



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	7/8/02
ID Number	358	WPQ record number	McNew 004 GTAW/FCAW 2G
Date of birth		Standard test number	Rev.
Stamp number		WPS record number	WPS004 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	SA-36 (UNS K02600)	1	1	-	-	1.0	-
	Plate	SA-36 (UNS K02600)	1	1	-	-	1.0	-
Joint type	Groove							

VARIABLES

Type of weld joint	Plate - Groove	RANGE QUALIFIED
Base metal	P1 to P1	Groove and Fillet welds P-no./S-no. 1 thru 11, 34, 4X

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	1.0	-	-	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	FCAW		GTAW	FCAW	
Welding process	GTAW	FCAW		GTAW	FCAW	
Type	Manual	Semi-automatic		Manual	Semi-automatic	
Backing	None	With		With, without	With	
Filler metal specification	5.18	5.20		5xx	5xx	
Filler metal classification	ER70S-2	E71T-1		Any	Any	
Filler metal F-number	6	6		6	6	
Filler metal variety (QW-404.23)	Bare (solid)	-		Solid, metal cored	-	
Consumable insert	None	-		Without	-	
Number of layers deposited	3 min.	3 min.				
Weld deposit thickness (in.)	.5	.5		no limit	no limit	
Weld position (Actual position tested)	2G	2G				
Groove - Plate & Pipe >24"				F,H	F,H	
Groove - Pipe 2.875" to 24"				F,H	F,H	
Groove - Pipe < 2.875"				-	-	
Fillet - Plate & Pipe >24"				F,H	F,H	
Fillet - Pipe 2.875" to 24"				F,H	F,H	
Fillet - Pipe < 2.875"				F,H	F,H	
Progression	-	-		-	-	
Backing gas	Without	Without		With, without	With, without	
GMAW transfer mode (QW-409)	-	Globular		-	Spray, pulse, globular	
GTAW welding current/polarity	DCSP	-		DCSP	-	

TESTS

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

Notes

CERTIFICATION

Tests conducted by	MQS INSPECTION	Laboratory test number	71F-W01285
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	Name	Signature
David Leapley			
Date		Date	
7/9/2002			

Signature 3

Name	Signature	Name	Signature
Date		Date	

Signature 4