

WELDER PERFORMANCE QUALIFICATION (WPQ)

Control Inc. - Petro Plants LLC



Designation

**ASME IX:2019 GTAW/SMAW P-No.1 to P-No.1 G F#6/4 T 14.02 DN 65 t
3/11.02 6G/6G**

Name	REX SHEPHERD	WPQ Record #	IX-RS1-01-Rev-0	
Welder ID	RS 1	Qualified to	ASME IX:2019	
Stamp Number		WPS Number	WPS-SAMPLE-01-Rev-0	
Employer	Control Inc.	Job Knowledge	Not tested	
Test Date	1-Nov-2021	Test/Production	Test	

Base Metals (QW-403)									
Base Metals	Form	Specification, Alloy	P #	Gr. #	UNS #	NPS/DN, mm	Dia, mm	Sch.	Thickness, mm
Steel & steel alloy	Pipe	A/SA-106 B	1	1	K03006	65	73.02	XXS	14.02
Steel & steel alloy	Pipe	A/SA-106 B	1	1	K03006	65	73.02	XXS	14.02

Joint Details (QW-350)		
Welding Variables	Actual Values	Range Qualified
Joint Type	Pipe - Pipe - Groove	Groove and Fillet welds
Branch Connection	No	
Base metals P-No. to P-No.	P-No.1 to P-No.1	P-No. 1 thru 15F, 34, 41 thru 49
Diameter, mm	73.02	25 - unlimited (groove); No limit (fillet)
Thickness, mm	14.02	





Variables	Actual Values		Range Qualified	
	GTAW	SMAW	GTAW	SMAW
Welding Process	GTAW	SMAW	GTAW	SMAW
Type	Manual	Manual	Manual	Manual
Backing (Metal, Weld Metal)	Without	With	With or Without	With
Spec. No. (SFA)	SFA-5.18	SFA-5.1		
AWS No. (Class)	ER70S-3	E7018		
Filler Metal F-Number	6	4	6	1 - 4
Filler Metal A-Number	1	1		
Consumable Insert	NA	NA	NA	NA
Filler Metal Product Form	Solid	Flux coated	Solid or metal cored	Flux coated (solid or metal cored)
Weld Deposit Thickness, mm	3	11.02	6	22.04
Number of Layers Deposited	2	5		
Type of Fuel Gas				
Gas Backing	Without	Without	With or Without	With or Without
Transfer Mode				
Current, Polarity	DCEN	DCEP	DCEN	DCEP
Position	6G Up	6G Up		
Groove - Plate			All	All
Groove - Pipe > 610 mm O.D.			All	All
Groove - Pipe 73 - 610 mm O.D.			All	All
Groove - Pipe < 73 mm O.D.			All	All
Fillet - Plate			All	All
Fillet - Pipe > 610 mm O.D.			All	All
Fillet - Pipe 73 - 610 mm O.D.			All	All
Fillet - Pipe < 73 mm O.D.			All	All

Test Methods	Test Result	Test Report
Visual Examination per QW-302.4	Performed and Acceptable	
2 face bend test - ref. QW-161.2	Performed and Acceptable	
2 root bend test - ref. QW-161.3	Performed and Acceptable	
4 side bend tests - ref. QW-161.1	Not tested	
Radiographic examination Cl. QW-302.2	Performed and Acceptable	Sample NDE Report (With Watermark).pdf
Ultrasonic examination Cl. QW-302.2	Not tested	

Date Welded	1-Nov-2021	Specification	CLI-SPE-01
Requalification?	No	Test Location	Mt. Gravatt TAFE
Place of Testing	Brisbane	Weather	Fine
Date Issued	8-Nov-2021	Ambient Temperature	26 °C

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Assessor Notes	Comments
All good. Please approve.	Approved
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 BOILER AND PRESSURE VESSEL CODE 2019 edition.	
 <p>Digital signature Examined by - Rob Hymie Examined on - 8-Nov-2021 Control Inc.</p>	<div style="text-align: center;">★ SIGNATURE ★ SIGNATURE ★</div>  <div style="text-align: center;">★ SIGNATURE ★ SIGNATURE ★</div>
 <p>Digital signature Approved by - Max Smart Approved on - 8-Nov-2021 Control Inc.</p>	<div style="text-align: center;">★ SIGNATURE ★ SIGNATURE ★</div>  <div style="text-align: center;">★ SIGNATURE ★ SIGNATURE ★</div>

TEST REPORTS



REPORT NO: 44111477-02

DATE: 08.11.2011

PAGE NO: 1 of 4

CLIENT:

SAMPLE SAMPLE
SAMPLE SAMPLE
SAMPLE SAMPLE
SAMPLE SAMPLE
SAMPLE SAMPLE

CONTACT:

SUBJECT: The Magnetic Particle Examination of nominated welds on Fuel Gas Pipe Work. The examination was carried out at Kenya Water Treatment Plant.

IDENTIFICATION: Request No's: LO-MT003 & LO-MT004

ORDER NO: SL83/ SAMPLE

EXAMINATION DATE: 02 & 03.11.2011

TECHNICIAN: S. Stevens

TECHNICAL DATA

Test Specification: AS 1171-1998
 Test Procedure: MT.001
 Current Type: AC
 Technique: Magnetic flow - sustained magnetisation
 Surface Condition/Coatings & Preparation: As welded
 Material Specification: Carbon Steel – Not Further Specified
 Acceptance Standard: AS 4037-1999, Table 8.4, Class 1
 Demagnetised: No
 Test Restrictions: Nil



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RESULTS OF EXAMINATION

IDENTIFICATION

INTERPRETATION

Magnetic Particle Examination of nominated welds on Fuel Gas Pipe Work

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REQUEST No. LO-MT003

Activity No: MT 001

Size: 40mm NS
Weld No: 3525

The weld complies with the acceptance standard

Activity No: MT 002

Size: 40mm NS
Weld No: 3526

The weld complies with the acceptance standard

Activity No: MT 003

Size: 40mm NS
Weld No: 3493

The weld complies with the acceptance standard

Activity No: MT 004

Size: 40mm NS
Weld No: 3494

The weld complies with the acceptance standard

Activity No: MT 005

Size: 40mm NS
Weld No: 3509

The weld complies with the acceptance standard

Activity No: MT 006

Size: 40mm NS
Weld No: 3510

The weld complies with the acceptance standard