Pyramid Co.
123 Any Street
KC, MO 64015

Welder or Welding Operator Performance Qualification (WPQ)

Welder's Name: **Smith, John** Stamp: **1**
Test WPS No.: **Example 1b** Rev.: **0** WPQ No.: **Example 1c** Date: **3/11/2016**
Welding process(es) / type(s) used: GTAW / Manual and GMAW / Semiautomatic and SMAW / Semiautomatic
Type of joint welded: Plate Groove weld Joint type(s) qualified: Groove and Fillet Welds
Base metal(s) welded: SA-516, Grade 70 to SA-516, Grade 70

Welder Variables (QW-350)	Actual Values Used		Range Qualified	
P- or S-Number to P- or S-Number	P-No. 1 to P-No. 1		P-1 thru P-15F,P-34 & P-4X	
Base metal thickness (in.)	1		WPS Limits	
Pipe diameter (in.)	N/A		2.875" minimum	
	GTAW / Manual	**GMAW / Semiauto**	**GTAW / Manual**	**GMAW / Semiauto**
Backing **	No backing used	Backing used	With or without backing	With backing only
AWS classification	ER70S-2	E70C-3C		
Filler metal specification (SFA)	5.18	5.18	5.xx	5.xx
Filler metal F-No.	6	6	F-No. 6	F-No. 6
Filler metal product form	Bare (Solid)	N/A	Bare / metal cored	N/A
Consumable insert	Insert used	N/A	With insert (n2)	N/A
Deposit thickness (in.) [>= 3 layers]	0.125 [N/A]	0.5 [Yes]	0.2500" maximum	WPS Limits
Welding position	1G - Flat	1G - Flat	Flat only	Flat only
Weld progression	N/A	N/A	N/A	N/A
Backing gas	No backing gas used	No backing gas used	W/WO backing gas	W/WO backing gas
GTAW welding current / polarity	DCEN (straight)	N/A	DCEN (straight)	N/A
GMAW / FCAW transfer mode	N/A	Short-circuiting arc	N/A	Short-circuiting arc

Machine Welding Variables (QW-360)	Actual Values Used		Range Qualified	
Direct / remote visual control	N/A	N/A	N/A	N/A
Automatic voltage control	N/A	N/A	N/A	N/A
Automatic joint tracking	N/A	N/A	N/A	N/A
Welding position	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Backing **	N/A	N/A	N/A	N/A
Single / multiple pass per side	N/A	N/A	N/A	N/A

(THIRD PROCESS)

Welder Variables (QW-350)	Actual Values Used	Range Qualified
	SMAW / Semiautomatic	**SMAW / Semiautomatic**
Backing **	With backing only	With backing only
AWS classification	E7018	
Filler metal specification (SFA)	5.1	5.xx
Filler metal F-No.	4	F-No. 1 to F-No. 4
Filler metal product form	N/A	N/A
Consumable insert	N/A	N/A
Deposit thickness (in.) [>= 3 layers]	0.375	0.7500" maximum
Welding position	1G - Flat	Flat only
Weld progression	N/A	N/A

Machine Welding Variables (QW-360)	Actual Values Used	Range Qualified
Direct / remote visual control	N/A	N/A
Automatic voltage control	N/A	N/A
Automatic joint tracking	N/A	
Welding position	N/A	N/A
Consumable insert	N/A	N/A
Backing **	N/A	N/A
Single / multiple pass per side	N/A	N/A

Fillet Welds: Qualified to make fillet welds of any size on all base material thicknesses and pipe diameters of any size.
** Welds with backing include fillets and double-welded groove welds.
Notes: (n2) Also qualified without insert for fillets and single-welded butt joints with backing or double-welded butt joints.

Guided Bend Test (QW-160)

Figure Number and Type	Result	Figure Number and Type	Result
QW-462.3(b) Face bend	Satisfactory	QW-462.3(b) Root bend	Satisfactory
QW-462.3(b) Face bend	Satisfactory	QW-462.3(b) Root bend	Satisfactory
None		None	

Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194

Volumetric test results: None

Welding test conducted by: Pyramid Co.

Mechanical/Radiographic tests conducted by: KC Lab #3 Lab test no.: 34576

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.

Organization: Pyramid Co.

Certified By: John Smith 3/11/2016 QA Manager
John Smith Date