

Creating a WPQ

Welder Performance Qualification

- 1 On the Tool Bar, click on the small drop-down arrow next to the "New" icon. Select **ASME IX WPQ**.
- 2 Begin filling out the record by entering the Welder's information. While filling out this record, make sure to take advantage of the drop-down menus and databases rather than typing the information manually.
- 3 Do not enter "Range Qualified" data manually. The Code Checking in WeldOffice® will take care of all of these fields for you. All you need to enter is the "Actual Values" of the welder qualification test and the Code Checking will fill in the qualified ranges based on the Actual Values that you enter.
- 4 As you select a welding process, the form will grow supplying you with the required fields specific to the process selected. Notice that WeldOffice® allows the use of up to three separate processes on a single WPQ.
- 5 When specifying the filler metal, remember to select it from the Filler Material Database instead of manually typing the information. To do this, place the cursor in the "Filler metal specification" field and click on the database icon. Locate the desired filler metal and double-click on it. Notice that WeldOffice® enters the proper Spec.#, Class.# and F# automatically.
- 6 Testing information is already entered for you. Based on the information previously entered, WeldOffice®'s Code Checking automatically specifies the required testing.
- 7 Printing this WPQ:
To print this record, go to the top of the screen and click on **File**. Select the second print option which will say something like:
Print Unassigned ASME WPQ 00001.
- 8 Instantly create a WPQ from another WPQ:
One of the best time-saving features in WeldOffice® is the ability to create duplicates of a completed WPQ. To do this, go to the top of the screen and click on **File / Save As New**. Then select **WPQ**. WeldOffice® will then create a duplicate of this current record. This feature allows incredible speed of data entry when entering identical WPQ's.

EN287 WPQ
ASME IX WPQ
AWS D1.1 WPQ

C-spec
P.O. Box 27604, Concord, CA 94527, (888) 673-9777
ASME Section IX Welder Performance Qualification (WPQ)
C-spec WeldOffice® Software

Welder's name: _____
ID Number: _____
Date of birth: _____
Sleep number: _____
Company name: _____
Division: _____

Welder's picture: _____
Test date: 2/5/01
WPQ record number: _____
Standard test no: _____
WPS record number: _____
Qualification code: ASME Section IX

BASE METALS

Product form	Specification (type or grade)	F-no	Grp-no	Size	Sch	Thick. (in)	Dia. (in)
Pipe	SA-106(B)	1	1	6	XX	0.864	6.625
Welded to:	Pipe SA-106(B)	1	1	6	XX	0.864	6.625

Weld type: Groove Fillet Overlay Stud welding

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, 40

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in)	-	-	-	no limit	no limit	-
Pipe/tube thickness (in)	0.864	-	-	no limit	no limit	-
Pipe diameter (in)	6.625	-	-	2.875 min	no limit	-

PROCESS VARIABLES

	SMW	FCW	SHAW	FCW
Welding process	SMW	FCW	SHAW	FCW
Type	Manual	Semi-automatic	Manual	Semi-automatic
Backing	Without	With	With, without	With
Filler metal specification	E 51	E 20	E 5x	E 30x
Filler metal classification	E 6010	E 711-12M	Ary	Amp
Filler metal F-number	3	6	3(1, 3 w/backing)	6
Number of layers deposited	2	3 min		
Field deposit thickness (in)	250	614	0.5 max	no limit
Weld position (manual position weld)	6G	6G		
Progression	Up	Up	Up	Up
Backing gas		Without		With, without
GNW transfer mode (GN-409)				Spre, pulse, glo

GRADED BEND TESTS (GW-400)

Type of test	Acceptance criteria	Result	Comments
4 transverse side bends per GW-181.1 and GW-482.2	GW-183	Acceptable	see - ASME IX - GW-482.1 Note (4)

OTHER TESTS

Type of test	Acceptance criteria	Result	Comments
Visual examination per GW-302.4	GW-104	Acceptable	see - ASME IX - GW-482.1 Note (8)

CERTIFICATION

Tests conducted by: Rick Mossman Laboratory test number: 001
Mechanical testing by: Rick Mossman Test file number: 001

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.

Welding Engineer
Name: _____ Signature: _____
Date: _____

QA Manager
Name: _____ Signature: _____
Date: _____

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Catalog n° WPQ00001

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C-spec

P.O. Box 27604, Concord, CA 94527, (888) 673-9777

ASME Section IX - Welder Performance Qualification (WPQ)

C-spec WeldOffice® Software

Welder's name	Rod Laver		Test date	1/6/02
ID Number	5555		WPQ record number	500-5555
Date of birth	4/17/23		Standard test number	
Stamp number	500		WPS record number	
Company name	C-spec		Qualification code	ASME Section IX
Division	Concord			

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	6	XX	0.864	6.625
	Pipe	SA-106 (B)	1	1	6	XX	0.864	6.625
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, 4X

BASE METAL THICKNESS

	Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness (in.)	-	-	-	no limit	no limit	-
Pipe/tube thickness (in.)	0.864	-	-	no limit	no limit	-
Pipe diameter (in.)	6.625	-	-	2.875 min	no limit	-

PROCESS VARIABLES

Actual values

RANGE QUALIFIED

	SMAW	FCAW	SMAW	FCAW
Welding process	SMAW	FCAW	SMAW	FCAW
Type	Manual	Semi-automatic	Manual	Semi-automatic
Backing	Without	With	With, without	With
Filler metal specification	5.1	5.20	5.xx	5.xx
Filler metal classification	E6010	E71T-12M	Any	Any
Filler metal F-number	3	6	3(1..3 w/backing)	6
Number of layers deposited	2	3 min		
Weld deposit thickness (in.)	0.250	0.614	0.5 max	no limit
Weld position (Actual position tested)	6G	6G		
Groove - Plate & Pipe >24"			All	All
Groove - Pipe 2.875" to 24"			All	All
Groove - Pipe < 2.875"			-	-
Fillet - Plate & Pipe >24"			All	All
Fillet - Pipe 2.875" to 24"			All	All
Fillet - Pipe < 2.875"			All	All
Progression	Up		Up	Up
Backing gas	-	Without	-	With, without
GMAW transfer mode (QW-409)	-	Globular	-	Spray, pulse, globular

TESTS

Type of test	Acceptance criteria	Result	Comments
4 transverse side bends per QW-161.1 and QW-462.2	QW-163	Acceptable	see - ASME IX - QW-452.1 Note (4)
Visual examination per QW-302.4	QW-194	Acceptable	see - ASME IX - QW-452.1 Note (8)

Notes

CERTIFICATION

Tests conducted by	Nick Mossman	Laboratory test number	001
Mechanical tests by	Nick Mossman	Test file number	001

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.

Welding Engineer

QA Manager

Name	Signature	Name	Signature
Date		Date	

Signature 3

Signature 4

Name	Signature	Name	Signature
Date		Date	