



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

Welder's name	Stone, James		Test date	8/22/03
ID Number	733		WPQ record number	Stone 380
Date of birth			Standard test number	Rev.
Stamp number			WPS record number	WPS380 Rev. 0
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-443 (1)	43		-	-	0.375	-
	Plate	SB-443 (1)	43		-	-	0.375	-
Joint type	Groove							

**VARIABLES**

	Actual values	RANGE QUALIFIED
Type of weld joint	Plate - Groove	Groove and Fillet welds
Base metal	P43 to P43	All base metals

**BASE METAL THICKNESS**

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	0.375	-	-	no limit	no limit	-
Pipe/tube thickness (in.)	-	-	-	no limit	no limit	-
Pipe diameter (in.)	-	-	-	no limit	no limit	-

**PROCESS VARIABLES**

	Actual values	RANGE QUALIFIED
Welding process	PAW	PAW
Type	Machine	Machine, Automatic
Backing	None	With, without
Consumable insert	None	Without
Weld position	1G	
Groove - Plate & Pipe >24"		F
Groove - Pipe 2.875" to 24"		F
Groove - Pipe < 2.875"		F
Fillet - Plate & Pipe >24"		F
Fillet - Pipe 2.875" to 24"		F
Fillet - Pipe < 2.875"		F
Direct/remote visual control	Direct & remote	Direct & remote
Automatic joint tracking	Without	With, without
Single or multiple pass per side	Multiple	Single, multiple

**TESTS**

Type of test	Acceptance criteria	Result	Comments
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 (a) Note (2)
Radiographic examination per QW-191 and QW-302.2	QW-191.2	Acceptable	see - ASME IX - QW-142, QW-304
2 transverse face bends per QW-161.2 and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-451.1
2 transverse root bends per QW-161.3 and QW-462.3(a)	QW-163	Acceptable	see - ASME IX - QW-451.1
2 reduced section tension tests per QW-151.1 and QW-462.1(a)	QW-153	Acceptable	see - ASME IX - QW-451.1

Notes	This test plate was welded and tested to ASME Sect. IX and AWS B2.1 requirements as PQR380.
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**CERTIFICATION**

Tests conducted by	MQS Inspections (radiography)	Laboratory test number	371-F0004 (MQS Inspections)
Mechanical tests by	Sherry Laboratories	Test file number	2003080919 (Sherry Labs)

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	
10/8/03	