



Major Tool and Machine, Inc.
 1458 E. 19th Street, Indianapolis, Indiana, 46218
Welder Performance Qualification (WPQ)
 WeldOffice WPQ

Welder's name	McNew, Derek		Test date	06/14/96
ID Number	358		WPQ record number	McNew 003
Date of birth			Standard test number	Rev.
Stamp number			WPS record number	WPS003 Rev.
Company name	Major Tool and Machine, Inc.		Qualification code	ASME Section IX
Division				

BASE METALS (QW-403)

	Product form	Specification (type or grade)	P no.	Grp-no.	Size	Sch.	Thick. (in.)	Dia. (in.)
Welded to:	Plate	SB-435 (UNS N06230)	43	-	-	-	1.25	-
	Plate	SB-435 (UNS N06230)	43	-	-	-	1.25	-
Joint type	Groove							

VARIABLES

Type of weld joint	Plate - Groove	RANGE QUALIFIED
Base metal	P43 to P43	Groove and Fillet welds P-no./S-no. 1 thru 11, 34, 41 thru 47

BASE METAL THICKNESS

		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)		1.25	-	-	no limit	no limit	-
Pipe/tube thickness (in.)		-	-	-	no limit	no limit	-
Pipe diameter (in.)		-	-	-	2.875 min	no limit	-

PROCESS VARIABLES

	Actual values		RANGE QUALIFIED	
	GTAW	GMAW	GTAW	GMAW
Welding process	GTAW	GMAW	GTAW	GMAW
Type	Manual	Semi-automatic	Manual	Semi-automatic
Backing	With	With	With	With
Filler metal specification	5.14	5.14	5xx	5xx
Filler metal classification	ERNiCrCoMo-1	ERNiCrCoMo-1	Any	Any
Filler metal F-number	43	43	34,41..45	34,41..45
Filler metal variety (QW-404.23)	Bare (solid)	-	Solid, metal cored	-
Consumable insert	None	-	Without	-
Number of layers deposited	12	6		
Weld deposit thickness (in.)	.625	.625	1.25 max	1.25 max
Weld position (Actual position tested)	3G	1G		
Groove - Plate & Pipe >24"			F,V	F
Groove - Pipe 2.875" to 24"			F	F
Groove - Pipe < 2.875"			-	-
Fillet - Plate & Pipe >24"			F,H,V	F
Fillet - Pipe 2.875" to 24"			F,H,V	F
Fillet - Pipe < 2.875"			F,H,V	F
Progression	Vertical up	-	Vertical up	-
Backing gas	With	Without	With	With, without
GMAW transfer mode (QW-409)	-	-	-	Spray, pulse, globular
GTAW welding current/polarity	DCEN (straight polarity)	-	DCEN (straight polarity)	-

TESTS

Type of test	Acceptance criteria	Result	Comments
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 Note (8)
Radiographic examination per QW-191 and QW-302.2	QW-191.2	Acceptable	see - ASME IX - QW-142, QW-304

Notes

CERTIFICATION

Tests conducted by	INDUSTRIAL NDT	Laboratory test number	74837
Mechanical tests by		Test file number	

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Signature

Name	Signature
David Leapley	
Date	
8/19/2002	



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WPQ - Additional Information
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NOTES:

- 1) Base Metal P-No. Changed for Haynes 230 (UNS N06230) from P47 to P43 Per JUL 1, 2004 ASME IX. - 10/11/05 J.L.M.