Welder Performance Qualification

WPQ GMAW-CF8MnMn MOD-TS **Rev** 0

Welder Name Terry Stanfield **Clock Nbr** 20027 **Stamp Nbr** 10

Welding Process Used GMAW **Type** Semi Automatic

WPS Followed 15-GMAW-CF8MnMn MOD

Base Material CF8MnMn MOD 18%Cr13%Ni2.8%Mn2.2%Mo **Thickness** 1.5"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.5" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	Metrode ER316MnnF	Metrode ER316MnnF
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.5"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Forehand	Forehand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	Spray	Spray
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A
Automatic Voltage Control	N/A	N/A
Automatic Joint Tracking	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Welding Position Machine	N/A	N/A
Consumable Insert	N/A	N/A
Backing Machine	N/A	N/A

Guided Bend Test Results

Guided Bend Tests Type Side

Sample No	Result	Comments
1129-1	Acceptable	No Discontinuities
1129-3	Acceptable	No Discontinuities
1129-4	Acceptable	No Discontinuities
1129-6	Acceptable	No Discontinuities

Visual Examination Results Acceptable

Radiographic Test Results N/A

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By St. Louis Testing Laboratories **Laboratory Test No** 04P-1129

Comments **Organization** MetalTek International Carondelet Division

1 Do to the nature of casting excavations the above welder is allowed to perform full penetration welds as well as partial penetration welds using the same Performance Qualification Record.

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 Code.

By _____ **Date** 4/20/2004

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ SMAW-CF8MnMn MOD-TS-3G **Rev** 0

Welder Name Terry Stanfield **Clock Nbr** 20027 **Stamp Nbr** 10

Welding Process Used SMAW **Type** Manual

WPS Followed 25-SMAW-CF8MnMn MOD

Base Material CF8MnMn MOD **Thickness** 1.0"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.0" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	B316NF	B316NF
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.0"	0.0" to Max Welded
Welding Position	3G	1G,3G & 1F,2F,3F
Progression	Vertical	Vertical
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	N/A	N/A
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified	Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A	Welding Position Machine	N/A	N/A
Automatic Voltage Control	N/A	N/A	Consumable Insert	N/A	N/A
Automatic Joint Tracking	N/A	N/A	Backing Machine	N/A	N/A

Guided Bend Test Results

Guided Bend Tests Type Side

Sample No	Result	Comments
TS-1	Acceptable	No Discontinuities
TS-3	Acceptable	No Discontinuities
TS-4	Acceptable	No Discontinuities
TS-6	Acceptable	No Discontinuities

Visual Examination Results Acceptable

Radiographic Test Results N/A

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By St. Louis Testing Laboratories **Laboratory Test No** 05P-0554

Comments **Organization** MetalTek International Carondelet Division

Do to the nature of casting excavations the above welder is allowed to perform full penetration welds as well as partial penetration welds using the same Performance Qualification Record.

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 Code.

By _____ **Date** 2/28/2005

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ GMAW-CF8MnMn MOD-WP **Rev** 0

Welder Name Wyatt Piediscalzi **Clock Nbr** 20437 **Stamp Nbr** 25

Welding Process Used GMAW **Type** Semi Automatic

WPS Followed 15-GMAW-CF8MnMn MOD

Base Material CF8MnMn MOD 18%Cr13%Ni2.8%Mn2.2%Mo **Thickness** 1.0"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.0" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	Lincoln LNM 4455	Lincoln LNM 4455
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.0"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Forehand	Forehand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	Spray	Spray
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A
Automatic Voltage Control	N/A	N/A
Automatic Joint Tracking	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Welding Position Machine	N/A	N/A
Consumable Insert	N/A	N/A
Backing Machine	N/A	N/A

Guided Bend Test Results

Sample No	Result	Comments

Guided Bend Tests Type N/A

Visual Examination Results Acceptable

Radiographic Test Results Acceptable

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By MetalTek Int **Laboratory Test No** Wyatt Piediscalzi 2-25-05

Comments **Organization** MetalTek International Carondelet Division

1 Do to the nature of casting excavations the above welder is allowed to perform full penetration welds as well as partial penetration welds using the same Performance Qualification Record.

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By _____ **Date** 2/25/2005

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ SMAW-CF8MnMn MOD-RR **Rev** 0

Welder Name Romulo Rubio **Clock Nbr** 19655 **Stamp Nbr** 5

Welding Process Used SMAW **Type** Manuel

WPS Followed 10-SMAW-CF8MnMn MOD

Base Material CF8MnMn MOD **Thickness** 1.0"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.0" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	B316NF	B316NF
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.0"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Backhand	Backhand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	N/A	N/A
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A
Automatic Voltage Control	N/A	N/A
Automatic Joint Tracking	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Welding Position Machine	N/A	N/A
Consumable Insert	N/A	N/A
Backing Machine	N/A	N/A

Guided Bend Test Results

Guided Bend Tests Type N/A

Sample No	Result	Comments

Visual Examination Results Acceptable

Radiographic Test Results Acceptable

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By MetalTek Int **Laboratory Test No** Romulo Rubio

Comments **Organization** MetalTek International Carondelet Division

Do to the nature of casting excavations the above welder is allowed to perform full penetration welds as well as partial penetration welds using the same Performance Qualification Record.

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By _____ **Date** 4/8/2004

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ GMAW-CF8MnMn MOD-TD **Rev** 0

Welder Name Timothy Duncan **Clock Nbr** 20492 **Stamp Nbr** 30

Welding Process Used GMAW **Type** Semi Automatic

WPS Followed 15-GMAW-CF8MnMn MOD

Base Material CF8MnMn MOD 18%Cr13%Ni2.8%Mn2.2%Mo **Thickness** 1.5"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.5" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	LNM 4455	LNM 4455
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.5"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Forehand	Forehand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	Spray	Spray
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified	Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A	**Welding Position Machine**	N/A	N/A
Automatic Voltage Control	N/A	N/A	**Consumable Insert**	N/A	N/A
Automatic Joint Tracking	N/A	N/A	**Backing Machine**	N/A	N/A

Guided Bend Test Results

Sample No	Result	Comments	Guided Bend Tests Type	N/A

Visual Examination Results Acceptable

Radiographic Test Results Acceptable

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By MetalTek Int **Laboratory Test No** Timothy Duncan 7/5/05

Comments **Organization** MetalTek International Carondelet Division

1 Do to the nature of casting excavations the above welder is allowed to perform full penetration welds as well as partial penetration welds using the same Performance Qualification Record.

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By _____ **Date** 7/5/2005

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ GMAW-CF8MnMn MOD-BD **Rev** 0

Welder Name Brad DeRousse **Clock Nbr** 20116 **Stamp Nbr** 2

Welding Process Used GMAW **Type** Semi Automatic

WPS Followed 15-GMAW-CF8MnMn MOD

Base Material CF8MnMn MOD 18%Cr13%Ni2.8%Mn2.2%Mo **Thickness** 1.0"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.0" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	Metrode ER316MnnF	Metrode ER316MnnF
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.0"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Forehand	Forehand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	Spray	Spray
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified	Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A	**Welding Position Machine**	N/A	N/A
Automatic Voltage Control	N/A	N/A	**Consumable Insert**	N/A	N/A
Automatic Joint Tracking	N/A	N/A	**Backing Machine**	N/A	N/A

Guided Bend Test Results

Sample No	Result	Comments

Guided Bend Tests Type N/A

Visual Examination Results Acceptable

Radiographic Test Results Acceptable

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By MetalTek Int **Laboratory Test No** Brad Derousse 6/20/2005

Organization MetalTek International Carondelet Division

Comments

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By _____ **Date** 6/20/2005

Ricardo M. Suria AWS-CWI #93041371

Welder Performance Qualification

WPQ GMAW-CF8MnMn MOD-JC **Rev** 0

Welder Name Jathon Cruse **Clock Nbr** 20431 **Stamp Nbr** 24

Welding Process Used GMAW **Type** Semi Automatic

WPS Followed 15-GMAW-CF8MnMn MOD

Base Material CF8MnMn MOD 18%Cr13%Ni2.8%Mn2.2%Mo **Thickness** 1.5"

Manual or Semiautomatic Variables used	Actual Values	Range Qualified
Backing Metal	Non-fusing/Back Welded	Non-fusing/Back Welded
ASME P-No to P-No	Unassigned	Same Unassigned
Plate Pipe	1.5" Plate	3/16" to Max Welded
Filler Metal SFA	Unassigned	Same Unassigned
Filler Metal Classification	Metrode ER316MnnF	Metrode ER316MnnF
Filler Metal F-No	Unassigned	Unassigned
Filler Metal for GTAW	N/A	N/A
Weld Deposit Thickness	1.5"	0.0" to Max Welded
Welding Position	1G	1G & 1F
Progression	Forehand	Forehand
Backing Gas for GTAW	N/A	N/A
GMAW Transfer Mode	Spray	Spray
GTAW Welding Current Type Polarity	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Direct Remote Visual Control	N/A	N/A
Automatic Voltage Control	N/A	N/A
Automatic Joint Tracking	N/A	N/A

Machine Welding Variables used	Actual Values	Range Qualified
Welding Position Machine	N/A	N/A
Consumable Insert	N/A	N/A
Backing Machine	N/A	N/A

Guided Bend Test Results

Guided Bend Tests Type N/A

Sample No	Result	Comments

Visual Examination Results Acceptable

Radiographic Test Results Acceptable

Fillet Weld Fracture Test N/A **Length and Percent of Defects** N/A

Macro Test Fusion N/A **Fillet Leg Size** N/A **Concavity / Convexity** N/A

Welding Test Conducted By Ricardo M. Suria

Mechanical Tests Conducted By MetalTek Int **Laboratory Test No** Jathon Cruse 4/19/04

Comments **Organization** MetalTek International Carondelet Division

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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 Code.

By _____ **Date** 4/19/2004

Ricardo M. Suria AWS-CWI #93041371