



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	07/18/00
ID Number	358	WPQ record number	McNew 004 GTAW/FCAW 3G
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	-	-	1.5	-
	Plate	SA-36 (UNS K02600)	1	1	-	-	1.5	-
Joint type	Groove							

VARIABLES

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

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	1.5	-	-	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	With	With	With	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)	-	-	Solid, metal cored	-
Consumable insert	None	-	Without	-
Number of layers deposited	3 min.	3 min.	-	-
Weld deposit thickness (in.)	.75	.75	no limit	no limit
Weld position (Actual position tested)	3G	3G	-	-
Groove - Plate & Pipe >24"	-	-	F,V	F,V
Groove - Pipe 2.875" to 24"	-	-	F	F
Groove - Pipe < 2.875"	-	-	-	-
Fillet - Plate & Pipe >24"	-	-	F,H,V	F,H,V
Fillet - Pipe 2.875" to 24"	-	-	F,H,V	F,H,V
Fillet - Pipe < 2.875"	-	-	F,H,V	F,H,V
Progression	Vertical up	Vertical up	Vertical up	Vertical up
Backing gas	Without	Without	With, without	With, without
GMAW transfer mode (QW-409)	-	Globular	-	Spray, pulse, globular
GTAW welding current/polarity	DCEN (straight polarity)	-	DCEN	-

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: Number of layers deposited is a minimum, not an actual. * Note added 7/8/02

CERTIFICATION

Tests conducted by	U.S. Inspections	Laboratory test number	IN-L1862
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
Michael G. Iverson	
Date	
7/8/02	