



Authorized Globally	NCP	WPQR - N°	N-Cs12.Ist	Date	xx/xx/20xx	QW-2002.2d	NCP-Fabrication Ltd
Marine Vessels Certified		WELDING PROCEDURE QUALIFICATION RECORDS (WPQR)				Off/Onshore Certified	
		ASME BPVC-Section IX_Article II <> {QW-200.2}					
		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4				
			EEMUA-158: Offshore Structures <> Part. 4				
		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX				
Mark:		QW-Process	XXXX + XXXX (OG-102)		Mark:		
NoBo - N°		Test-Position	2G (on Plate Steel)		NoBo - N°		XXXX

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NCP\_ Welding Procedure Qualification Record (WPQR) Template

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[Date: 2009] <sup>KC-R</sup>

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		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX				
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NoBo - N°	XXXX	Test-Position	2G (on Plate Steel)		NoBo - N°	XXXX	



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{Add Owner's Logo /cover picture here}

Released for Construction by	Name		Release Company Address
	Release Date		
	Signature		
		Tele:	
		Email:	
		Website:	

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		ASME BPVC-Section IX_Article II <> {QW-200.2}					
NoBo - N°		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4		NoBo - N°		XXXX
XXXX		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX		XXXX		
Mark:		QW-Process	XXXX + XXXX (OG-102)		Mark:		
		Test-Position	2G (on Plate Steel)				

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**CONTENTS PAGE (QW\_2002.2b)**

**WPQR for STRUCTURAL; SHAPES, PIPE & PLATE STEEL WELDING: \*CERTIFIED by QUALIFICATION TEST\***

WPQR-N°	X= Company Initial <> T = PWHT <> Cs = Carbon Steel <> XX = Thickness of Test Coupon <> I = Impact Tested <> P = Pipe <> St = Plate <> tb = Temper-bead-weld <> b = Back-gouge
Fitness For Use	Provided the verification of this WPQR meets the requirements of local laws/regulations and when required - 3 <sup>rd</sup> Party "Supplementary Approval Certification (SAC)" are acceptance --- This WPQR shall be qualified and applicable for use globally [QW-201, Para. 3], for both Onshore and Offshore Structural welding applications
WPS Templates	Unless otherwise agreed by EPC: Only NCPfirst WPS-Templates_X-Forms: WPX01 thru 10, "Shall" be used with NCP, WPQR- Templates.
Qualified Supplementary Welding Standards	NACE-MR 0175-Part 2 <> AWS-D1.1+D1.8 <> EN ISO 15614-1 <> DNV-OS-C401
Design & Construction	Supporting WPS/s that is to be used to produce Structural-shapes, pipe, plate weldments for Nuclear, Subsea, Marine, offshore & Onshore structures
Filler Material Limits	Filler material Qualification range of approval are limited to the same, A and F number (QW-422 & 404.15), except when the WPS conforms to AWS-D1.1
Base metal Limitations	Base Metal qualified in WPQR qualifies the WPS for base metals of same Group only. MDMT shall not exceed this WPQR impact "Temperature"
WPQR Verifications	Test performed in this WPQR are for establishing the Filler metal "Low Temperature susceptibility" and material weld-ability via welding process selection
WPS Base Metal Limits	Only base materials in the same group and sub-group tested in this WPQR shall qualified the WPS for production welding applications
WPS_QW-Position Limits	As per QW-Code: {ASME-IX: QW-203 = All in Plate} <> {AWS-D1.1 Table 4.1 = Flat & Horizontal on Pipe/Plate} <> {EEMUA-158 = Section 4.4}
QW-Impact Test Range	Impact Tested @ - 25 °C with average weld-metal impact strength above 40 Joules have been assured. See Table 11
Attachments	Appendix A1: (a) Legend, (b) Instructions For WPS Preparation, (c) Welder Tips and Welding Requirements
QW-Acceptance Standard & Criterion	CJP Welds: Acceptance Criteria according to EEMUA -158_Part 7.5_Table 5. PJP & Fillet Welds: Acceptance Criteria according to AWS-D1.1_Clause 5.24_Table 6.1_Figure 5.4 "A" Unless otherwise instructed by EPC: Production WPS/s shall be qualified in accordance with the same Acceptance Criteria as per this WPQR. WPS qualification in accordance to AWS-D1.1 with unlisted AWS material shall conform to Para. 4.8.3. (unlisted Materials) NAVSEA: Acceptance Criteria shall be according to: NAVSEA:>MIL-STD-2035A_Chapter -5.2.2: Class -1
Note	In addition to Special Procedure Qualification Test (SPORT) with the spares from the original Test coupon & SAC test, -- only editorial correction & code addendum shall be permitted [QW-200.2 c].

**Actual Tests That Was Performed In This PQR**

<b>Required Tests For Mechanical Toughness &amp; Properties</b>	<b>Required Tests For Weld Soundness &amp; Quality</b>	<b>Required Tests For Weld Improvement</b>
<ul style="list-style-type: none"> <li>Tensile test (Transverse: Reduced Section) &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Guided Bend test: &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>Fillet Fracture Toughness test: &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>Toughness test (Charpy-V): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>Crack Tip Open Displacement (CTOD): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>Macro-hardness test (EEMUA-158_HV10): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>Macro-hardness test (NACE-MR0175_HV10): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>CTOD (Crack Tip Opening Displacement): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>SOHIC (Stress-Oriented H<sub>2</sub> Induce Crack): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>HIC (Hydrogen Induce Crack Test): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Butt weld nick-break test: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> </ul>	<ul style="list-style-type: none"> <li>Macro test (etching, 5% Nitral): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>MCM [x 200], (etching, 2% Nitral): &gt;&gt; TRR-N°: XXX-XXXX-XXXX</li> <li>NDE -Visual Test (VT): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>NDE -Volumetric UT: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>NDE -Volumetric RT: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>NDE -Magnetic Particle Test (MPT): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>NDE -Liquid Penetrant Test (LPT): &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Test Pad: Undiluted_Chemical Analysis: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>PMI: Particular Material Identification: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> </ul>	<ul style="list-style-type: none"> <li>PWHT: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Pre-heat Treatment &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Hydrogen Bake-Out &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>FLI-Dressing: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Temper Bead Welding &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Cyclic Pressure Test &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>SIV -Test &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> <li>Corrosion test: VCI: &gt;&gt;TRR-N°: XXX-XXXX-XXXX</li> </ul>

Acronym | FLJ = Fatigue Life Improvement, TRR = Test Report Reference, § = AWS-D1.1: Clause, H<sub>2</sub> = Hydrogen, MCM = Microscopic Metallurgy, VCI = Volatile Corrosion Inhibitor, SIV = Stress Induced Vibration

<b>Legal Statement (LS)</b>	<b>Weld Soundness Guarantee and documentation Quality</b>
The Engineering Procurement Contractor (EPC) has the rights to reject any WPS and WPQR template which is not a registered NCP_X-Form format It is a Violation and shall not be permitted to support this WPQR. These rights extend also to the Owner of the Weldment.	The guarantee of production weld/s shall be a 100% liable to the Fabrication Company/s of whom deposited the actual weld/s. The deposited weld/s shall equal the warrantee/guarantee of the weldment and or the equipment's design life respectively.



<b>TABLE-1 AWS D1.1 JOINT PREPARATION &lt;&gt; TEST COUPON REQUIREMENTS (QW - 210/211) &gt;</b>									
Metal Standard	EN 10025-X <&> EN 10025-X	Metal Heat Numbers for	XXXXXX = XXXXX <&> XXXXX = XXXXX	Metal Certification	EN 10204-3.1				
(§5.15.2) Joint Preparation	Flame Cutting + Machining	Weld Face Preparation	Grinding & Sanding	High-low Tolerance (mm)					
Groove Weld Toe-overlap (mm)		Groove Weld Crown Height (mm)		(§C-8.4.1) Fatigue-Life Improvement Method	None				
Metal Temperature before Welding (°C)		Test Plate MDMT (°C)		(Qw-200.2(f) Thickness Range (mm)	12 > 24	Preliminary WPS / QW	QW-256 & 255		
(ISO-15608) Material Designator	Group - 1	Sub-group	1.2	welded to	Sub-group	1.2	(QW-403.8) Coupon Thickness (mm)	12	
Joint Fit-up Method		QW-200.4 (b) Root Backing		Proof Test: Fillet leg-length (mm)		Fillet Weld Theoretical Throat (mm)			
(§ 4.1.1:T-4.1) Joint Type	CJP	Joint Design	V	Coupon Size (area) (mm)	300 by 400	Welding Position	2G	Welding Progression	Horizontal (H)
(QW-451.1) Butt-joint groove Radius		Groove Angles °C		Root Face (mm)		Root Gap (mm)		Weld End/Tab	
(QW-451.4) Fillet-joint groove Radius		Fillet-groove Angles °C		Fillet Root Face (mm)		Fillet Root Gap (mm)		Weld End/Tab	
(QW-403.4) Base Metal		ASME-IX- P-N°		(§ 3.3: T- 3.1)/(§ 4.8.3) Listed/Unlisted		§ 4.8.3-unlisted	Metal Grade		welded to
Visual Acceptance Criteria	AWS-D1.1: §5.24: T-6.1, Figure 5.4 "A" (for CJP, PJP and Fillet Welds) Onshore			&	EEMUA-158: § 7.5 (for CJP and Fillet Welds) Offshore				

Note (a) For symmetrical Fillet Leg-length = 0.707 x Tn. (b) For asymmetrical Fillet Leg-length = 1.09 x Tn (where: Tn = Smallest Thickness (or joint Web). (c) Joint-prep soundness Test Method = UT or LPT (d) Theoretical Throat = Cos 45 x Fillet Leg-length or (0.7071 x Fillet Leg-length).

Remark (1) Filler Metal Qualification Range of approval is limited to filler materials with the same, A and F number as per (Qw-404.15) (2) Unless otherwise instructed by the Weldment Owner \_ only the filler material Brand tested in this WPQR "Shall" qualify the WPS for production welding.

Documents on Request (a) Material 3.1 Certification. (b) Consumable Test Report. (c) NDE Test Reports. (d) Mechanical Test-Reports. (e) Welder Certification. (f) PMI Reports



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		<b>ASME BPVC-Section IX Article II &lt;&gt; {QW-200.2}</b>					
Mark:		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4			Mark:	
NoBo - N°		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX			NoBo - N°	
XXXX		QW-Process	XXXX + XXXX (OG-102)			XXXX	
		Test-Position	2G (on Plate Steel)				



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Table-3	WPS_QW-Data	FIRST PROCESS	SECOND PROCESS	THIRD PROCESS
<b>(QW-200.4) &amp; (ISO) WELDING PROCESS DESIGNATOR</b>		(QW-XXX) XXXX / (XXX)	(QW-XXX) XXXX / (XXX)	(QW-254) SAW / (12)
TYPE: >Manual, Automatic, or Semi-automatic:		Manual	Semi-Automatic	Full-Automatic
<b>FILLER METALS (QW-404)</b>		<i>{Further Information: See Table-18}</i> Diffusible H <sub>2</sub> = API-582: § 5.2.4.4/3_Table 5-1	Diffusible H <sub>2</sub> = API-582: § 5.2.4.4/3_Table 5-1	Diffusible H <sub>2</sub> = API-582: § 5.2.4.4/3_Table 5-1
Flux Trade Name & Type (SAW)		XXXX	XXXX	-
Wire - Flux Classification (SAW) (☛) see table18		XXXX	XXXX	-
SFA/AWS: Specification & Classification		XX.XX: XXXX-XX HX	XX.XX: XXXX-XX HX	-
Filler Metal Manufacturer		XXXXXXXXXX	XXXXXXXXXX	-
Filler Metal Product Form		XXXXXXXXXX - XX XXX-X	XXXXXXXXXX - XX XXX-X	-
Weld Metal Analysis A-N°.		X	X	-
Filler Metal F-N°.		X	X	-
Filler Metal Size (mm)		X.X	X.X	-
Weld Pass Thickness; Max. (mm)		X.X	X.X	-
Deposited Weld Metal Thickness Per Process (mm)		X.X	X.X	-
Weld-Deposit Chemistry (Test-pad). (also SAW -Alloy Flux)	See Table: 8)	< X.XX% Carbon	< X.XX% Carbon	-
Ferrite Contents % (Max)		XXXX	XXXX	-
Root Contour :_ Height (mm) (▲) See table18		X.X	NA	-
Crown/Cap Profile :_ Height (mm)		NA	X.X	-
<b>POSITION (QW-405)</b>				
Welding Position : (2G, 3G, 5G, 6G, (1G / PA))		XX	XX	-
Welding Progression : (H, F, Vu, Oh, Vd),		X = XXXXXXXX_(XXXXXX)	X = XXXXXXXX_(XXXXXX)	-
<b>PREHEAT (QW-406) +(AWS-D1.1: §4.7.4)</b>				
Preheat Temperature: (°C) < Constant or Single >	(See table15)	Single = XX	XXXX	-
Inter-pass Temperature: (Rang) (°C)		XXX - XXX	XXX - XXX	-
Hydrogen Bake-out		According to Table: 15	According to Table: 15	-
<b>GAS (QW-408) &lt;&gt; "Inert or Active" &lt;&gt;</b>		<b>"INERT"</b>	<b>"MIX"</b>	
Shielding Gas Type (% Mixture or Pure)		Pure - Argon (XX.X %)	XX% Argon to XX% CO <sub>2</sub>	-
Shielding Gas Flow Rate (Lt / min)		XX	XX	-
Trailing Gas Type (% Mixture or Pure)		XXXX	XXXX	-
Trailing Gas Flow Rate (Lt / min)		XXXX	XXXX	-
Backing or Purge Gas (% Mixture or Pure)		XXXX	XXXX	-
Backing or Purge Gas Flow Rate (Lt / min)		XXXX	XXXX	-
<b>ELECTRICAL (QW-409)</b>				
Current & Polarity: DCSP (-) or DCRP (+)		DCRP (+)	DCSP (-)	-
Amps [Range]		XXX - XXX	XXX - XXX	-
Volts [Range]		XX.X - XX.X	XX.X - X.X	-
[WFS]-Wire Feed Speed (Range) (in / min)		None	XXX - XXX	-
Travel Speed [Range] ( mm / min) [QW-409.1(b2)]	(●) See table18)	XXX - XXX	(●) See table18) XXX - XXX	-
Mode of Metal Transfer (Dip, Spray, Pulse, STT)		XXXXX	XXXXX	-
Tungsten Electrode Size (mm)		X.X	None	-
Tungsten Type: (Pure, Cerium, Thorium)		EW-Ce2 (Cerium "Grey")	None	-
<b>TECHNIQUE (QW-410 + ( 462.12)</b>		<i>Clean each layer before welding</i>	<i>Clean each layer before welding</i>	
Stringer, Weave, Circle, Whip, Dip or Push-pull		-	-	-
Multiple or Single (Electrodes/Wire/Rod)		Single-Rod	Single-Wire	-
Multiple or Single Passes		-	-	-
Single-side or Double-side Weld		Single-side	Single-side	-
Orifice of Nozzle/Cup Size (mm)		Cups No = X	Nozzle ID = XX	-
CTWD or Visible Stick-out (mm)		Tungsten: Visible Stick-out = X	Visible Stick-out = X	-
Method of Back Gouging: (Arc-air, Grinding)		XXXX	XXXX	-
Welding Torch angle to work piece (90°, 85°, 25° - 15°.)		XX°	XX°	-
Temper Bead Weld-Overlay Range (mm)		XXXX	XXXX	-
Peening: (For welding "Nickle" base material)		XXXX	XXXX	-
Metal Cleaning & Joint Preparation. (API part:10)		Sanding Disc + Machining	Sanding Disc + Machining	-
Inter-pass Cleaning: (Grinding, brushing, Sanding, Dressing)		Brushing + Dressing	Grinding-wheel + Brushing	-
Thermal Process (QW-410.60)		XXXX	XXXX	-
Fatigue Dressing: (GTAW, Burr-grinding, UP) (BS-7608)	(●) See table18)	XXXX	XXXX	-
<b>POSTWELD HEAT TREATMENT (QW- 407)</b>				
PWHT According to (QW-407.2) 80% Rule		XXXX	XXXX	-
PWHT According Div. 1-UCS -56 / Div-2:T—6.7		XXXX	XXXX	-
Source: Induction / Electric Resistance Heater		XXXX	XXXX	-
Heating Rate (°C / Minute)		XXXX	XXXX	-
Soaking Time (Minutes)		XXXX	XXXX	-
Cooling Rate (°C / Minute)		XXXX	XXXX	-
Thermocouple Type (Brand Name)		XXXX	XXXX	-
Thermocouple Total (1T/C, 2T/C, 3T/C, 4T/C)		XXXX	XXXX	-

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		QW-Process	XXXX + XXXX (OG-102)				
NoBo - N°	XXXX	Test-Position	2G (on Plate Steel)		NoBo - N°	XXXX	

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**TEST RESULTS (QW-451)**  
(Testimony that the data collated herein are the true Test results of the titled specimens)

Table-4												NONE-DESTRUCTIVE EXAMINATION (NDE) PROCEDURE ACCORDING TO ASME BPVC Section: V											
Test Coupon No:	Metal Type	Wall Thickness (mm)	Weld Metal Thickness (mm)	UT: (QW-191) + AWS-D1.1: §6.13.2 EEMUA-158_§7.5.3 (100%)		RT (QW-191) + AWS-D1.1: §6.12.2 + EEMUA-158_§7.5.4 (100%)		(100%) MPT: AWS-D1.1: §6.10: Para. 6.14.5		(100%) LPT: (QW-195) + AWS-D1.1: §6.10: Para.6.14.5		(100%) VT: (QW-194) + EEMUA-158_§4.4.3a											
				TRC	Rp.- N°	TRC	Film + (Rp.- No)	TRC	Rp.- N°	TRC	Rp.-N°	TRC	Rp.-N°										
	Plate	12		XXXXXXXXXX	XXXXXXXXXX (See also Fig. 4a & 4b)		XXXXXXXXXX		XXXXXXXXXX		XXXXXXXXXX		XXXXXXXXXX1										

Acceptance Criteria According to: EEMUA-158: Para. 7.5. & EN ISO 15614-1: Para. 7.5 (Since they are Notably more stringent than ASME BPVC: Section V)  
 NOTE TRC = Test Result Code, Sh. = Sheet, Rp = Report, A = No Evident Imperfections, WC = Within Code-limits

Figure-4a	VERIFICATION of AS WELDED TEST COUPON	Figure-4b	VERIFICATION of VOLUMETRIC DIGITAL RADIOGRAPHIC FILM

Coupon-N° \_\_\_\_\_ Base Material Grade/s XXXXXXXX to XXXXXXXX WPQR-N° \_\_\_\_\_ Weld-N° \_\_\_\_\_ Welder-ID-N° \_\_\_\_\_ NDE-ID \_\_\_\_\_



Table-5 (QW-162) & (QW-160) GUIDE BEND TEST ACCORDING TO: < AWS D1.1: § 4.8: Para: 4.9.3.1 Fig. 4.13 >											
Specimen No.	Test Location (°)	Specimen Size: (LW) (mm x mm)	TEST TYPE (TV or Lateral)	Bend Direction	Mandrel Diameter 4T (mm)	Space between Rollers (mm)	Figure No. [QW-462.3 (a)]	Elongation (%) (•)	Test Temp. (°C)	Test Results	
		XX x XX	Transverse	TV-X			Mandrel = 4T @ 180°				
		XX x XX	Transverse	TV-X			Mandrel = 4T @ 180°				
		XX x XX	Transverse	TV-X			Mandrel = 4T @ 180°				
		XX x XX	Transverse	TV-X			Mandrel = 4T @ 180°				

Acronyms TV = Transverse, S = Side, R = Root, F = Face, NR = Not required, LW = Length x Width Remark (•) Not required according to EN ISO 15614-1: § or Para: 7.4.3.

Figure: 5a	VERIFICATION OF TVS SIDE BEND TEST SPECIMEN	Figure: 5b	

Guide Bend Acceptance Criteria AWS-D1.1: Para. 4.8.3.3 & (QW-163) Remark \_\_\_\_\_

Table-6 (QW-180) GUIDED-BEND TESTS ACCORDING TO (QW-162)											
Figure-6a	Macro-Hardness EEMUA-158: § 4.4.4c_Fig.8	Figure-6b	Macro-Hardness NACE MR 0175- Part 2_§7.3.3.2 -Fig.2	Figure-6c							
Specimen-N°	XX (See also figure-6d)	Specimen-N°	XX (See also Figure 6e)	Specimen-N°							
Hardness Acceptance Criteria		According to EPC Requirements (NACE / EEMUA-158 / ASME-IX)		Remark Apply for Production WPS qualification as per EPC request							

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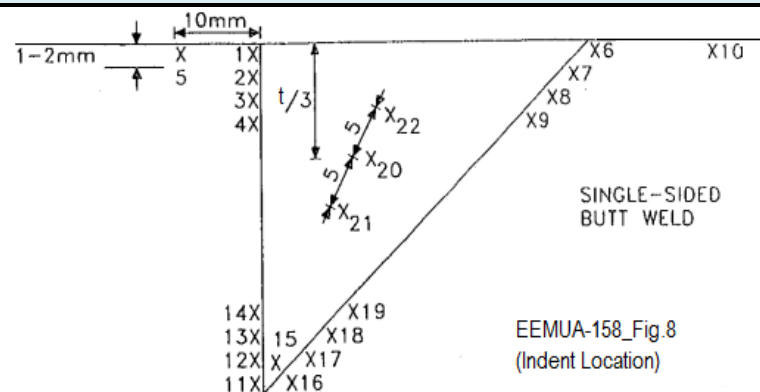
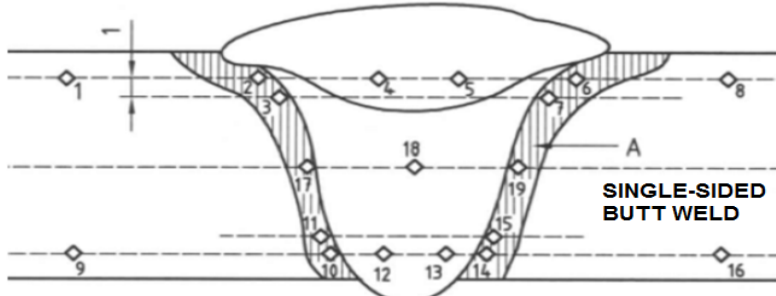
Table-6d	(QW-180) HV10 ≤ 248_MACRO-HARDNESS VALUES and INDENT LOCATOIN: EEMUA 158_Para. 4.4.4c _Figure 8																																																																					
					 <p>SINGLE-SIDED BUTT WELD EEMUA-158_Fig.8 (Indent Location)</p>																																																																	
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Table-6e	(QW-180) HV10 ≤ 248_MACRO-HARDNESS VALUES and INDENT LOCATOIN: NACE MR 0175-Part 2_Para. 7.3.3.2 _Figure 2																																														
			 <p>NACE-MR 0175-Part 2_Figure 2 __ (Indent Location) SINGLE-SIDED BUTT WELD</p>																																												
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9		19																																													
10		20																																													

Hardness Acceptance Criteria **EN ISO 5817\_Level C & B**

NOTES (a) Weld Surface: Brinell Hardness(HB10) ≤ 200, as per NACE (b) PQR: Vickers Hardness (HV10) ≤ 248,(max) as per NACE (c) Weldmetal: Vickers Hardness (HV10) ≤ 380, as per EN ISO



Indent applied Load: 10 kg Time of Load: 15 second HV10 Indent Spacing = 1mm WPS for None NACE, PWHT\_ shall conform to EN ISO 15614-1: § 7.4.6. (Table 2); @ max. Permitted HV10, Limits = 320

Table-7	(QW-151) PRISMATIC or TRANSVERSE (TV) TENSILE TEST ACCORDING TO: < AWS D1.1: § 4.9.3.4: Fig. 4.14 >+<EEMUA:4.4.4a									
Specimen N°	Test Location	Specimen Dimension (mm x mm)	AREA (mm²)	Elongation (%) (*)	Ultimate Total Load, (kN)	Ultimate Unit Stress (N/mm²)	Yield Point (N/mm²) (*)	Test Temp. (°C) (*)	Reduction of Area (%)	Type of Failure and Location
MINIMUM REQUIRED TARGET →				XXX	XXX	XXX ≥ XXX	XXX ≥ XXX		XXX	

Figure-6a	VERIFICATION OF TENSILE TEST SPECIMEN	Figure-6b

Tensile Acceptance Criteria **AWS-D1.1: Para. 4.8.3.5 +( QW-153) + (EN 10025-2 / 04)**

Acronyms NR = Not-required, TV = Transverse Remark (♦) Not required for TV -tensile test as per EN 15614-1 and ASME Section IX

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Marine Vessels Certified		WELDING PROCEDURE QUALIFICATION RECORDS (WPQR)					Off/Onshore Certified	
		ASME BPVC-Section IX_Article II <> {QW-200.2}						
NoBo - N°		QW-Code/s		AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4		NoBo - N°		
XXXX		ISO-9001_QA-Certificate N°		XXXXXXXXXXXXXXXXXXXX		XXXX		
Mark:		QW-Process		XXXX + XXXX (OG-102)		Mark:		
		Test-Position		2G (on Plate Steel)				

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Table-8 TEST PAD: FILLER METAL UNDILUTED CHEMICAL ANALYSIS ASME BPVC Section-II_Part-C_Table 5 & 4: _Figure-1																
Specimen No.	Classification (SFA/AWS)	Filler Size	C (%)	Mn (%)	Ni (%)	Cr (%)	Mo (%)	Si (%)	V (%)	Cu (%)	Ti (%)	Nb (%)	P (%)	S (%)	B (%)	Al (%)
1																
2																
3																
4																
Figure 8a Test-Pad: XXXXXXX			Figure 8b Test-Pad: XXXXXXX			Figure 8c Test-Pad: XXXXXXX			Figure 8d Test-Pad: XXXXXXX							
Testing Apparatus / Equipment										Chemical Analysis Procedure According to						
										ASTM: E-415						
Chemical Analysis Acceptance Criteria										ASME BPVC Section. II-Part C -Table 5 & 4: -Fig. 1						
NOTE Apply for production WPS qualification when no "A" number or no assigned AWS number is designated by the code/s, or if specified by the EPC																

Table-9 (QW-181) FILLET WELD FRACTURE TEST ACCORDING TO: < AWS-D1.1: Para. 4.11.2_Fig. 4.19 >												
Specimen N°	Temp (°C)	Web (mm)	Flange (mm)	Weld Length (mm) <sup>Lw</sup>	Leg-length (mm) <sup>a</sup>	Weld-throat (mm)	Ultimate Total Load (UTL) (N)	Design Weld Strength (DWS) (ksi)	Ultimate Weld Strength (UWS) (ksi)	Fracture Depth of Penetration (mm)	Microscopic Results	Type of Failure and Location
									DWS x UTL			Ductile _ Through Weld Fracture
									DWS x UTL			Ductile _ Through Weld Fracture
Formula Design Weld Strength (DWS) = Fs x 0.707 x a x 0.60 x F <sub>EXX</sub> x L <sub>w</sub> ( Where: a = Fillet Leg Length, FS = Safety Factor, L <sub>w</sub> = Weld- Length, F <sub>EXX</sub> = Electrode Class,...i.e. E70XX )												
Figure 9a (QW-181) Fillet Fracture Test Filler: XXXXXXX			Figure 9b (QW-181) Fillet Fracture Test Filler: XXXXXXX			Figure 9c (QW-462.4a) Fillet Weld Procedure: (QW-XX)						
Specimen N°										Qualification Code: According to		
XXXXX										Multi-Pass Fillet as per EEMUA-158_Para.4.4.1b in 2F (applicable for Production WPS qualification)		
Fillet Fracture Acceptance Criteria										According to (QW-182), and if required by the EPC _ Production WPS qualification / mockup Test in accordance with (QW-181.2)		
WPT of Table-2_Bead N°7		Filler size = XX mm	Amp = XXX	Volts = XX.X	TS = XXX mm/min	Wire-feed = XXX inch/min	Pre-Heat = XX °C	Weld Beads = X	Plate Thk = XX mm			
Remark (a) WPT = Welding Parameters, (b) Thk = Thickness, (c) ■ Single Preheat Time = 8 minutes (Max), TS = Travel Speed												

Table-10 API-1104_Section-5.6.3_NECK BREAK TEST												
Figure 10a Groove weld Neck-Break Test: φ Figure 5			Figure 10b Fillet Weld Neck-Break Test: φ Figure 10			Figure 10c						
Specimen N°										Qualification Code: According to		
										Single Pass Fillet WPS as per EEMUA-158_Para.4.4.1a in 2F (applicable for Production WPS qualification)		
WPT of Table-2_Bead N°8		Filler size = 1.2 mm	Amp = 220	Volts = 30.4	TS = 416 mm/min	Wire-feed = 311 inch/min	Pre-Heat = 85 °C	Weld Beads = 1	Plate Thk = 12mm			
Neck-Break Acceptance Criteria										According to API-1104_Para. 5.6.3.3		
Remark										(a) WPT = Welding Parameters, (b) Thk = Thickness, (c) ■ Single Preheat Time = 8 minutes (Max), TS = Travel Speed		



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		ASME BPVC-Section IX_Article II <> {QW-200.2}					
		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4				
		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX				
		QW-Process	XXXX + XXXX (OG-102)				
NoBo - N°	XXXX	Test-Position	2G (on Plate Steel)			NoBo - N°	XXXX

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**Table-11** (QW-170) IMPACT TESTING REQUIREMENTS ACCORDING TO: < EEMUA-158: Para. 4.4.4e\_Table-2\_Fig. 9a + (EN ISO 148-1)

Average Impact Target @ -10° as per Code		{ASME-IX = 19}, {ASME- B31.3 = 20 J}, {PED = 27 J}, {EEMUA-158= 36 J}, {AWS-D1.8 = 40 J}										Impact Test Procedure as per	SA-370
Specimen No. (★)	Specimen Location & Dimension		Notch Position	[QW-463.1(f)] Test Temperature & Notch Type (Charpy-V / U)		IMPACT-ENERGY Joules		Impact Strength (Value & T <sub>IA</sub> )		Lateral Expansion (Elongation)		(QW-172.1) Drop Weight Break: (Yes or No)	
	Location	Size (mm)		(°C)	Values (J/cm²)	Actual (J/cm²)	Average (J)	Values (J/cm²)	T <sub>IA</sub> (cm²)	Shear (%)	(mm)		
			BM <sub>01</sub>					(*)		(*)			
			BM <sub>01</sub>					(*)		(*)			
			BM <sub>01</sub>					(*)		(*)			
			FL <sub>1</sub>					(*)		(*)			
			FL <sub>1</sub>					(*)		(*)			
			FL <sub>1</sub>					(*)		(*)			
			HAZ <sub>1</sub>					(*)		(*)			
			HAZ <sub>1</sub>					(*)		(*)			
			HAZ <sub>1</sub>					(*)		(*)			
			WM					(*)		(*)			
			WM					(*)		(*)			
			WM					(*)		(*)			
			HAZ <sub>2</sub>					(*)		(*)			
			HAZ <sub>2</sub>					(*)		(*)			
			HAZ <sub>2</sub>					(*)		(*)			
			FL <sub>2</sub>					(*)		(*)			
			FL <sub>2</sub>					(*)		(*)			
			FL <sub>2</sub>					(*)		(*)			
			BM <sub>2</sub>					(*)		(*)			
			BM <sub>2</sub>					(*)		(*)			
			BM <sub>2</sub>					(*)		(*)			

Acronyms BM<sub>1</sub> = S355J2-N\_Base Metal, BM<sub>2</sub> = S355J2-M\_Base Metal, HAZ<sub>1 or 2</sub> = Heat-affected Zone, WM = Weld-metal, FL<sub>1 or 2</sub> = Fusion line, T<sub>IA</sub> = Total Impact Area

CALCULATIONS (\*) Impact Value = Actual J + T<sub>IA</sub> (\*) Shear % = (Ductile Area ÷ T<sub>IA</sub>) x 100 Impact Target = Specimen size x multiply code requirement

T<sub>IA</sub> = Ductile Area + Fragile Area. <OR> (T<sub>IA</sub> = 8 x 10 x 0.01) "Where" 8 is the distance from notch to base of the Specimen Other Reference Refer\_B31.3-Table 323.3.5

**NOTES**  
 \*Impact Testing Requirements for WPS –Qualification  
 (a) Impact Testing of base metal is not required when the base material is certified PED 97/23/CE, or impact tested to ASTM/SA-370 \_\_ or as per EN 10204-3.1 inspection Certificate  
 (b) (★) Impact Testing of both base metals is not required, when the Materials has the same P-No. & Group-No., or if the specified temperature lower than qualified in this table.  
 (c) AWS-D1.1\_Clause 4.33\_Impact Testing shall be as per Contractual requirement s and in conformance with Para: 5.26.5 (3d).  
 (d) EEMUA-158\_Para. 4.4.4e\_Impact Testing of base & Weld metal, HAZ & Fusion line is required to demonstrate weld strength and toughness when the WPS welds are for Offshore structures

Acceptance Criteria According to EEMUA-158: Para. 4.4.4 (e) -Table 2. << And >> AWS-D1.8\_Annex-A\_Para. A7.1 + Annex-B\_Para. B7 & B8

**Table-12** (EN ISO 15635) CRACK-TIP-OPEN-DISPLACEMENT (CTOD) TESTING ACCORDING TO: EEMUA-158: Appendix A2\_Figure 10

Specimen N°	Location	Temp (°C)	Thk. (mm)	Width (mm)	KET (mm)	DBKE (mm)	CL (mm)	Load (kN)	Speed (N/mm)	Span (N/mm)	A (N/mm)	P (N/mm)	SOUT (A or B)	Notch Type	Final Analysis
	BM <sub>1</sub>														
	HAZ <sub>1</sub>														
	WM														
	HAZ <sub>2</sub>														
	BM <sub>2</sub>														

Acronyms (★) DBKE = Distance Between Knife Edges, CL = Crack Length, SOUT = Source Of Uncertainty Type, KET = Knife Edge Thickness, P = Perpendicularity, A = Alignment,

APPLICABLE METHODS EEMUA's Recommended CTOD Testing Lab NAMAS CTOD\_Accredited Test House

Acceptance Criteria EEMUA-158: Para. A2.6 Note For this Special Requirement Test (SRT) Spares from the original Test Coupon have been stored for this>



**Table-13** STRESS-ORIENTED HYDROGEN INDUCE CRACKING (SOHIC) (NACE-TM 0284)

Specimen N°	Length (mm)	Width (mm)	Thickness (mm)	Cut (mm)	CAR (%)	RSK (%)	CLR (%)	CTR (%)	CSR (%)	Microscopic Results	Type of Failure and Location

Acronyms CSR = Crack Sensitivity Ratio, CTR = Crack Thickness Ratio, CLR = Crack Length Ratio, CAR = Crack Area Ratio, RSK = Risk of Stress Sensitivity Factor

Apparatus Brand Name Method Used

Acceptance Criteria According to NACE 0284 + Owner's Acceptance REMARKS Spares from the original Test Coupon have been stored for this Test

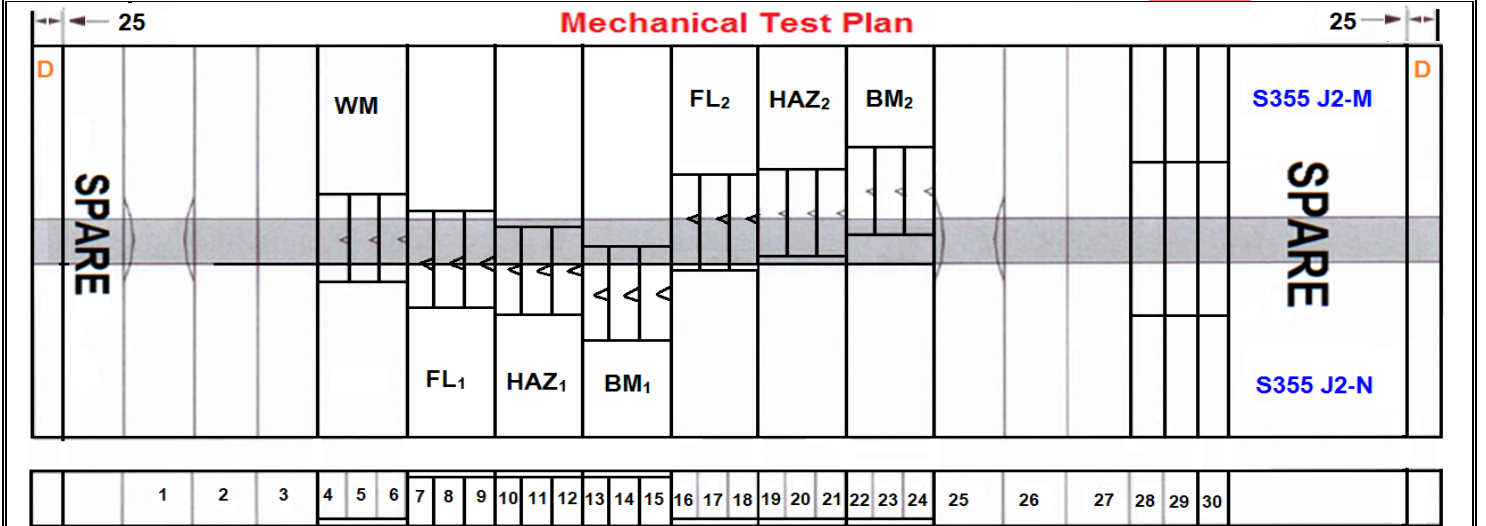
Authorized Globally	NCP	WPQR - N°	N-Cs12.Ist	Date	xx/xx/20xx	QW-2002.2d	NCP-Fabrication Ltd
Marine Vessels Certified		WELDING PROCEDURE QUALIFICATION RECORDS (WPQR)				Off/Onshore Certified	
		ASME BPVC-Section IX_Article II <> {QW-200.2}					
		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4				
		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX				
		QW-Process	XXXX + XXXX (OG-102)				
NoBo - N°	XXXX	Test-Position	2G (on Plate Steel)		NoBo - N°	XXXX	

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**Table-14** PROCEDURE RECORD MECHANICAL TEST PLAN (ASME-IX\_QW-463.1a) + (AWS-D1.1: §4.8\_Figure 4.10) + (EEMUA-158\_§4.4.4)



Acronym	Material Description	Material Mechanical Characteristics	Mandril Details
D = Discard FL = Fusion Line BM = Base Metal WM = Weld Metal BD = Bend Distance t = Thickness	Base material Class	Rm or UTS (N/mm2)	Mandril Diameter
	Base material Spec.	% Area ≥	Distance between rollers (mm)
	Material Type	Average Required Charpy-V, @ -20 °C	Thickness of Coupon: t (mm)
	Thickness	Minimum Required Charpy-V, @ -20 °C	Angle of Bend: BD
	Filler Metal		
	Welding Process		

Notes: Double click on Mechanical Test Plan sketch to edit material spec if required

**Table-15** HEAT-TREATMENT ACCORDING TO AWS D1.1: Para. 5.6\_TABLE: 4.5 <and> HYDROGEN-BAKEOUT (EN ISO 15614-1: Para. 8.4.11 and 8.4.12)



Coupon N°	Description	Temperature (°C)			HR & C (minutes)	Method (Open Flame or Heat-pad)	Thermocouple (total & clock- position)	Insulation (Yes/No)		Preheat Activity		Test performed Yes / None
		Min.	Max.	H				Position	Total	Yes/No	Action	
	(QW-406.1) Pre-heat									Yes	Before welding	
	Weld Joint Stress Relieving										After welding	None (**)
	(QW-407) Pre-heat for PWHT										Before PWHT	
	(QW-407.2) PWHT									No	None	None
	(QW-406.11) BM H <sub>2</sub> Bake-out										Before welding	None (**)
	(QW-406.11) Weld H <sub>2</sub> Bake-out										After welding	None (**)

**PWHT - Thermocouple layout Sketch**

**Hydrogen Bake-out Instructions:**

- (\*\*) Use the PQR, with the highest inter-pass temperature, ± 20 % when required for WPS qualification. (Temperature limits: 200 ≥ 400 °C, max. (as per wall thickness) )
- (\*\*\*) Use the PQR, Average inter-pass temperature, ± 20 % and Hold for 40 to 60 minutes, when required for WPS qualification.

Acronym	C = Cooling, H = Holding, HR = Heating Rate, H <sub>2</sub> = Hydrogen, BM = Base Metal
Acceptance Criteria	AWS-d1.1_Part-C_Para. 6.8 Engineer's Approval
Remark	For PWHT, the Total thermocouple is dependent on the thickness of the plate
Note	

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		ASME BPVC-Section IX _Article II <> {QW-200.2}					
		QW-Code/s	AWS-D1.1: Structural Welding <> Clause-4 EEMUA-158: Offshore Structures <> Part. 4				
		ISO-9001_QA-Certificate N°	XXXXXXXXXXXXXXXXXXXX				
		QW-Process	XXXX + XXXX (OG-102)				
NoBo - N°	XXXX	Test-Position	2G (on Plate Steel)		NoBo - N°	XXXX	

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**Table-16** WPQR \_ VERIFICATION OF CERTIFICATION and STATEMENTS

Compliance to Pressure Directive	PED 97/23/EC _Pressure Equipment Directive _ In accordance with Annex - I: (3.1.1), (3.1.2), (3.1.3), (3.14), (4.1), & (4.3)							
WPQR - Preparation and Coordinated By				Assisted By Certification Inspector				
Address where WPQR _Test Coupon was welded						Date	xx / xx / 20xx	
WPQR - Welder Name + Id				Qualification Code			Skill Level	
Mechanical Testing _Laboratory Name				Lab-Accreditation N°				
Mechanical Testing Standards				NDE Reports-File N°				
Address				Date	xx / xx / 20xx			
Telephone				FAX				
Email				Website				
Lab-Technician/s Name				Signature				
Lab-Technician/s Accreditation / Qualification								
WPQR_Certification Notified-body				NoBo-N°				
Notified-body Standards				WPQR-Registration No				
Address				Date	xx / xx / 20xx			
Telephone				FAX				
Email				Website				
Certification Inspector Name				Signature				
Inspector Accreditation / Qualification								
WPQR_Supplymentary Approval Notified-body				NoBo-N°				
Notified-body Standards				WPQR-Registration No				
Address				Date	xx / xx / 20xx			
Telephone				FAX				
Email				Website				
Supplymentary Inspector Name				Signature				
Inspector Accreditation / Qualification								

(Lab \_Approval Stamp here)

(NoBo \_Approval Stamp here)

(NoBo \_Approval Stamp here)

**Declaration**

(a) Testing Criterion has assured the requirements according to QW-Codes for \*Welding and Fabrication of Onshore or Offshore, Structural Steel Welding,-- including Tanks, Marine and Pressure Vessels.

(b) We certify by verifications that the statements in this Welding Procedure Qualification Record, are correct and that the tested welds were prepared, welded, and mechanically tested in accordance with the combined requirements of ASME-Section IX <> AWS-D1.1 <> AWS-D1.8 <> EEMUA-158 <> EN ISO 15614-1 <> NACE MR 0175-Part 2 and DNV-OS-C401 respectively.

(c) Details of the recorded tests are accurate, and may only be modified to conform to the type and number of extra tests allowed by the Code, using the spares from the same test coupon, - including addenda, editorial corrections or QW-XX changes. (add owner name here) reserves the rights to grant access for use to any fabricator working for us as we so see fit.

**Table-17** OWNERSHIP and ORGANIZATIONAL RESPONSIBILITY as per ASME IX-2013 ed. GENERAL REQUIREMENT: QG-106

Owner's Name				Welding Engineer				
WPQR Holding Address				Company Name & Address				
Telephone			FAX	Email / Website				
Email			Website	Experience				
Director				Qualification				
Signature	(Digital signature here)		Date	xx / xx / 20xx	Signature	(Digital signature here)	Date	xx / xx / 20xx

Owners Stamp here

Authorization to Use: Authorization by Owner In accordance with [QG-107] & [ASME IX\_2010\_QW-201.1 (c<sup>1-13</sup>)]. Expiry Date: "At owners request"

Fabrication Company Details	Name:						
	Address:						
	ISO_9001-QA-Certificate No:						
	Phone:						
	Fax:						
	Email:						
	Website:						
Terms Accepted by Fabricator							
Director:						Signature:	
QC Manager / Welding Engineer:						Signature:	
Acceptance Date:		xx / xx / 20xx					

Technically Evaluated: On the, xx / xx / 20xx by Welding Specialist Mr/Miss. ....'under the instructions of (owners name here) for authorization for use approval.

**Terms & Conditions**

The Owner reserves the rights to request additional information/s --should it be deemed necessary. The Fabricator (Add 3<sup>rd</sup> Party Name here) is not permitted to make any addendums, plagiarize, Duplicate, combined third party PQR/s with this WPQR or grant access to third party/s. Should these requirements be ignored - all privileges shall be revoked immediately and may result in legal breach of agreement charges. [Note: f-13: << The Quality Control System/Quality Assurance Program shall reflect the source of this PQR >>].