

Welding Performance Qualification Record (WPQR)
Welding Code: AWS D1.1

Company Name: **WeldCanada.com**

Company Address: **info@WeldCanada.com, 1 (877) WPS-WELD**

Welder's Name: **Elvis Tom Jones**

Identification No: **ETJ-2005**

Type of welder: **Welder**

Welding Performance Qualification Record WPQR No. **DEMO-SMAW-WPQR**

Qualification Date: **12, 12, 2005**

Welding Procedure Specification WPS No. **DEMO-SMAW-WPS**

Rev. **0**

BASE METALS USED

Material Specification, Type or Grade: **ASTM A 36** Plate Pipe Box Tube Sheet

Welded to

Material Specification, Type or Grade: **ASTM A 36** Plate Pipe Box Tube Sheet

Variables	Actual Values Used	Qualification Range
Welding Process	SMAW	SMAW
Process Type	Manual	Manual
Electrode (Single or Multiple)	Single	Single
Current Type/Polarity	DCEP	
Backing (Yes or No)	Without backing	With or without
Testing Position(s) and Qualified Welding Position(s):		
Groove	2G on Plate	F, H
Fillet		F, H
Vertical Progression	n/a	n/a
Plug or Slot Welds		F
Base Metals Thickness in (mm):		
Groove	3/8 in. (10 mm)	1/8 in. (3 mm) to 3/4 in. (20 mm)
Fillet		Unlimited
Plug or Slot Welds		Qualified
Base Metals Diameter in (mm) (Pipe or Tube):		
Groove	Plate tested	24 in. (600 mm) OD and over
Fillet		24 in. (600 mm) OD and over
Filler Metal Specification (SFA)	A5.1	
Filler Metal Classification (AWS Classified)	E7018	Any AWS A5 Class Approved
Filler Metal F-Number	4	4, 3, 2, 1
Gas/Flux (SAW)	n/a	n/a
Other Variable (coating type/thickness, etc.)	n/a	n/a

Results

Visual Inspection of Completed Weld (D1.1, 4.9.1): Acceptable YES NO

Guided Bend Test Type and Results (D1.1, 4.31.5): **One Root and One Face Bend Specimens**

Result and Comments: **Acceptable criteria based on AWS D1.1, Clause 4.8.3.3 measured values**

Fillet-Weld Test Results (D1.1, 4.31.2.3 and 4.31.4.1):

Appearance: n/a Fillet Size in (mm): n/a

Fracture Test Root Penetration: n/a Macroetch: n/a

(Describe the location, nature, and size of any crack or tearing of the specimen.)

Result and Comments: **Groove weld test qualifies fillet weld test as well**

Inspected by: **Tom Jones, AWS Certified Welding Inspector (CWI)** Test Number: **1012-Stick**

Organization: **Testing Lab Data, Inc.** Date: **12, 12, 2005**

Alternative * Radiographic Test Results (D1.1, 4.31.3.2) : * In lieu of Guided Bend Test, except for GMAW-S

Film Identification No.	Results	Remarks	Film Identification No.	Results	Remarks
n/a	n/a	n/a	n/a	n/a	n/a
n/a	n/a	n/a	n/a	n/a	n/a

Film interpreted by: **n/a**

Test Number:

Organization:

Date:

Other information: **Guide bend test conducted instead of RT. This WPQR demo form has been created by WeldCanada.com Online Welding Software**

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in conformance with the requirements of Clause 4 of AWS D1.1/D1.1M:2010, Structural Welding Code-Steel.

Manufacturer/ Contractor
Welding Engineer

Authorized By:

Name: **Joe Smith**
 Title: **Welding Engineer**
 Signature: **J. S.**
 Date: **14, 12, 2005**

Name: **James Bond**
 Title: **QA Manager**
 Signature: **J. B.**
 Date: **14, 12, 2005**