

# Hindustan Shipyard Ltd.

(A Govt. of India Undertaking)

Gandhigram

Visakhapatnam - 530 005 (INDIA)

(An ISO - 9001:2015 Company)



# हिन्दुस्तान शिपयार्ड लि.

(भारत सरकार का उपक्रम)

गांधीग्राम

विशाखपट्टनम - 530 005 (भारत)

(आईएसओ - 9001 : 2015 कंपनी)

## WELDER PERFORMANCE QUALIFICATIONS CERTIFICATE (QW-484A)

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

Certificate No:VKM25X020/21

Welder's Name: GURUBILLI NANAJI

Date of Birth: 24 May 1992 Sex: MALE



Identification No. : TCS-02

Employer's name & address : M/s Technocon services,  
AIE E-16, Road no:14, AILA,  
pedagantyada, Visakhapatnam-530044.

### Test Description

Identification of WPS followed : 36

Date of welded : 05 Mar 2025

Test coupon : YES

Production Weld : N.A

### Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(s)	SMAW	SMAW
Type( i.e., Manual, semi-automatic) used	Manual	Manual
Backing (with/without)	without	Without
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube)	OD 90 mm	73 mm to Unlimited
Base metal P-N umber to P-Number	P1 to P1 (ASTM A 106 Gr.B)	P1 to P15F
Filler metal or electrode specification(s) (SFAS) (info. only)	SFA-5.1/ AWS E6013	SFA-5.1/ AWS E6013
Filler metal F-Number(s)	2	2
Consumable insert (GTAW or PAW)	NA	NA
Filler metal Product Form (QW-404-23) (GTAW or PAW)	NA	NA
Process 1 <u>SMAW</u> 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	Yes	Yes
Process 2 <u>GTAW</u> 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	NA	NA
Position(s)	6G	Groove-Pipe and Plate-All Fillet-Plate and Pipe-All
Vertical progression (uphill or downhill)	NA	NA
Type of fuel gas(OFW)	NA	NA
Use of backing gas (GTAW or PAW,GMAW)	NA	NA
Transfer mode (spray, globular or pulse to short circuit-GMAW)	NA	NA
GTAW current type and polarity (AC, DCEP, DCEN)	NA	NA

ISO 9001 : 2015  
APPROVED BY IRQS



Registered Office: Gandhigram (P.O.), Visakhapatnam-530 005 (A.P.), India

Fax: (+91-891) 2577502, 2577356, 2577667(SRC), 2577038(Submarine)

Website: [www.hslvizag.in](http://www.hslvizag.in)

CIN: U74899AP1952GO1076711

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## Results

Visual examination of completed weld (QW-302-4) SATISFACTORY

- Tranverse face and root bends [QW-462-3 (a)]     Longitudinal bends [QW-462.3 (b)]     Side bend (QW-462.2 )  
 Pipe bend specimen corrosion resistant weldmetal overlay (QW-462-5(c))  
 Pipe bend specimen corrosion resistant weldmetal overlay (QW-462-5(d))  
 Pipe specimen, macro test for fusion (QW-462-5(b))     Pipe specimen, micro test for fusion (QW-462-5(e))

Type	Result	Type	Result	Type	Result

Alternative volumetric Examination Result (QW-191): SATISFACTORY (HSL RT R.No.055/2025,18/03/2025) RT.

Field weld-fracture test (QW-181-2) N.A length and percent of defects N.A  
 Fillet welds in plate [QW 462-4(b)]     Fillet welds in plate [QW 462-4(c)]

Macro examination (QW-184) N.A Fillet size (in.) N.A Concavity or convexity (in) N.A  
Other tests N.A

Film or specimens evaluated by R.JAYA KUMAR Company INDIAN REGISTER OF SHIPPING.

Mechanical tests conducted by N.A Laboratory test no. N.A

Welding supervised by MOHAMMED AZHARUDHEEN

We certify that the statements in this record are correct and that the coupons were prepared, welded, and tested in accordance with the requirements of section IX of the ASME BOILER AND PRESSURE VESSEL CODE.

(G. Santosh Raju)

Manager (QC-NDT)

Hindustan Shipyard Limited

Visakhapatnam-530 005

Organisation: HINDUSTAN SHIPYARD LTD



Certified by: MOHAMMED AZHARUDHEEN (IRIS)

Date: 23 Apr 2025.

ISO 9001 : 2015  
APPROVED BY IRQS



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