

ISO No	ISO-9001-XXXXXX	Supervision Test Agency Logo	WPO-No	NCP-WPO-W19-R1	Qualified Date	xx/xx/20xx
			WELDER PERFORMANCE QUALIFICATION RECORD (WPO)		Validity Date	Indefinitely
			QW-Code	ASME-IX_Article III (&) AWS-D1.1_Clause 4_Part-C		
			QW Application	Onshore / Offshore - Structural Steel Welding		
Test Agency Accreditation No			QW-Process	GTAW + MCAW	Weld position	2G (CJP)
Welding Certificate/s	ASME-IX, AWS-D1.1, ASME-B31.3 & EN 287-1	Fabrication Certificate	NJC-Part 1 & 2 (Pipe & Plate)		Name & ID	Miss. X. XXXXXXX (W19)
Performance Test WPS No		Performance Test Via POR No			Test Type: Original / Renewal	Original
Test Agency Address		Welding Company Address				



NCPFIRST

Published By: Nilveur Custom-made Procedures (NCP) <<< X-Form: WPOX01 >>> NCP - Publication Ltd © UK_2010 < Contact: <http://ncpfirst.com/> >

Page 1 of 1

Joint Detail	QW-402.1+ AWS-D1.1-Sec 2: Part-B_§ 2.8	TEST COUPON VERIFICATION PICTURE	(QW-184) Macro Test: AWS-D1.1_§4.31.2.3 + ISO 5817
			Acc. Criterion NACE MR 0175-Part 2_§7.3.3.2_Fig. 2
VISUAL EXAMINATION TEST (QW-194) + AWS-D1.1_§4.31.1 + EEMUA-158_§4.4.3a			
ISO 5817-Part-5_Table-1: Weld Evaluation Quality		Level-B	Visual Weld Quality Class 1
(QW-191) Volumetric Radiographic Test: AWS-D1.1: §4.31.3.2 + EEMUA-158_§7.5.4 (100%)			
RS	Ir-192	Exposure	Single
		RT-Report No	RT-WPO-W19-01
		Results	Satisfactory
Groove Angle $x^\circ \pm 5^\circ$		30	Radius R_1
			Fillet Leg (mm): $a = 0.707 \times T_n =$

(QW-250 to 280) MULTI-PROCESS PROCEDURE (QW-200.4 & QW-451.1) «AND» RECORDED **WELDING PARAMETER RANGE** (QW-409)														
Bead No	Process	AWS-Filler Spec	Size mm	Amps	Volts	Travel mm/min	WF inch/min	CS mm	SG L/min	CTWD mm	Heat Input kJ/mm	TG L/min	WMT	CP
1 TO	GTAW	ER70S-3	2.4	xxx-xxx	xxx-xxx	xxx-xxx	xxx-xxx	8	16	5	x.xx-x.xx	No	Dip	DCRP (+)
2 TO n	MCAW	E70C-6M- H4	1.2	xxx-xxx	xxx-xxx	xxx-xxx	xxx-xxx	14	19	7	x.xx-x.xx	No	Full Spray	DCSP (-)
- TO -	SAW	XXXXXXXX		xxx-xxx	xxx-xxx	xxx-xxx	xxx-xxx	xx	NA	x	x.xx-x.xx	NA	Touch	DCSP (-)

(QW-150) QW-151.1-TV_REDUCE SECTION TENSILE TEST: AWS-D1.1: Para. 4.9.3.4 Figure 4.14 + (Figure QW-462.1a) + (EEMUA-158: Para. 4.4.4a)									
Specimen No	Size (mm x mm)	Area (mm²)	UL (KN)	UTS (N/mm²)	Target UTS (N/mm²)	TT. °C	Failure Type & Location	Test Result	
					470 ≥ 630		Out of Weld Ductile	Satisfactory	
					470 ≥ 630				

(QW-160) QW-16.1-TV_GUIDE BEND TEST ACCORDING TO: AWS-D1.1 Clause 4.31.5 (As per 4.9.3.1/3 Figure 4.13)									
Total Specimen Type	Size (mm x mm)	Test Type	BD	MD_4T (mm)	SBR (mm)	QW-462.3 (a)	TT °C	Test Result	
2 Side bends	XX x XX	Transverse	Side			Mandrel = 4T @ 180°		Satisfactory	

WELDING VARIABLES	RECORDED QUALIFICATION DATA	QUALIFICATION RANGE
Welding Apparatus	Manual <> Semi-Automatic	
(AWS-D1.1_§ 3.2.1) Welding Process	GTAW <> MCAW	
(QW-408.2) Shielding Gas	(99.99% Argon) <> (82%Argon, 18% CO₂)	
(QW-404.12) Filler Metal Specification	ER70S-3 <> E70C-6M- H4	
Filler Metal Classification	AWS-A5.18 <> AWS-A5.18	
(AWS-D1.1_§ 4.8.3) Unlisted Base Metal	S355 J2-N <> S355 J-M (Carbon Steel)	
(QW-404.5_Table:442) Base Metal_A-No	1	2 (Visa - Versa)
(QW-433_Table:432) Filler Metal_F-No	6	
(QW-200.4b) Root Backing	Weld-metal	Fusible Insert / Retainer / Backing Plate
(QW-406.8) Weld Deposit Thickness (mm)	GTAW MCAW SAW None	GTAW MCAW SAW None
(QW-403.2) Wall Thickness (mm)	12	
Pipe Diameter_NPS_inch (")	None	None
Groove Type	Single Side_V	
Welding Axis / Position	2G_Horizontal Vertical (HV)	
(QW-410.6) Back Gouging Method	Arc Air Gouging	
Metal Surface: Bare metal / HDG	Bare Metal	Bare Metal
Acceptance Criterion	AWS-D1.1 Table 6.1 + (4.9.1.1/2) Inspection of CJP + Fillet Welds & (EN ISO 5817-Part B) Heat Input: → kJ/mm = (Amps x Volts x 60) ÷ TS (where: TS = Travel Speed x 1000)	

Acronym | CTWD = Contact-To-Work-Distance, TP = Travel Speed, SG = Shielding Gas, WMT = Metal Transfer, TG = Trailing Gas, CS = Cup Size, WF = Wire Feed, CP = Current & Polarity, VT = Visual Test
 RS = Radiation Source, MD = Mandrel Diameter, SBR = Space Between Rollers, TT = Test Temperature, TV = Transverse, LT = Lateral, BD = Bend Direction, UTS = Ultimate Tensile Stress, UL = Ultimate Load

Declaration	We certify by verification that the statements in this Welder Performance Qualification (WPO) 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, and in the presence of the authorised Supervision Agency duly signed herein.					
Renewal Test Dates	Maintained (By QC Manager)	Renewal Test (Witnessed By)	Welding Company (QA/QC-Stamp)	Original Test (Supervision Personal)	3rd Party Approval Stamp	Renewal Test (Supervision Personal)
xx/xx/20xx					NoBo XXXXX_XXX	
xx/xx/20xx						
xx/xx/20xx						
xx/xx/20xx						
xx/xx/20xx						Apply If requested by PO