No. 4 – Qualification Expiration Notice (QEN)	Page 35

WELDER PERFORMANCE QUALIFICATION MAINTENANCE PROGRAM
QUALIFICATION EXPIRATION NOTICE (QEN) 4/23/05
LOCAL 83 KANSAS CITY, MO

WELDER PERFORMANCE QUALIFICATION MAINTENANCE PROGRAM
QUALIFICATION EXPIRATION NOTICE (QEN) 4/23/06
LOCAL 83 KANSAS CITY, MO

SS#	Welder Name		Process	Last Worked	Expires
269-40-7185	Beckett	David	GTAW	11/25/05	5/26/06
269-40-7185	Beckett	David	SMAW	11/25/05	5/26/06
339-60-4278	France	Lawrence	FCAW	11/30/05	5/31/06
443-78-0023	George	Andrew	GTAW	11/23/05	5/24/06
443-78-0023	George	Andrew	SMAW	11/23/05	5/24/06
515-36-1298	Manchester	Phillip	GTAW	11/24/05	5/25/06
515-36-1298	Manchester	Phillip	SMAW	11/24/05	5/25/06
056-77-3052	Stone	James	SMAW	11/27/05	5/28/06

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CONTRACTOR’S CERTIFICATION

TO: Common Arc Corporation, Geneva, Illinois

We hereby certify that we have developed and consistently implement a written quality control system for work governed by _____

(List Primary Standards or Codes Governing Work)

The quality control system includes provisions for assuring the welding conforms to the requirements of the ASME Code, Section IX.

Contractor

Authorized Representative

Date

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COMMON ARC WELDER PERFORMANCE QUALIFICATION
MAINTENANCE PROGRAM MANUAL

PROGRAM TRANSMITTAL FORM

TO: _____ Date _____

Description of Transmittal: _____

- | | |
|------------------------------|-------------------------------|
| 1. Review/Comment/Acceptance | 2. Information Only |
| 3. Manual Change | 4. Program Manual Transmittal |

TO: COMMON ARC
 P. O. Box 190
 Geneva, IL 60134
 Fax: 630/232-9643

This will verify that the documents transmitted with this Program Transmittal Form have been accomplished as indicated below:

The documents have been inserted in Program Manual Number _____,
 and the superseded revisions have been destroyed.

Program Manual Number _____ has been received and is in my
 possession.

Name: _____

Date: _____

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LOCAL
SESSION

(PLEASE PRINT) **WELDERS SIGN-IN ROSTER**

	NAME (FIRST INITIAL LAST)	SOCIAL SECURITY NUMBER	TIG ROOT	6010 ROOT	BACKING RING/BAR	RETEST YES/NO	HOME LOCAL
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							
30							
31							
32							

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CODE REVIEW

_____ ASME Section _____ Edition _____ Addenda _____

_____ NBIC Edition _____ Addenda _____

The Code edition and addenda indicated above has been reviewed and incorporated, as appropriate, into the Welder Performance Qualification Maintenance Program Manual.

Signed _____
Chairman, Common Arc Operating Committee

Date _____

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WELDER PERFORMANCE QUALIFICATION TEST

2" TIG

WELDERS NAME _____		SS # _____	LOCAL _____
WELDING PROCESS(ES) _____		GTAW / SMAW	TYPE _____
BASE MATERIALS WELDED _____		SA 106 GR. B	WELDING PROCEDURE USED _____
FILLER METAL SPECIFICATION (SFA) / CLASS _____		5.18 / ER70S-2 & 5.1 / E7018	
VARIABLES USED FOR EACH PROCESS			
BACKING MATERIAL DESCRIPTION		ACTUAL VALUES	RANGE QUALIFIED
		F6-OPEN	F6-WITH & WITHOUT
		F4-WELD METAL	F4, 3, 2, & 1 -WITH
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>			P1 THRU P11 & P4X
<input type="checkbox"/> PLATE	<input checked="" type="checkbox"/> PIPE	DIAMETER	2" NPS
			1" OD & GREATER
BASE METAL THICKNESS		.436"	
FILLER METAL F-NUMBER		F6 / F4	F6 / F4, 3, 2, & 1
FILLER METAL PRODUCT FORM		GTAW-SOLID	SOLID, & METAL CORED
CONSUMABLE INSERT		NONE	WITHOUT
WELD DEPOSIT THICKNESS (EACH PROCESS)		GTAW-.125"	GTAW-.250"
		SMAW-.311"	SMAW-.622"
WELDING POSITION		6G	ALL
PROGRESSION		UP	UP
BACKING GAS		NONE	WITH & WITHOUT
TRANSFER MODE (GMAW)		NA	NA
CURRENT / POLARITY (GTAW)		DCEN	DCEN
GUIDED BENT TEST RESULTS			
GUIDED BEND TYPE		(X) QW 462.2 SIDE	() QW 462.3a R&F
		() QW 462.3b LONG R & F	
4 BENDS - ACCEPT			
VISUAL EXAMINATION RESULTS			
		SATISFACTORY	
RADIOGRAPHIC TEST RESULTS			
		NA	
FILLET WELD - FRACTURE TEST			
		NA	DEFECT LENGTH
			NA
			DEFECT PERCENT
			NA
MACRO TEST FUSION			
		NA	FILLET LEG SIZE
			NA X NA
			CONVEXITY / CONCAVITY
			NA
LABORATORY TEST NUMBER			
		NA	TEST DATE
MECHANICAL TEST CONDUCTED BY _____			
WELDING TEST CONDUCTED BY _____			
<p>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 OF SECTION IX OF THE ASME CODE.</p>			
DATE _____		BY _____	
		ORGANIZATION _____	

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WELDER PERFORMANCE QUALIFICATION TEST

2" BR

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ SMAW _____ TYPE _____ MANUAL _____	
BASE MATERIALS WELDED _____ SA 106 GR. B _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.1 / E7018 _____	
VARIABLES USED FOR EACH PROCESS	ACTUAL VALUES
RANGE QUALIFIED	
BACKING MATERIAL DESCRIPTION	F4-METAL
	F4, 3, 2, & 1 WITH
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>	P1 THRU P11 & P4X
<input type="checkbox"/> PLATE <input checked="" type="checkbox"/> PIPE	DIAMETER
	2" NPS
	1" OD & GREATER
BASE METAL THICKNESS	.436"
FILLER METAL F-NUMBER	F4
	F4, 3, 2, & 1
FILLER METAL PRODUCT FORM	NA
	NA
CONSUMABLE INSERT	NONE
	WITHOUT
WELD DEPOSIT THICKNESS (EACH PROCESS)	SMAW-.436"
	SMAW-.872"
WELDING POSITION	6G
	ALL
PROGRESSION	UP
	UP
BACKING GAS	NA
	NA
TRANSFER MODE (GMAW)	NA
	NA
CURRENT / POLARITY (GTAW)	NA
	NA
GUIDED BENT TEST RESULTS	
GUIDED BEND TYPE	(X) QW 462.2 SIDE () QW 462.3a R&F () QW 462.3b LONG R & F
4 BENDS - ACCEPT	
VISUAL EXAMINATION RESULTS	SATISFACTORY
RADIOGRAPHIC TEST RESULTS	NA
FILLET WELD - FRACTURE TEST	NA
	DEFECT LENGTH
	NA
	DEFECT PERCENT
	NA
MACRO TEST FUSION	NA
	FILLET LEG SIZE
	NA X NA
	CONVEXITY / CONCAVITY
	NA
LABORATORY TEST NUMBER	TEST DATE
MECHANICAL TEST CONDUCTED BY	
WELDING TEST CONDUCTED BY	
<p>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 OF SECTION IX OF THE ASME CODE.</p>	
DATE _____	BY _____
ORGANIZATION _____	

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WELDER PERFORMANCE QUALIFICATION TEST

2" 6010

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ SMAW _____ TYPE _____ MANUAL _____	
BASE MATERIALS WELDED _____ SA 106 GR. B _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.1 / E6010 & E7018 _____	
VARIABLES USED FOR EACH PROCESS	ACTUAL VALUES
RANGE QUALIFIED	
BACKING MATERIAL DESCRIPTION	F3-OPEN _____ F4-METAL _____
	F3-WITH & WITHOUT _____ F4, 3, 2, & 1-WITH _____
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>	_____
<input type="checkbox"/> PLATE <input checked="" type="checkbox"/> PIPE	DIAMETER <u>2" NPS</u>
	P1 THRU P11 & P4X _____ 1" OD & GREATER _____
BASE METAL THICKNESS	<u>.436"</u>
FILLER METAL F-NUMBER	<u>F3 & F4</u>
FILLER METAL PRODUCT FORM	<u>NA</u>
CONSUMABLE INSERT	<u>NONE</u>
WELD DEPOSIT THICKNESS (EACH PROCESS)	<u>F3-.125"</u> <u>F4-.311"</u>
	F3-.250" _____ F4-.611" _____
WELDING POSITION	<u>6G</u>
PROGRESSION	<u>UP</u>
BACKING GAS	<u>NA</u>
TRANSFER MODE (GMAW)	<u>NA</u>
CURRENT / POLARITY (GTAW)	<u>NA</u>
GUIDED BENT TEST RESULTS	
GUIDED BEND TYPE	(X) QW 462.2 SIDE () QW 462.3a R&F () QW 462.3b LONG R & F
4 BENDS - ACCEPT	
VISUAL EXAMINATION RESULTS	SATISFACTORY _____
RADIOGRAPHIC TEST RESULTS	NA _____
FILLET WELD - FRACTURE TEST	NA DEFECT LENGTH _____ NA DEFECT PERCENT _____ NA
MACRO TEST FUSION	NA FILLET LEG SIZE _____ NA X NA CONVEXITY / CONCAVITY _____ NA
LABORATORY TEST NUMBER	NA TEST DATE _____
MECHANICAL TEST CONDUCTED BY	_____
WELDING TEST CONDUCTED BY	_____
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 OF SECTION IX OF THE ASME CODE.	
DATE _____	ORGANIZATION _____ BY _____

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WELDER PERFORMANCE QUALIFICATION TEST

2" TIG SS

WELDERS NAME _____		SS # _____		LOCAL _____	
WELDING PROCESS(ES) _____		GTAW / SMAW _____		TYPE _____	
BASE MATERIALS WELDED _____		SA 106 GR. B _____		WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____		5.9 / ER309 & 5.4 / E309			
VARIABLES USED FOR EACH PROCESS		ACTUAL VALUES		RANGE QUALIFIED	
BACKING MATERIAL DESCRIPTION _____		F6-OPEN _____		F6-WITH & WITHOUT _____	
		F5-WELD METAL _____		F5-WITH _____	
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>				P1 THRU P11 & P4X	
<input type="checkbox"/> PLATE <input checked="" type="checkbox"/> PIPE		DIAMETER <u>2" NPS</u>		1" OD & GREATER	
BASE METAL THICKNESS _____		.436"			
FILLER METAL F-NUMBER _____		F6 / F5		F6 / F5	
FILLER METAL PRODUCT FORM _____		GTAW-SOLID		SOLID & METAL CORED	
CONSUMABLE INSERT _____		NONE		WITHOUT	
WELD DEPOSIT THICKNESS (EACH PROCESS) _____		GTAW -.125"		GTAW-.250"	
		SMAW-.311"		SMAW-.622"	
WELDING POSITION _____		6G		ALL	
PROGRESSION _____		UP		UP	
BACKING GAS _____		ARGON		WITH	
TRANSFER MODE (GMAW) _____		NA		NA	
CURRENT / POLARITY (GTAW) _____		DCEN		DCEN	
GUIDED BENT TEST RESULTS					
GUIDED BEND TYPE _____		(X) QW 462.2 SIDE		() QW 462.3a R&F	
				() QW 462.3b LONG R & F	
4 BENDS - ACCEPT					
VISUAL EXAMINATION RESULTS _____		SATISFACTORY			
RADIOGRAPHIC TEST RESULTS _____		NA			
FILLET WELD - FRACTURE TEST _____		NA		DEFECT LENGTH NA	
				DEFECT PERCENT NA	
MACRO TEST FUSION _____		NA		FILLET LEG SIZE NA X NA	
				CONVEXITY / CONCAVITY NA	
LABORATORY TEST NUMBER _____		NA		TEST DATE _____	
MECHANICAL TEST CONDUCTED BY _____					
WELDING TEST CONDUCTED BY _____					
<p>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 OF SECTION IX OF THE ASME CODE.</p>					
DATE _____		BY _____		ORGANIZATION _____	

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WELDER PERFORMANCE QUALIFICATION TEST

2"/160/F3F4

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ SMAW _____ TYPE _____ MANUAL _____	
BASE MATERIALS WELDED _____ SA 106 GR. B _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.1 / E6010 & E7018 _____	
VARIABLES USED FOR EACH PROCESS	
BACKING MATERIAL DESCRIPTION	ACTUAL VALUES
	F3-OPEN
	F4-WELD METAL
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>	
<input type="checkbox"/> PLATE <input checked="" type="checkbox"/> PIPE	DIAMETER
	2" NPS
BASE METAL THICKNESS	.343"
FILLER METAL F-NUMBER	F3 / F4
FILLER METAL PRODUCT FORM	NA
CONSUMABLE INSERT	NONE
WELD DEPOSIT THICKNESS (EACH PROCESS)	F3- .125"
	F4- .218"
WELDING POSITION	6G
PROGRESSION	UP
BACKING GAS	NA
TRANSFER MODE (GMAW)	NA
CURRENT / POLARITY (GTAW)	NA
GUIDED BENT TEST RESULTS	
GUIDED BENT TYPE	() QW 462.2 SIDE (X) QW 462.3a R&F () QW 462.3b LONG R & F
2 FACE BENDS	ACCEPT
2 ROOT BENDS	ACCEPT
VISUAL EXAMINATION RESULTS _____ SATISFACTORY _____	
RADIOGRAPHIC TEST RESULTS _____ NA _____	
FILLET WELD - FRACTURE TEST	NA
	DEFECT LENGTH _____ NA _____
	DEFECT PERCENT _____ NA _____
MACRO TEST FUSION	NA
	FILLET LEG SIZE _____ NA X NA _____
	CONVEXITY / CONCAVITY _____ NA _____
LABORATORY TEST NUMBER	NA
	TEST DATE _____
MECHANICAL TEST CONDUCTED BY _____	
WELDING TEST CONDUCTED BY _____	
<p>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 OF SECTION IX OF THE ASME CODE.</p>	
DATE _____	ORGANIZATION _____
BY _____	_____

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WELDER PERFORMANCE QUALIFICATION TEST

2"/80/TIG

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ GTAW _____ TYPE _____ MANUAL _____	
BASE MATERIALS WELDED _____ SA 106 GR. B _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.18 / ER70S-2 _____	
VARIABLES USED FOR EACH PROCESS	
ACTUAL VALUES	RANGE QUALIFIED
BACKING MATERIAL DESCRIPTION	F6-OPEN
	F6- WITH & WITHOUT
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>	P1 THRU P11 & P4X
<input type="checkbox"/> PLATE <input checked="" type="checkbox"/> PIPE DIAMETER	2" NPS
	1" OD & GREATER
BASE METAL THICKNESS	.218"
FILLER METAL F-NUMBER	F6
FILLER METAL PRODUCT FORM	SOLID
	SOLID & METAL CORED
CONSUMABLE INSERT	NONE
	WITHOUT
WELD DEPOSIT THICKNESS (EACH PROCESS)	.218"
	.436"
WELDING POSITION	6G
	ALL
PROGRESSION	UP
	UP
BACKING GAS	NONE
	WITH & WITHOUT
TRANSFER MODE (GMAW)	NA
	NA
CURRENT / POLARITY (GTAW)	DCEN
	DCEN
GUIDED BENT TEST RESULTS	
() QW 462.2 SIDE (X) QW 462.3a R&F () QW 462.3b LONG R & F	
2 FACE BENDS	ACCEPT
2 ROOT BENDS	ACCEPT
VISUAL EXAMINATION RESULTS _____ SATISFACTORY _____	
RADIOGRAPHIC TEST RESULTS _____ NA _____	
FILLET WELD - FRACTURE TEST	NA
DEFECT LENGTH	NA
DEFECT PERCENT	NA
MACRO TEST FUSION	NA
FILLET LEG SIZE	NA X NA
CONVEXITY / CONCAVITY	NA
LABORATORY TEST NUMBER	NA
TEST DATE	_____
MECHANICAL TEST CONDUCTED BY _____	
WELDING TEST CONDUCTED BY _____	
<p>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 OF SECTION IX OF THE ASME CODE.</p>	
ORGANIZATION _____	
DATE _____	BY _____

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WELDER PERFORMANCE QUALIFICATION TEST

3/8" 6010

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ SMAW _____ TYPE _____ MANUAL _____	
BASE MATERIALS WELDED _____ SA 36 _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.1 / E6010 & E7018 _____	
VARIABLES USED FOR EACH PROCESS	
BACKING MATERIAL DESCRIPTION	ACTUAL VALUES
	F3-OPEN
	F4-WELD METAL
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>	
<input checked="" type="checkbox"/> PLATE <input type="checkbox"/> PIPE	DIAMETER
	PLATE
BASE METAL THICKNESS	.375"
FILLER METAL F-NUMBER	F 3 / F4
FILLER METAL PRODUCT FORM	NA
CONSUMABLE INSERT	NONE
WELD DEPOSIT THICKNESS (EACH PROCESS)	F3-.125" F4-.250"
WELDING POSITION	2G, 3G, & 4G
PROGRESSION	UP
BACKING GAS	NA
TRANSFER MODE (GMAW)	NA
CURRENT / POLARITY (GTAW)	NA
GUIDED BENT TEST RESULTS	
GUIDED BEND TYPE	() QW 462.2 SIDE (X) QW 462.3a R&F () QW 462.3b LONG R & F
2G-FACE & ROOT BEND	ACCEPT
3G-FACE & ROOT BEND	ACCEPT
4G-FACE & ROOT BEND	ACCEPT
VISUAL EXAMINATION RESULTS	SATISFACTORY
RADIOGRAPHIC TEST RESULTS	NA
FILLET WELD - FRACTURE TEST	NA
	DEFECT LENGTH NA
	DEFECT PERCENT NA
MACRO TEST FUSION	NA
	FILLET LEG SIZE NA X NA
	CONVEXITY / CONCAVITY NA
LABORATORY TEST NUMBER	NA
	TEST DATE _____
MECHANICAL TEST CONDUCTED BY	_____
WELDING TEST CONDUCTED BY	_____
<p>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 OF SECTION IX OF THE ASME CODE.</p>	
DATE _____	BY _____
	ORGANIZATION _____

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WELDER PERFORMANCE QUALIFICATION TEST

3/8" FCAW BR

WELDERS NAME _____ SS # _____ LOCAL _____	
WELDING PROCESS(ES) _____ FCAW _____ TYPE _____ SEMI-AUTOMATIC _____	
BASE MATERIALS WELDED _____ SA 36 _____ WELDING PROCEDURE USED _____	
FILLER METAL SPECIFICATION (SFA) / CLASS _____ 5.20 / E71T-1 _____	
VARIABLES USED FOR EACH PROCESS	ACTUAL VALUES
BACKING MATERIAL DESCRIPTION	METAL
ASME P-GROUP 1 TO P-GROUP 1	RANGE QUALIFIED
<input checked="" type="checkbox"/> PLATE <input type="checkbox"/> PIPE DIAMETER _____	P1 THRU P11 & P4X
	PL & PIPE > 24" OD
BASE METAL THICKNESS	.375"
FILLER METAL F-NUMBER	F6
FILLER METAL PRODUCT FORM	FLUX CORED
CONSUMABLE INSERT	NONE
WELD DEPOSIT THICKNESS (EACH PROCESS)	.375"
	.750"
WELDING POSITION	2G, 3G, & 4G
PROGRESSION	UP
BACKING GAS	NONE
TRANSFER MODE (GMAW)	SPRAY
CURRENT / POLARITY (GTAW)	NA
	ALL
	UP
	WITH & WITHOUT
	SPRAY/GLOB./PULSE
	NA
GUIDED BENT TEST RESULTS	
GUIDED BEND TYPE	() QW 462.2 SIDE (X) QW 462.3a R&F () QW 462.3b LONG R & F
2G-FACE & ROOT BEND	ACCEPT
3G-FACE & ROOT BEND	ACCEPT
4G-FACE & ROOT BEND	ACCEPT
VISUAL EXAMINATION RESULTS	SATISFACTORY
RADIOGRAPHIC TEST RESULTS	NA
FILLET WELD - FRACTURE TEST	NA DEFECT LENGTH NA
	DEFECT PERCENT NA
MACRO TEST FUSION	NA FILLET LEG SIZE NA X NA
	CONVEXITY / CONCAVITY NA
LABORATORY TEST NUMBER	NA TEST DATE _____
MECHANICAL TEST CONDUCTED BY _____	
WELDING TEST CONDUCTED BY _____	
<p>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 OF SECTION IX OF THE ASME CODE.</p>	
<p>ORGANIZATION _____</p>	
<p>DATE _____ BY _____</p>	

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WELDER PERFORMANCE QUALIFICATION TEST

3/8" FCAW BR
V-DN

WELDERS NAME _____		SS # _____	LOCAL _____
WELDING PROCESS(ES) _____		FCAW	TYPE _____
BASE MATERIALS WELDED _____		SA 36	WELDING PROCEDURE USED _____
FILLER METAL SPECIFICATION (SFA) / CLASS _____		5.20 / E71T-11	
VARIABLES USED FOR EACH PROCESS			
BACKING MATERIAL DESCRIPTION _____		METAL _____	RANGE QUALIFIED _____
ASME P-GROUP <u>1</u> TO P-GROUP <u>1</u>			P1 THRU P11 & P4X
<input checked="" type="checkbox"/> PLATE	<input type="checkbox"/> PIPE	DIAMETER _____	PL & PIPE > 24" OD
BASE METAL THICKNESS _____		.375"	
FILLER METAL F-NUMBER _____		F6	F6
FILLER METAL PRODUCT FORM _____		FLUX CORED	ALL
CONSUMABLE INSERT _____		NONE	WITHOUT
WELD DEPOSIT THICKNESS (EACH PROCESS) _____		.375"	.750"
WELDING POSITION _____		3G	1G & 3G
PROGRESSION _____		DOWN	DOWN
BACKING GAS _____		NONE	WITH & WITHOUT
TRANSFER MODE (GMAW) _____		SPRAY	SPRAY/GLOB./PULSE
CURRENT / POLARITY (GTAW) _____		NA	NA
GUIDED BENT TEST RESULTS			
GUIDED BEND TYPE _____	() QW 462.2 SIDE	(X) QW 462.3a R&F	() QW 462.3b LONG R & F
3G-FACE & ROOT BEND	ACCEPT		
VISUAL EXAMINATION RESULTS _____			
SATISFACTORY			
RADIOGRAPHIC TEST RESULTS _____			
NA			
FILLET WELD - FRACTURE TEST _____	NA	DEFECT LENGTH _____	NA
		DEFECT PERCENT _____	NA
MACRO TEST FUSION _____	NA	FILLET LEG SIZE _____	NA X NA
		CONVEXITY / CONCAVITY _____	NA
LABORATORY TEST NUMBER _____	NA	TEST DATE _____	
MECHANICAL TEST CONDUCTED BY _____			
WELDING TEST CONDUCTED BY _____			
<p>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 OF SECTION IX OF THE ASME CODE.</p>			
DATE _____		ORGANIZATION _____	
		BY _____	