Section - 5
Sr No. 5

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QW – 484A WELDER PERFORMANCE QUALIFICATION (WPQ)
(SEE QW – 301, SECTION IX, ASME BOILER AND PRESSURE VESSEL CODE)

WELDER'S NAME: SHISHIR KUMAR	STAMP NO.: MRSPL-002
WELDING PROCESS (ES) USED: GTAW	TYPE: MANUAL
IDENTIFICATION OF WPS FOLLOWED: MRSPL/WPS/GTAW/001	TEST COUPEN: PLATE:✓ PIPE:
SPECIFICATION OF BASE METAL(S): AA 1100/ AA 1200	THICKNESS: 2 MM
FILLER METAL OR ELECTRODE SPECIFICATION(S) (SFA): 5.10	
FILLER METAL OR ELECTRODE CLASSIFICATIN(S): ER 4043	

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SCWI 05070028
QC1 EXP. 7/1/2023

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUE	RANGE QUALIFIED
BACKING (METAL, WELD METAL, DOUBLE-WELDED, ETC.)	WITHOUT BACKING	WITHOUT BACKING
☐ ✓ PLATE ☐ PIPE (ENTER DIAMETER IF PIPE OR TUBE)	PLATE (2 MM THIK)	PLATE & PIPE*
BASE METAL P-OR S-NUMBER TO P OR S-NUMBER	P-NO. 21	P-NO. 21 THROUGH P-NO. 26
FILLER METAL F-NUMBER (S)	F-NO. 23	F-NO. 21 THROUGH F-NO. 26
CONSUMABLE INSERT (GTAW OR PAW)	N.A.	N.A.
FILLER TYPE (SOLID / MEETAL OR FLUX CORED/POWDER) (GTAW OR PAW)	SOLID	SOLID
WELD DEPOSIT THICKNESS – 3 LAYERS MINIMUM	2 MM	UP TO 4 MM
WELD DEPOSIT THICKNESS -3 LAYERS MINIMUM	N.A.	N.A.
POSITION QUALIFIED (2G, 6G, 3F, ETC.)	3G	GROOVE (F,V*&F,H,V**) FILLET (F,V*&F,H,V***)
VERTICAL PROGRESSION (UPHILL OR DOWNHILL)	UPHILL	UPHILL
TYPE OF FUEL GAS (OFW)	N/A	N/A
INERT GAS BACKING (GTAW, PAW, GMAW)	ARGON	ARGON
TRANSFER MODE (SPRAY/GOBULAR OR PULSE TO SHORT CIRCUIT – GMAW)	N/A	N/A
GTAW CURRENT TYPE/POLARITY (AC, DCEP, DCEN)	ACEP	ACEP

*PLATE AND PIPE OVER 24 INCH OD
**PIPE 73 MM OD AND OVER
***ALL BASE MATERIAL THICKNESS FILLET SIZES & DIAMETERS

RESULTS

VISUAL EXAMINATION OF COMPLETED WELD (QW–302.4): SATISFACTORY

BEND TEST: TRANSVERSE ROOT AND FACE (QW-462.3 (a)); LONGITUDINAL ROOT AND FACE (QW-462.3(b)); SIDE (QW-462.2);
PIPE BEND SPECIMEN, CORROSION-RESISTANT OVERLAY (QW-462.5(c)); PLATE BEND SPECIMEN, CORROSION-RESISTANT OVERLAY(QW-462.5(d);
MACRO TEST FOR FUSION (QW-462.5(b)); MACRO TEST FOOR FUSION (QW-462.5(e)).

ALTERNATIVE RADIOGRAPHIC EXAMINATION RSULTS (QW-191): SATISFACTORY (RADIOGRAPHY REPORT NO.STNS-256)

RADIOGRAPHY REPORT DATE: 18/02/2022

FILLET WELD-FRACTURE TEST (QW-180): N.A.	LENGTH AND PERCENT OF DEFECT: N.A.
MACRO EXAMINATION (QW-184): N.A.	FILLET SIZE (IN.): N.A. CONCAVITIES/CONVEXITY(IN.): N.A.
FILM OR SPECIMENS EVALUATED BY: HEMANT DESAI	COMPANY: DESAI INDUSTRIAL INSPECTION SERVICES
MECHANICAL TEST CONDUCTED BY: MET-HEAT ENGINEERS PVT LTD.	LABORATORY TEST REPORT NO: STNS-256
WELDING SUPERVISED BY: ARCHIT GANDHI	

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND TAT THE TEST COUPENS WERE PREPARED WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENT OF SECTION IX OF THE ASME BOILER AND PRESSURE VESSEL CODE.

ORGANIZATION/CLIENT: MAX ROOFING SYSTEMS PVT.LTD.	DATE: 21/02/2022
INSPECTION AGENCY: DIIS	APPROVED BY: HEMANT DESAI

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