## QW-484B — SUGGESTED FORMAT B FOR WELDING OPERATORPERFORMANCE QUALIFICATIONS (WOPQ) (See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

Test Description (Information Only)    Test Coupon   Production weld	Welding operator's name Identification No						
Specification and type/grade or UNS number of base metal(s)   Base Metal P- or S- Number   Do P- or S- Number   Position (26, 66, 3F, etc.)			Test Description	(Information Only)			
Base Metal P- or S- Number	Identification of WPS fo	llowed		☐ Test Coupon ☐ Production weld			
Base Metal P- or S- Number	Specification and type/grade or UNS number of base metal(s)			·			
Plate   Plope (enter diameter, if pipe or tube	Base Metal P- or S- Number to P- or S- Number						
Testing Conditions and Qualification Limits When Using Automatic Welding Equipment Welding Variables (QW-361.1)							
Melding Variables (QW-361.1)   Actual values   Range qualified							
Type of welding (automatic) Welding process Filler metal used (Yes / No) (EBW or LBW) Type of laser for LBW (CO: to YAG, etc.) Continuous drive or inertia welding (FW) Vacuum or out of vacuum (EBW)  Testing Conditions and Qualification Limits When Using Machine Welding Equipment Welding Variables (QW-361.2) Actual values  Range qualified  Type of welding (machine) Welding process Direct or remote visual control Automatic arc voltage control (GTAW) Automatic joint tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side  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	Testing Conditions and Qualification Limits When Using Automatic Welding Equipment						
Filler metal used (Yes / No) (EBW or LBW) Type of laser for LBW (CD v AG, etc.) Continuous drive or inertia welding (FW) Vacuum or out of vacuum (EBW)  Testing Conditions and Qualification Limits When Using Machine Welding Equipment Welding Variables (QW-361.2)  Actual values  Range qualified	Welding Variables (QW-361.1)			Actual	l values	Range qualified	
Type of laser for LBW (CO: to YAC, etc.) Continuous drive or inertia welding (FW) Vacuum or out of vacuum (EBW)  Testing Conditions and Qualification Limits When Using Machine Welding Equipment Welding (Machine) Welding process Welding process Direct or remote visual control Automatic arc voltage control (GTAW) Automatic point tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (With/Without) Single or multiple passes per side  RESULTS  Visual Examination of Completed Weld (QW-302.4)    Gransverse face and root bends [QW-462.3 (a)];   Longitudinal bends [QW-462.3 (b)];   Side bends (QW-462.2)     Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5 (d)];     Plipe 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 Type Result     Alternative radiographic examination results (QW-191)   Fillet welds in pipe [QW-462.4(c)     Macro examination (QW-181.2)   Length and percent of defects     Gillet 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   Company     Mechanical tests conducted by:   Laboratory Test Number     Welding supervised by		AL.) (EDIA)					
Continuous drive or inertia welding (FW) Vacuum or out of vacuum (EBW)  Testing Conditions and Qualification Limits When Using Machine Welding Equipment  Welding Variables (QW-361.2)  Actual values  Range qualified  Type of welding (machine)  Welding process  Direct or remote visual control  Automatic joint tracking  Position qualified (2G, 6G, 3F, etc.)  Consumable inserts (GTAW)  Backing (with/without)  Single or multiple passes per side  RESULTS  Visual Examination of Completed Weld (QW-302.4)  Transverse face and root bends [QW-462.3 (a)];							
Testing Conditions and Qualification Limits When Using Machine Welding Equipment  Welding Variables (QW-361.2)  Type of welding (machine)  Welding process  Direct or remote visual control  Automatic zor voltage control (GTAW)  Automatic zor voltage control (GTAW)  Automatic zor voltage control (GTAW)  Backing (with/without)  Single or multiple passes per side  RESULTS  Visual Examination of Completed Weld (QW-302.4)    Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5 (d)];   Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5 (d)];   Plate specimen macro test for fusion [QW-462.5 (b)];   Plate specimen macro test for fusion [QW-462.5 (b)];   Plate specimen macro test for fusion [QW-462.5 (b)];   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.):				-			
Welding Variables (QW-361.2) Type of welding (machine) Welding process Direct or remote visual control Automatic are voitage control (GTAW) Automatic joint tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side  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 (d)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pilet specimen macro test for fusion [QW-462.5 (e)];    Alternative radiographic examination results (QW-191)  Fillet weld Fracture test (QW-181.2)   Length and percent of defects   Fillet welds in plate [QW-462.4(c)   Fillet size (in.):   X   Concavity/convexity (in.):   Context (in.):   Concavity/convexity (in.):   Conca	<del>-</del> , , , <u>— — — — — — — — — — — — — — — — </u>						
Welding Variables (QW-361.2) Type of welding (machine) Welding process Direct or remote visual control Automatic are voitage control (GTAW) Automatic joint tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side  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 (d)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Pilet specimen macro test for fusion [QW-462.5 (e)];    Alternative radiographic examination results (QW-191)  Fillet weld Fracture test (QW-181.2)   Length and percent of defects   Fillet welds in plate [QW-462.4(c)   Fillet size (in.):   X   Concavity/convexity (in.):   Context (in.):   Concavity/convexity (in.):   Conca	Testing Conditions and Qualification Limits When Using Machine Wolding Equipment						
Type of welding (machine) Welding process    Company   Company	,	_	=	=		Range qualified	
Direct or remote visual control Automatic arc voltage control (GTAW) Automatic joint tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side    RESULTS		• • • • • • • • • • • • • • • • • • • •	<b>-</b> ,				
Automatic arc voltage control (GTAW) Automatic joint tracking Position qualified (26, 66, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side    RESULTS    Visual Examination of Completed Weld (QW-302.4)   Transverse face and root bends [QW-462.3 (a)];							
Automatic joint tracking Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side    RESULTS							
Position qualified (2G, 6G, 3F, etc.) Consumable inserts (GTAW or PAW) Backing (with/without) Single or multiple passes per side    RESULTS							
Backing (with/without) Single or multiple passes per side    RESULTS							
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							
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							
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 (d)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Plate specimen macro test for fusion [QW-462.5 (e)];    Type	Single or multiple passes per side						
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 (d)];   Pipe specimen macro test for fusion [QW-462.5 (b)];   Plate specimen macro test for fusion [QW-462.5 (e)];    Type	DECILITO						
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)];   Plate specimen macro test for fusion [QW-462.5 (e)];   Type   Result   Type   Result   Type   Result   Resul							
□ 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	Transverse face and root bends [OW-462,3 (a)];						
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							
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 Type Result  Alternative radiographic examination results (QW-191)  Fillet weld Fracture test (QW-181.2) 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							
Type Result Type Result Type Result  Alternative radiographic examination results (QW-191)  Fillet weld Fracture test (QW-181.2) 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							
Alternative radiographic examination results (QW-191)  Fillet weld Fracture test (QW-181.2) Length and percent of defects  Fillet welds in plate [QW-462.4(b)]							
Fillet weld Fracture test (QW-181.2) Length and percent of defects	Туре	Result	Туре	Result	Туре	Result	
Fillet weld Fracture test (QW-181.2) Length and percent of defects							
Fillet weld Fracture test (QW-181.2) Length and percent of defects	Alternative radiographic	evamination results (O	W-191)	•	•		
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	· · · · · · · · · · · · · · · · · · ·						
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							
Other tests  Film or specimens evaluated by: Company  Mechanical tests conducted by: Laboratory Test Number  Welding supervised by		• -	. ,,,		` ,		
Film or specimens evaluated by:  Mechanical tests conducted by:  Welding supervised by  Company  Laboratory Test Number  Welding supervised by	Macro examination (QW	′-184)	Fillet size (in.	):X	_ Concavity/convexity	(in.):	
Mechanical tests conducted by:  Welding supervised by  Laboratory Test Number  Laboratory Test Number	Other tests						
Welding supervised by	Film or specimens evaluated by:Company						
Welding supervised by	Mechanical tests conducted by: Laboratory Test Number						
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:	Date						