JDH INSPECTION SERVICES 6 Progress Avenue Nashua New Hampshire 03062 Phone: (603) 402-3656

# WELDER/WELDING OPERATOR PERFORMANCE QUALIFICATIONS (WPQ)

**Welder's Name:** Dominic D'Orazio **Clock No.:** N/A **Stamp No.:** DD

**Welding Process(es) Used:** SMAW **Type:** Manual

**Identification of WPS followed by Welder During Welding Test** AW-SM-P1-CVN1

**Base Material(s) Welded:** Carbon Steel **Thickness:** 0.625"

| Manual of Seniautomatic Variables for Each Process (QW-350) | Actual Values | Range Qualified |
|---|---|---|
| Backing (metal, weld metal, welded from both sides, flux. Etc.) (QW-402) | E6010 without / E7018 With | With or Without / With |
| ASME P-No. (QW-403) 1 to ASME P-No. (QW-403) 1 | P1 | SAME |
| Plate X Pipe (enter diameter, if pipe) | 2" Dia. | 1" - Unlimited |
| Filler Metal Specification (SFA) 5.1 / 5.5 Classification (QW-404) | 5.1 & 5.5 | Same |
| Filler Metal F-No. | 3 & 4 | Same |
| Consumable insert for GTAW or PAW | N/A | N/A |
| Weld Deposit Thickness for Each Welding Process | 0.125 / 0.219+ | 0.109" - 1.25" |
| Welding Position (1G, 5G, etc.) (QW-405) | 6G | All |
| Progression (uphill/downhill) | Uphill | Uphill |
| Backing Gas for GTAW, PAW, or GMAW; Fuel Gas for OFW (QW-408) | N/A | N/A |
| GMAW Transfer Mode (QW-409) | N/A | N/A |
| GTAW Welding Current Type/Polarity | N/A | N/A |

| Machine Welding Variables for the Process Used (QW-360) | Actual Values | Range Qualified |
|---|---|---|
| Direct/Remote Visual Control | N/A | N/A |
| Automatic Voltage Control (GTAW) | N/A | N/A |
| Automatic Joint Tracking | N/A | N/A |
| Welding Position (1G, 5G, etc.) | N/A | N/A |
| Consumable Insert | N/A | N/A |
| Backing (metal, weld metal, welded from both sides, flux, etc.) | N/A | N/A |

## Guided Bend Test Results

| Guided Bend Tests Type | QW-462.2 (side) Results | QW-462.3(a) (Trans. R&F) Type | Guided Bend Tests Type |
|---|---|---|---|
| N/A | N/A | N/A | N/A |
| | | | |
| | | | |

**Visual Examination Results** Satisfactory

**Radiographic Test Results (QW-304 )** Acceptable Sean Elliott

**(For alternative qualification of groove welds by radiography)**

**Fillet Weld - Fracture Test** N/A **Length (in.) and Percent of Defects** N/A

**Macro Test Fusion** N/A **Fillet Leg Size** N/A **Concavity/Convexity (in.)** N/A

**Welding Conducted By** Dominic D'Orazio of Anderson Welding

**Mechanical Tests Conducted By** N/A **Laboratory Test No.** 22-1129 LT22-12-012

**We certify that the statements in this record are corrected and that the test coupons were prpared, welded and tested in accordance with the requirements of Section IX of the ASME Code.**

**Organization:** Anderson Welding

**Date:** December 19, 2022 **Accepted By:**