



**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES**

**WELDER PERFORMANCE QUALIFICATION  
( ASME SEC IX )**

PROJECT NAME : MPP-12  
 CLIENT : PI INDUSTRIES - JAMBUSAR  
 NAME OF WELDER : RAJAN  
 WELDER ID : W-VPI-40  
 WPS NO. FOLLOWED : VE/WPS/008  
 TEST COUPON NO. : WELD DATE : 24.11.2024, WQT-112  
 BASE METAL : SA 312 TP316L  
 TEST COUPON SIZE : 2" Sch STD (Thk 5.54 mm)

<b>Welding Variables</b>	<b>Actual Values</b>	<b>Range Qualified</b>
Welding Process(es)	GTAW	GTAW
Type (i.e, Manual, Semi-Automatic)	Manual	Manual
Material Size (mm)	2" (60.3 mm Dia)	1" (25 mm) to unlimited
Material Thickness (mm)	5.54 mm	upto 11.08 mm
Type of Weld Joint	Pipe Groove- Without Backing	Groove : With & Without Backing Fillet : Any
Base Metal (P No.)	8	1 through 15F
Filler Metal Specification	AWS A5.22 + SFA 5.9	AWS A5.22 + SFA 5.9
Filler Metal Classification	R316LT1-5 + ER316L	R316LT1-5 + ER316L
Filler Metal F No.	6	6
Filler Metal Product Form (Solid/ Core / Flux Core)	Solid	Solid
Welding Position	6G	PIPE & PLATE Groove : All PIPE & PLATE Fillet : All
Progression (Uphill / Downhill)	Uphill	Uphill
Single or Multiple Electrode	Single	Single
Backing Gas for GTAW, PAW, GMAW, FUEL Gas to OFW	NA	NA
GMAW Transfer mode / Metal Transfer mode	NA	NA
Polarity	DCEN	DCEN

**Examination Detail:**

Radiographic Test : Satisfactory	Report no. : VE/RT/WPQ/11/2024/01E Dt: 25.11.2024
Tensile / Bend Test : NA	Report no. : NA
Macro Test : NA	Report no. : NA
Fillet Test : NA	Report no. : NA
Film Evaluated By : CLIENT / TPIA	Report no. : VE/RT/WPQ/11/2024/01E Dt: 25.11.2024
Visual Examination: Satisfactory	Report no. : NA

**REVIEWED & APPROVED BY :**

VE QC	CLIENT-QC/TPI
SIGN: 	SIGN:
Name: HARDIK PRAJAPATI	Name:
Date: 25.11.2024	Date:
VE/QA FORMAT/51 REV.01	