


WELDER QUALIFICATION TEST CERTIFICATE

Welder Name :	MD RUSTAM ALI KHAN	Certificate Number
Welder ID No:	SDC-0167	SDC-WQT-681
Date Of Birth :	11-APR-1983	
Passport Number :	A14351133	
WPS Reference :	SDC/WPS-001	
Test Coupon :	SDC-091-WQTP	
Base Metal :	CS-ASTM A36	
Weld Length & Thickness :	200 mm & 12.00 mm	
Date of Test :	25-08-2024	

Testing Variables and Qualification Limits

Welding Variable	Actual Values	Qualification Ranges
Welding process :	GTAW	GTAW
Type used (manual, Semi-auto):	Semi Auto	Semi Auto
Backing (metal, weld metal, double welded, etc.) If No, Entre No :	Not Required	Not Applicable
For Pipe (Enter diameter if pipe/tube) & For Plate (Welding Length) :	Pipe - 2"	Pipe - 2"
Base Metal Thickness :	8.00 mm	8.00 mm
Base Metal P-or-S to P-or-S Number :	P1 to P1	P1 to P1
Filler Metal or electrode specification (s) (SFA) :	A5.18	A5.18
Filler Metal or electrode classification(s) :	ER70S-6	ER70S-6
Filler Metal F - Number :	F-6	F-6
Consumable insert (GTAW) :	Not Applicable	Not Applicable
Filler type (solid/metal of flux cored/powder) (GTAW) :	Solid	Solid
Deposit Thickness for each process of welding pass. :	8.00	16.00
Process 1-GTAW : (Root, Hot, Fill & Cap) : Three Layer Minimum	8.00	Maximum
Process 2-SMAW (Root, Hot, Fill & Cap) : Three Layer Minimum	Not Applicable	Not Applicable
Position qualified :	6G	6G
Vertical Progression (uphill or downhill) :	Uphill	Uphill
Type of fuel gas (OFW) :	Argon 99.99%	Argon 99.99%
Inert gas backing (GTAW, PAW, GMAW) :	Not Required to Used	Not Used
Transfer mode (spray/globular or pulse to short circuit - GMAW) :	Not Applicable	Not Applicable
FCAW, GMAW, GTAW, SMAW current type / polarity (Polarity (AC, DCEP, DCEN) :	DCEN	DCEN

Sketch of Bevel Preparation



Validity : 06 Months (Renewable under the conditions of ASME SEC. IX, QW-322.)

Results

Non-Destructive Test		Destructive Test	
Visual Inspection By -CWI	Satisfactory	Macro Exam.	Not Applicable
Magnetic Particle Test	Not Applicable	Root Bend	Not Applicable
Liquid Penetrant Test	Not Applicable	Face Bend	Not Applicable
Radiography Test	Satisfactory (SDC-091-WQTP)	Side Bend	Not Applicable
Ultrasonic Test	Not Applicable	Fillet Weld Fracture	Not Applicable

We Certify that the statements in this record are correct and the test coupons were prepared, welded and tested in accordance with the requirement of section IX of the ASME Boiler and pressure Vessel Code.

SDC Overseas Training & Testing Centre Authority Approved

Approved By Welding Inspector			Witnessed & Endorsed By Manager
			

