

Form Flashbutt Welder Qualification Checklist

This form must be signed off before the FB welder is permitted to carry out welding for the specified rail type combination. All tests must be completed in accordance with BHP procedure 0130845.

Section A – Qualification DETAILS

Date		Test weld Location	<input type="checkbox"/> Field <input type="checkbox"/> Dome	FBW Machine ID	
Qualification Type	<input type="checkbox"/> Initial qual. <input type="checkbox"/> Weekly re-qual. <input type="checkbox"/> 5/10 weekly Fixed re-qual. <input type="checkbox"/> Yearly re-qual. <input type="checkbox"/> Post-Maintenance Trial <input type="checkbox"/> R&D Trial <input type="checkbox"/> Other Details:				
Reason for Qualification (Test Level)	<input type="checkbox"/> Minor maintenance (Level 3) <input type="checkbox"/> Major maintenance (Level 5) <input type="checkbox"/> Minor Program Change (Level 5) <input type="checkbox"/> Major Program Change (Level 8) <input type="checkbox"/> Other Details:				
Rail Grade 1		Rail Grade 2		Welding Program	
				Welder name	

Section B – WELDING, ALIGNMENT, GRINDING & NDT

WELDING, ALIGNMENT And GRINDING												NDT		HEAT NO.	
No.	Weld #	Physical Consumption (mm)	Quench Pressure / time (psi / s)	Grinding Pass / Fail	Alignment Pass/Fail	<-- Checked by:	MPI Pass / Fail	UT Pass / Fail	NDT tech name	Heat No. Code Left	Heat No. Code Right				
SBT weld	1.														
	2.														
	3.														
	4.														
	5.														
MET	1.														
	2.														

Section C – SLOW BEND TEST AND BOND INTEGRITY

Test Details								Photos*		Bond Integrity
No.	Weld #	SBT Test #	Test Date	Tested by	kN	mm	Pass/Fail	Weld Prior	Fracture Faces	Defect info
SBT	1.									
	2.									
	3.									
	4.									
	5.									

Outcome of Sections B & C:

Attachments: ☐ Weld Charts ☐ Bend Test Charts ☐ Photographs (Weld stencil, fracture face, macro)

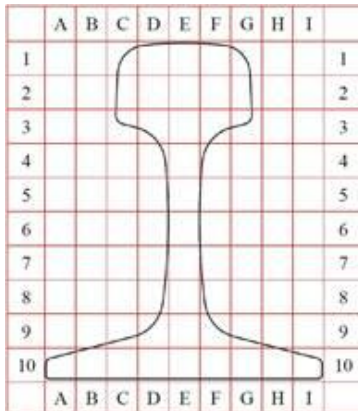
Tester		FBW Engineer	
Signed		Signed	
Date		Date	

Identify location and size of defects on fracture face (flat spots, Lack of fusions etc.)

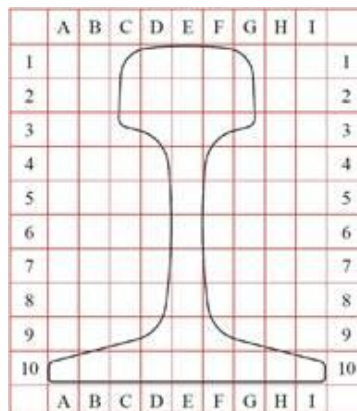
Form

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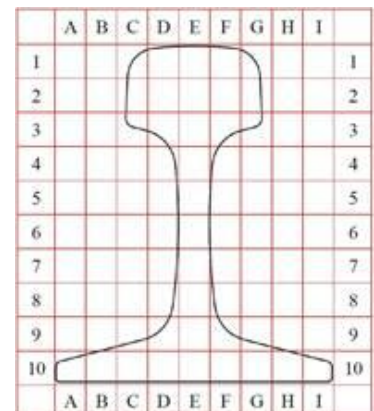
Weld ID:



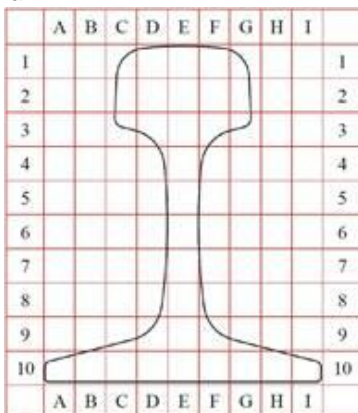
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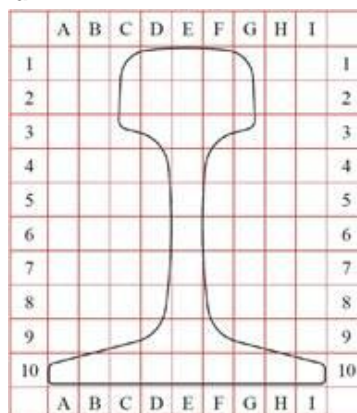
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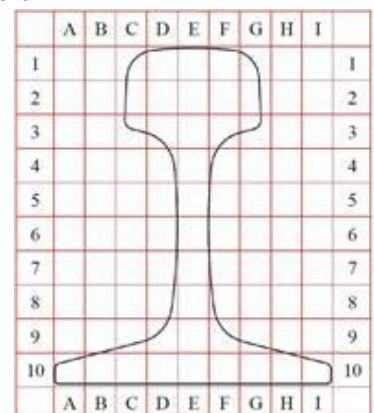
Weld ID:



Weld ID:



Weld ID:

Section E – 3rd Party METALLURGICAL TEST ☐ Required ☐ Not required

No.	Weld #	Report #	Hardness	Macro	Micro	Comments
Met	1.					
	2.					

Overall qualifications results (including 3rd party metallurgical testing)Qualification Approved ☐ YES ☐ NO

Reasons for any deviation from 0130845 Flashbutt Welding of Rails:

Comments:

Attachments:

☐ Weld Charts ☐ Bend Test Charts ☐ Photographs ☐ Program Settings ☐ Metallurgy Report

FBW Engineer		Signed		Date	
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