



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 : MITHUN KUMAR SAH
 WELDER ID : W-VPI-53
 WPS NO. FOLLOWED : VE/WPS/018 Rev 01
 TEST COUPON NO. : WQT-103
 BASE METAL : SA 106 Gr.B
 TEST COUPON SIZE : 6" Sch STD (Thk 7.11 mm)

| Welding Variables | Actual Values | Range Qualified |
|---|------------------------------|--|
| 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 | |