QW-484B – SUGGESTED FORMAT B FOR WELDING OPERATORPERFORMANCE QUALIFICATIONS (WOPQ)

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

Welding operator's name _____ Identification No. _____

Test Description (Information Only)

Identification of WPS followed _____ ☐ Test Coupon ☐ Production weld

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

Base Metal P- or S- Number _____ to P- or S- Number _____ Position (2G, 6G, 3F, etc.) _____

☐ Plate ☐ Pipe (enter diameter, if pipe or tube _____

Filler metal (SFA) specification _____ Filler metal or electrode classification _____

Testing Conditions and Qualification Limits When Using Automatic Welding Equipment

Welding 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_2 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 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-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 _____

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: _____