Major Tool and Machine, Inc.

1458 E. 19th Street, Indianapolis, Indiana, 46218

Welder Performance Qualification (WPQ)

WeldOffice WPQ

Welder's name	Fischer, Tim		Test date	12/01/95	
ID Number	197		WPQ record number	Fischer 113	
Date of birth			Standard test number		Rev.
Stamp number			WPS record number	WPS113	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.)
	Plate	Inconel 617 (UNS N06617)	43		-	-	.31	-
Welded to:	Plate	Inconel 617 (UNS N06617)	43		-	-	.31	-

Joint type	Groove

VARIABLES

	Actual values	RANGE QUALIFIED
Type of weld joint	Plate - Groove	Groove and Fillet welds
Base metal	P43 to P43	P-no./S-no. 1 thru 11, 34, 4X

BASE METAL THICKNESS

		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness	(in.)	.31	-	-	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
Welding process		GMAW	GMAW
Type		Semi-automatic	Semi-automatic
Backing		With	With
Filler metal specification		5.14	5.xx
Filler metal classification		ERNiCrCoMo-1	Any
Filler metal F-number		43	34,41..45
Number of layers deposited			
Weld deposit thickness	(in.)	.31	0.62 max
Weld position	(Actual position tested)	1G	
	Groove - Plate & Pipe >24"		F
	Groove - Pipe 2.875" to 24"		F
	Groove - Pipe < 2.875"		-
	Fillet - Plate & Pipe >24"		F
	Fillet - Pipe 2.875" to 24"		F
	Fillet - Pipe < 2.875"		F
Progression		N/A	N/A
Backing gas		Without	With, without
GMAW transfer mode (QW-409)		Pulsed Spray	Spray, pulse, globular

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

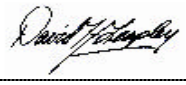
Notes	

CERTIFICATION

Tests conducted by	INDUSTRIAL NDT	Laboratory test number	69983
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	
8/6/2002	