QW-484A – SUGGESTED FORMAT A FOR WELDER PERFORMANCE QUALIFICATIONS (WPQ)

(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code))

Welders Name _____ Identification No. _____

Test Description

Identification of WPS followed _____ ☐ Test Coupon ☐ Production weld

Specification and type/grade or UNS number of base metal(s) _____ Thickness: _____

Testing Conditions and Qualification Limits

Welding Variables (QW-350)	Actual values	Range qualified
Welding process (es)		
Type (i.e., manual, semi-automatic) used		
Backing (with/without, metal, weld metal, double-welded, etc.)		
☐ Plate ☐ Pipe (enter diameter, if pipe or tube)		
Base metal P- or S-Number to P-or S-Number	**to**	
Filler metal or electrode specification(s) (SFA) (info only)		
Filler metal or electrode classification(s) (info only)		
Filler metal F-Number(s)		
Consumable insert (GTAW or PAW)		
Filler type (solid/metal or flux cored/powder (GTAW or PAW)		
Deposit thickness for each process		
Process 1: _____ 3 layers minimum ☐ Yes ☐ No		
Process 2: _____ 3 layers minimum ☐ Yes ☐ No		
Position qualified (2G, 6G, 3F, etc.)		
Vertical progression (uphill or downhill)		
Type of fuel gas (OFW)		
Inert gas backing (GTAW, PAW, GMAW)		
Transfer mode (spray/globular or pulse to short circuit –GMAW)		
GTAW current type/polarity (AC, DCEP, DCEN)		

RESULTS

Visual Examination of Completed Weld (QW-302.4) _____

☐Transverse face and root bends [QW-462.3 (a)]; ☐Longitudinal bends [QW-462.3 (b)]; ☐Side bends (QW-462.2)

☐Pipe bend specimen, corrosion-resistant weld metal overlay [QW-462.5(c)]

☐Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5 (d)];

☐ Pipe specimen macro test for fusion [QW-462.5 (b)]; ☐ Plate specimen macro test for fusion [QW-462.5 (e)];

Type	Result	Type	Result	Type	Result

Alternative radiographic examination results (QW-191)

Fillet weld -- Fracture test (QW-180) _____ Length and percent of defects _____

☐ Fillet welds in plate [QW-462.4(b)] ☐ Fillet welds in pipe [QW-462.4(c)

Macro examination (QW-184) _____ Fillet size (in.): _____ X _____ Concavity/convexity (in.): _____

Other tests _____

Film or specimens evaluated by: _____ Company _____

Mechanical tests conducted by: _____ Laboratory Test Number _____

Welding supervised by _____

We certify that the statements in this record are correct and that the test coupons were prepared welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer or Contractor _____

Date: _____ Certified by: _____