



**ASME IX WELDER PERFORMANCE QUALIFICATION (WPQ).**  
ASME Boiler and Pressure Vessel Code, Section IX, QW301

Employer STAINLESS FITTINGS LTD, TIPTON ROAD, WEST MIDLANDS, DY1 4SQ  
 Welder's Name :  
 Identification:  
 Method of Identification :  
 Date of Welding

Certificate Ref : ASME/WPQ/000794 Rev 0  
 Reference Number: IC-2789

**Test Description**

Identification of WPS followed: ASME/PQR/BW2-WQ  
 Specification and type/grade or UNS number of base metal(s): ASTM A213 TP 316L

Test Coupon:  Production Weld  
 Thickness (mm): 1.65mm

**Testing Conditions and Qualification Limits**

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Processes(es)	GTAW with filler	GTAW with filler
Type (i.e. Manual, Semi-Automatic) used	Manual	Manual
Backing (with/without)	Without	Without, with =>25mm
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (Pipe diameter)	50.8mm	P N° 1-15F,34,41-49
Base Metal P- or S- number to P- or S- number	P N° 8 to P N° 8	Groove, Fillet
Joint Type	Single V Groove	-
Filler metal or electrode specification(s) (SFA)	N/A	-
Filler metal or electrode classifications(s)	N/A	-
Filler metal F-Number(s)	N/A	-
Consumable insert (GTAW or PAW)	N/A	-
Filler type (solid/metal or flux cored/powder)	N/A	-
Deposit thickness for each process (mm)	1.65mm	3.3mm Max
Fillet Weld base material thickness	1.65mm	All
Position Qualified (2G, 6G, 3F etc.)	Horizontal(2G)	F, H
Vertical progression (uphill or downhill)	N/A	-
Type of fuel gas (OFW)	N/A	-
Inert gas backing (GTAW, PAW, GMAW)	With	With
Transfer mode	N/A	-
GTAW current type/polarity	DCEN	DCEN

**Test Results**

Visual examination of completed weld; QW-302.4

- Transverse face and root bends; QW-462.3 (a)
- Longitudinal bends; QW-462.3 (b)
- Side bends; QW-462.3 (b)
- Pipe/Pipe bend specimen, corrosion-resistant overlay; QW-462.5 (c/d)
- Pipe/Plate specimen, macro test for weld overlay; QW-462.5 (b/e)
- RT or  UT; Alternative Volumetric Examination Results; QW-191
- Fillet welds in Plate/pipe; QW-462.4 (b/c) (Fracture)
- Fillet welds Macro examination; QW-184

- Acceptable
- Not Required
- Not Required
- Not Required
- Not Required
- Acceptable
- Not Required
- Not Required

Welding Supervised by:

Inspection Body: WQ Inspection & Certification Ltd

Certified by:

Date of Issue:



Test Result: RT002449

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 BOILER AND PRESSURE VESSEL CODE.

QW-322 - Confirmation of continuity is required every six months (see reverse)

## Test qualification certificate for welding operators or weld setters

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Manufacturer's welding procedure specification ASME/PQR/BW4

Certificate Ref: ISO/OP000215 Rev 1

Reference No. (if applicable)

Reference No. IC-2789

Name of welding operator or weld setter:

Identification:

Method of Identification:

Date and Place of Birth:

N/A

Employer:

STAINLESS FITTINGS LTD

Code / Testing Standard:

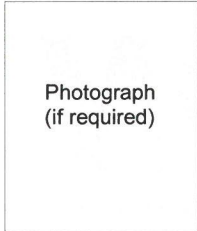
ASME IX 2021

Functional knowledge test (Mandatory):

Acceptable

Job Knowledge:

Not Tested



	Weld Test Details	Range of qualification
Welding process(es) Welding equipment Welding unit	GTAW - P AMI M217 Power Source AMI 08-4000 Enclosed Head	GTAW-P Types as test Types as test
<b>Details for mechanized welding</b> Visual control / visual remote control Automatic arc length control Automatic joint tracking Welding position Single run / multi run Material backing Consumable insert	Direct Visual Control Without Without Special Position (SP) single PASS without - gas backed without	Direct Visual Control - with, without sp, f single PASS with, without - gas backed without

Additional information is available on attached sheet and / or welding procedure Specification No: ASME/PQR/BW4

<p>The qualification is based on:</p> <p>-welding procedure test <input type="checkbox"/></p> <p>-pre-production welding test <input type="checkbox"/></p> <p>-standard test piece <input checked="" type="checkbox"/></p> <p>-production test or production sample testing <input type="checkbox"/></p>	<p>Name and Signature</p> <p>Examiner or examining body: WQ Inspection &amp; Certification Ltd</p> <p>Date of welding of test piece</p> <p>Location: West Midlands</p> <p>Validity of qualification until: N/A, see below</p>
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Requalification 5.3 c)  Valid until:

Confirmation of the validity by examiner or examining body for the following 6 months (refer to 5.3.c)

Date	Signature	Position or Title

Test Results	RT002448
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