QW-484A SUGGESTED FORMAT A FOR WELDER PERFORMANCE QUALIFICATIONS (WPQ)

(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

Welders name: **Michael Epp** Identification Number: **TSBC Reg#:CBP000245476**

Test Description

Identification of WPS followed: **SM - 1 - 1 - 080 Rev. 1 (Reg # 5633255)** [X] Test coupon [ ] Prod. weld

Specification of base metal (s): **SA 106-B TO SA 106-B** Thickness: **2 " - 0.436**

Test Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values		Range Qualified	
Welding process(es)	SMAW	SMAW	SMAW	SMAW
Type (ie; manual, semi-auto) used	MANUAL	MANUAL	MANUAL	MANUAL
Backing (metal,weld metal, double-welded, etc.)	No Backing	With Backing	No Backing	With Backing
[ ] Plate [X] Pipe (enter diameter if pipe or tube)	2"		1" To No Limit	
Base metal P- or S-Number to P- or S-Number	P1 To P1		P-No.1 through P-No.15F ,P-No.34, and P-No.41 through P-No.49	
Filler metal or electrode specifications(s) (SFA) (info.only)	5.1	5.1	5.1	5.1
Filler metal or electrode classification(s) (info only)	E6010	E7018-1		
Filler metal F-Number(s)	F3	F4	F3	F4
Consumable insert (GTAW or PAW)	NO		NO	
Filler type (solid/metal or flux cored/powder) GTAW or PAW	Covered	Covered	Covered	Covered
Deposited thickness for each process				
Process 1: SMAW 3 layers min. [ ] Yes [X] No	0.125"	0.311"	0.250"	0.622"
Process 2: 3 layers min. [ ] Yes [ ] No				
Positions qualified (2G, 6G, 3F etc.)	6G		ALL	
Vertical progression (uphill or downhill)	UPHILL	UPHILL	UPHILL	UPHILL
Type of fuel gas (OFW)	NO		NO	
Type of Shielding Gas	NO		NO	
Inert gas backing (GTAW, PAW, GMAW)	NO		NO	
Transfer mode (spray/globular or pulse to short circuit-GMAW)	NO		NO	
GTAW current type/polarity (AC, DCEP, DCEN)	DCEP	DCEP	DCEP	DCEP

RESULTS Acceptable

Visual Examination of Completed Weld (QW-302.4)

[X] Bend test; [ ] Transverse root & face [QW-462.3(a)]; [ ] Longitudinal root & face [QW-462.3(b)]; [X] Side (QW-462.2);
[ ] Pipe bend specimen, corrosion-resistant overlay [QW-462.59 c]; [ ] Plate bend spec. corrosion-resistant overlay [QW-452.5(d)];
[ ] Macro test for fusion [QW-462.5(b)]; [ ] Macro test for fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result
Side Bend-1	Pass	Side Bend-3	Pass		
Side Bend-2	Pass	Side Bend-4	Pass		

Alternate radiographic examination results (QW-191)

Fillet weld-fracture test (QW-184): **NONE** Fillet size (in): **NONE** X **NONE** Concave/convex(in): **NONE**

Other tests: **NONE**

Film or ***specimens*** evaluated by: **Leonard Wiebe** Company: **UAPICBC**

Mechanical tests conducted by: **UAPICBC** Laboratory test no.: **TP# 06**

Welding supervised by: **Leonard Wiebe**

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 & Pressure Vessel Code.

Test Conducted For: **Lorneville Mechanical Contractors Ltd.**

Accredited Test Facility: **UA Piping Industry College of BC**

Date: **January 31, 2023**

By: **Leonard Wiebe** **10011192**

Leonard Wiebe

CSA W178.2---10011192
Leonard Bruce Wiebe
Welding Inspector Level 2