




# Desai Industrial Inspection Services

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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 CLASSIFICATION(S): ER 4043		
TESTING CONDITIONS AND QUALIFICATION LIMITS		
WELDING VARIABLES (QW-350)		
	ACTUAL VALUE	RANGE QUALIFIED
BACKING (METAL, WELD METAL, DOUBLE-WELDED, ETC.)	WITHOUT BACKING	WITHOUT BACKING
<input type="checkbox"/> PLATE <input type="checkbox"/> 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 / METAL 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 FOR FUSION (QW-462.5(e)).		
ALTERNATIVE RADIOGRAPHIC EXAMINATION RESULTS (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 THAT 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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QC1 EXP. 7/1/2023



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