

SPMT

Designation	ASME IX:2015 GTAW/SMAW 1-1 G F#6/4 T 17.12 DN 114.3 t 3.5/13.62 6G/6G		
Name	Jason Rose	WPQ Record #	4510-JR1-Rev-0
Welder ID	JR1	Qualified to	ASME IX:2015
Stamp Number	JRW1	WPS Number	4510
Employer	SPMT	WPS Date	2-Mar-2018
Date of Birth		Test Date	24-Apr-2019
Test/Production	test	Award Date	1-May-2019
Job Knowledge	notTested		



Base Metals (QW-403)									
Base Metals	Product Form	Specification	P #	Group #	UNS #	NPS/DN	Diameter	Schedule	Thickness
Steel & steel alloy	Pipe	A/SA-106 B	1	1	K03006	100 mm	114.3 mm	XXS	17.12 mm
Steel & steel alloy	Pipe	A/SA-106 B	1	1	K03006	100 mm	114.3 mm	XXS	17.12 mm

Joint Details (QW-350)		
Welding Variables	Actual Values	Range Qualified
Joint Type	Pipe - Pipe - Groove	Groove and Fillet welds
Base metals P-No. to P-No.	1 - 1	P-No. 1 thru 15F, 34, 41 thru 49
Diameter	114.3 mm	73 - unlimited (groove); No limit (fillet) mm
Thickness	17.12 mm	

Process 1		
Welding Variables (QW-350)	Actual Values	Range Qualified
Process	GTAW	GTAW
Type	Manual	Manual
Backing (Metal, Weld Metal)	Without	Optional
Spec. No. (SFA)	SFA-5.28	
AWS No. (Class)	ER80S-D2	
Filler Metal F-Number	6	6
Filler Metal A-Number	11	
Consumable Insert	Without	Optional
Filler Metal Product Form	Bare (solid or metal cored)	Bare (solid or metal cored)
Weld Deposit Thickness	3.5	7
Number of Layers Deposited	1	

Position		6G		See the rows below for the positions qualified. To be read together with the range qualified values for diameter in the joint details			
Groove - Plate	Groove - Pipe > 610 mm O.D.	Groove - Pipe 73 - 610 mm O.D.	Groove - Pipe 73 mm O.D.	Fillet - Plate	Fillet - Pipe > 610 mm O.D.	Fillet - Pipe 73 - 610 mm O.D.	Fillet - Pipe < 73 mm O.D.
All	All	All	All	All	All	All	All

Process 2		
Welding Variables (QW-350)	Actual Values	Range Qualified
Process	SMAW	SMAW
Type	Manual	Manual
Backing (Metal, Weld Metal)	With	Required
Spec. No. (SFA)	SFA-5.1	
AWS No. (Class)	E7018-1	
Filler Metal F-Number	4	1 - 4
Filler Metal A-Number	1	
Consumable Insert	Without	Optional
Filler Metal Product Form	Flux coated (solid or metal cored)	Flux coated (solid or metal cored)
Weld Deposit Thickness	13.62	27.24
Number of Layers Deposited	3	

Position		6G		See the rows below for the positions qualified. To be read together with the range qualified values for diameter in the joint details			
Groove - Plate	Groove - Pipe > 610 mm O.D.	Groove - Pipe 73 - 610 mm O.D.	Groove - Pipe 73 mm O.D.	Fillet - Plate	Fillet - Pipe > 610 mm O.D.	Fillet - Pipe 73 - 610 mm O.D.	Fillet - Pipe < 73 mm O.D.
All	All	All	All	All	All	All	All

Test Methods	Test Result	Test Report
Visual Examination per QW-302.4	Performed and Acceptable	
2 face bend test - ref. QW-161.2	Performed and Acceptable	
2 root bend test - ref. QW-161.3	Performed and Acceptable	
4 side bend tests - ref. QW-161.1	Not tested	
Radiographic examination Cl. QW-302.2	Performed and Acceptable	Test Report 01.pdf
Ultrasonic examination Cl. QW-302.2	Not tested	

Date Welded	24-Apr-2019	Specification	CLI-SPEC-001	Digital signatures Examined by - Kannan Adityan 1-May-2019 Approved by - Kannan Adityan 1-May-2019
Requalification?	Yes	Test Location	AWS Center	
Place of Testing	Loveland, CO	Weather	Fine	
Award Date	1-May-2019	Ambient Temperature	10 °C	

TEST REPORTS



REPORT NO: 44120962

DATE: 28 June 2012

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CLIENT: SAMPLE SAMPLE SAMPLE SAMPLE
SAMPLE SAMPLE SAMPLE SAMPLE
CONTACT: SAMPLE SAMPLE SAMPLE SAMPLE

SUBJECT: The Radiographic Examination of nominate Project. The examination was carried out at Power. SAMPLE SAMPLE SAMPLE
SAMPLE SAMPLE SAMPLE
SAMPLE SAMPLE SAMPLE

IDENTIFICATION: As per results

ORDER NO: P4840-0175

EXAMINATION DATE: 25.06.2012

TECHNICIAN: A. Dyktynski & I. Parsons

TECHNICAL DATA

Radiographic Standard: AS 2177-2006
Test Procedure: RT.002
Method No: GR 1 / DWS
Radiation Type: Iridium 192 – 925 GBq
IQI Type: 10 FE EN (F)
Sensitivity Achieved: Wire No: 12
Screen Type: PB 0.125 mm
Density Range Achieved: 2.6-3.3
Material Specification: 2 1/4 CR-1Mo (D2)
Welding Process: GTAW
Manufacturing Standard: AS 1228-2006, Class 1
Acceptance Standard: AS 4037-1999, Table 8.2, Class 1
Test Restrictions: Nil



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