



ATLANTIC STEAM
 5 SILVER PARK, SILVER STREET, BRACKENFELL, 7560
ASME IX - Welder Performance Qualification (WPQ)
 Welderqual

Welder's name ID Number Date of birth Stamp number Company name Division	R.RABIE 7009155186087 1970/09/15 RR ATLANTIC STEAM WELDING		Test date WPQ record number Standard test number WPS record number Qualification code	2017/11/13 ATLANTIC -2017-3 - AS001 ASME Section IX	Rev. - Rev. 0
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BASE METALS							
	Product form	Spec. (Type or Grade), UNS #	P no.	Grp.no.	Size	Sch.	Thick. mm Dia. mm
Welded to:	Pipe	A-106 (B), UNS K03006	1	1	50.80	80	5.54 60.33
	Pipe	A-106 (B), UNS K03006	1	1	50.80	80	5.54 60.33
Joint type	Groove						

VARIABLES		Actual values		RANGE QUALIFIED			
Type of weld joint Base metal	Pipe - Groove P1 to P1			Groove and Fillet welds P-no. 1 thru 15F, 34, 41 thru 49			

BASE METAL THICKNESS							
		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness	mm	-	-	-	no limit	no limit	-
Pipe/tube thickness	mm	5.54	-	-	no limit	no limit	-
Pipe diameter	mm	60.33	-	-	25.4 min	no limit	-

VARIABLES		Actual values		RANGE QUALIFIED			
Welding process Type Backing Filler metal specification Filler metal classification Filler metal F-number Filler metal variety (QW-404.23) Consumable insert Number of layers deposited Weld deposit thickness Weld position (Actual position tested) Groove - Plate & Pipe > 610mm Groove - Pipe 73mm to 610mm Groove - Pipe < 73mm Fillet - Plate & Pipe > 610mm Fillet - Pipe 73mm to 610mm Fillet - Pipe < 73mm Progression Backing gas Welding current/polarity		GTAW Manual None 5.18 ER70S-6 6 Bare None 2 5.54 6G Up Without DCSP		GTAW Manual With, without 5.xx Any 6 Bare Without 11.08 max. All All All All All All Up With, without DCSP			

TESTS			
Type of test	Acceptance criteria	Result	Comments
Visual examination per QW-302.4 RT per QW-191 and QW-302.2	QW-194 QW-191.2	Acceptable Acceptable	see - ASME IX - QW-452.1 (a) see - see ASME IX - QW-1423, QW-304

Notes: SEE RT REPORT : 26996- RT 04

CERTIFICATION			
Tests conducted by	RITC (Pty) Ltd	Laboratory test number	-
Mechanical tests by	-	Test file number	26996- RT 04

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

INSPECTION AUTHORITY

Name	Signature
RITC (Pty) Ltd	
Date	
2017/11/23	
Signature 3	
Name	Signature
Date	



CLIENT

Name	Signature
ATLANTIC STEAM	
Date	
2017/11/23	
Signature 4	
Name	Signature
Date	