



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

Welder's name	Roberts, Scott	Test date	6/16/2006
ID Number	509	WPQ record number	Roberts, S. 435 Pipe
Date of birth		Standard test number	Rev.
Stamp number		WPS record number	WPS435 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:	Pipe	SA-106 (B)	1	1	n/a	n/a	0.625	2.75
	Pipe	SA-106 (B)	1	1	n/a	n/a	0.625	2.75
Joint type	Groove							

VARIABLES

	Actual values	RANGE QUALIFIED
Type of weld joint	Pipe - Groove	Groove and Fillet welds
Base metal	P1 to P1	P-no./S-no. 1 thru 11, 34, 41 thru 49

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	-	-	-	no limit	no limit	-
Pipe/tube thickness (in.)	0.625	-	-	no limit	no limit	-
Pipe diameter (in.)	2.75	-	-	1.0 min	no limit	-

PROCESS VARIABLES

	Actual values	RANGE QUALIFIED
Welding process	GTAW	GTAW
Type	Manual	Manual
Backing	Without	With, without
Filler metal specification	5.14	5.xx
Filler metal classification	ERNiCrCoMo-1	Any
Filler metal F-number	43	34,41..46
Filler metal variety (QW-404.23)	Bare (solid)	Solid, metal cored
Consumable insert	None	Without
Number of layers deposited	3 min	
Weld deposit thickness (in.)	0.625	no limit
Weld position (Actual position tested)	6G	
Groove - Plate & Pipe >24"		All
Groove - Pipe 2.875" to 24"		All
Groove - Pipe < 2.875"		All
Fillet - Plate & Pipe >24"		All
Fillet - Pipe 2.875" to 24"		All
Fillet - Pipe < 2.875"		All
Progression	Up and down	Up and down
Backing gas	With	With
GTAW welding current/polarity	DCEN	DCEN

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-142/3, QW-304/5
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 (a)

Notes

CERTIFICATION

Tests conducted by	MQS Inspections	Laboratory test number	13860001
Mechanical tests by	N/A	Test file number	N/A

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 the Code.

Signature

Name	Signature
David Leapley	
Date	
6/19/2006	