



**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 : GULSHAN KUMAR  
 WELDER ID : W-VPI-52  
 WPS NO. FOLLOWED : VE/WPS/018 Rev 01  
 TEST COUPON NO. : WQT-104  
 BASE METAL : SA 106 Gr.B  
 TEST COUPON SIZE : 6" Sch STD (Thk 7.11 mm)

<b>Welding Variables</b>	<b>Actual Values</b>	<b>Range Qualified</b>
Welding Process(es)	GTAW + SMAW	GTAW + SMAW
Type (i.e, Manual, Semi-Automatic)	Manual + Manual	Manual + Manual
Material Size (mm)	6" (168.3 mm Dia.)	2 7/8" to unlimited
Material Thickness (mm)	7.11 mm	upto 14.22 mm
Type of Weld Joint	Pipe Groove- Without Backing	Groove :With & Without Fillet : Any
Base Metal (P No.)	1	1 through 15F
Filler Metal Specification	AWS A5.18 + AWS A5.1	AWS A5.18 + AWS A5.1
Filler Metal Classification	ER 70S-2 + E7018	ER 70S-2 + E7018
Filler Metal F No.	6 + 4	6 + 4
Filler Metal Product Form (Solid/ Core / Flux Core)	Solid + Flux covered	Solid + Flux covered
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 + DCEP	DCEN + DCEP

**Examination Detail:**

Radiographic Test : Satisfactory Report no. : VE/RT/WPQ/11/2024/01C Dt: 20.11.2024  
 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/11/2024/01C Dt: 20.11.2024  
 Visual Examination: Satisfactory Report no. : NA

**REVIEWED & APPROVED BY :**

VE QC	CLIENT-QC/TPI
SIGN:	SIGN:
Name: HARDIK PRAJAPATI	Name:
Date: 20.11.2024	Date:
VE/QA/FORMAT/51 REV.01	