



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

Welder's name	Stupples, Greg	Test date	7/18/94
ID Number	233	WPQ record number	Stupples 115
Date of birth		Standard test number	Rev.
Stamp number		WPS record number	WPS115 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	Inconel 617	43		-	-	.305	-
	Plate	Inconel 617	43		-	-	.305	-
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.)	.305	-	-	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	GTAW	GTAW
Type	Manual	Manual
Backing	None	With, without
Filler metal specification	5.14	5.xx
Filler metal classification	ERNiCrCoMo-1	Any
Filler metal F-number	43	34,41..45
Filler metal variety (QW-404.23)	Bare (solid)	Solid, metal cored
Consumable insert	None	Without
Number of layers deposited		
Weld deposit thickness (in.)	.315	0.63 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	-	-
Backing gas	Without	With, without
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	INDUSTRIAL NDT	Laboratory test number	74949
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	
10/11/2002			

Signature 3

Name	Signature	Name	Signature
Date		Date	

Signature 4