



**AWS**  
ATF WPQR  
**ASME Section IX - Welder Performance Qualification (WPQ)**  
WeldOffice WPQ

|               |                             |  |                      |                          |
|---------------|-----------------------------|--|----------------------|--------------------------|
| Welder's name | Teresa Saldatrice           |  | Test date            | 4/22/2024                |
| ID Number     | TM-01                       |  | WPQ record number    | TSP-TAG-001              |
| Date of birth |                             |  | Standard test number | GTAW/SMAW/GMAW-01 Rev. 0 |
| Stamp number  | S2000                       |  | WPS record number    | WPS-TAG-001 Rev. 0       |
| Company name  | AWS                         |  | Qualification code   | ASME Section IX          |
| Division      | Melfi, Provincia di Potenza |  |                      |                          |

**BASE METALS (QW-403)**

|            | Product form | Specification (type or grade) | P no. | Grp-no. | Size | Sch. | Thick. (in.) | Dia. (in.) |
|------------|--------------|-------------------------------|-------|---------|------|------|--------------|------------|
| Welded to: | Pipe         | SA-53 (S, B)                  | 1     | 1       | 2.75 | XX   | 0.688        | 2.75       |
|            | Pipe         | SA-53 (S, B)                  | 1     | 1       | 2.75 | XX   | 0.688        | 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. 1 thru 15F, 34, 41 thru 49 |

**BASE METAL THICKNESS**

|                           | Groove | Fillet | Overlay | Groove   | Fillet   | Overlay |
|---------------------------|--------|--------|---------|----------|----------|---------|
| Plate thickness (in.)     | -      | -      | -       | no limit | no limit | -       |
| Pipe/tube thickness (in.) | 0.688  | -      | -       | no limit | no limit | -       |
| Pipe diameter (in.)       | 2.75   | -      | -       | 1.0 min  | no limit | -       |

**PROCESS VARIABLES**

|  | Actual values |        |                | RANGE QUALIFIED    |          |                        |
|--|---------------|--------|----------------|--------------------|----------|------------------------|
|  | GTAW          | SMAW   | GMAW           | GTAW               | SMAW     | GMAW                   |
| Welding process                        | Manual        | Manual | Semi-automatic | Manual             | Manual   | Semi-automatic         |
| Type                                   | Manual        | Manual | Semi-automatic | Manual             | Manual   | Semi-automatic         |
| Backing                                | None          | With   | With           | With, without      | With     | With                   |
| Filler metal specification             | 5.18          | 5.1    | 5.18           | 5.xx               | 5.xx     | 5.xx                   |
| Filler metal classification            | ER70S-2       | E7018  | ER70S-6        | Any                | Any      | Any                    |
| Filler metal F-number                  | 6             | 4      | 6              | 6                  | 1..4     | 6                      |
| Filler metal variety (QW-404.23)       | Bare (solid)  | -      | -              | Solid, metal cored | -        | -                      |
| Consumable insert                      | None          | -      | -              | Without            | -        | -                      |
| Number of layers deposited             | 3             | 3      | 3              |                    |          |                        |
| Weld deposit thickness (in.)           | 0.23          | 0.23   | 0.23           | 0.46 max           | 0.46 max | 0.46 max               |
| Weld position (Actual position tested) | 6G            | 6G     | 6G             |                    |          |                        |
| Groove - Plate & Pipe >24"             |               |        |                | All                | All      | All                    |
| Groove - Pipe 2.875" to 24"            |               |        |                | All                | All      | All                    |
| Groove - Pipe < 2.875"                 |               |        |                | All                | All      | All                    |
| Fillet - Plate & Pipe >24"             |               |        |                | All                | All      | All                    |
| Fillet - Pipe 2.875" to 24"            |               |        |                | All                | All      | All                    |
| Fillet - Pipe < 2.875"                 |               |        |                | All                | All      | All                    |
| Progression                            | Up            | Up     | Up             | Up                 | Up       | Up                     |
| Backing gas                            | Without       | -      | Without        | With, without      | -        | With, without          |
| GMAW transfer mode (QW-409)            | -             | -      | Globular       | -                  | -        | Spray, pulse, globular |
| GTAW welding current/polarity          | DCSP          | -      | -              | DCSP               | -        | -                      |

**TESTS**

| Type of test  | Acceptance criteria | Result                   | Comments  |
|---|---------------------|--------------------------|---|
| 4 transverse side bends per QW-161.1, QW-463.2(e) and QW-462.2<br>Visual examination per QW-302.4 | QW-163<br>QW-194    | Acceptable<br>Acceptable | see - ASME IX - QW-452.1 (a) Note (1)<br>see - ASME IX - QW-452.1 (a) |

Notes

**CERTIFICATION**

|                     |                  |                        |        |
|---------------------|------------------|------------------------|--------|
| Tests conducted by  | C-SPEC           | Laboratory test number | QTL001 |
| Mechanical tests by | Quality Test Lab | Test file number       | CSP-01 |

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.

**Welder**

|                   |           |           |           |
|-------------------|-----------|-----------|-----------|
| Name              | Signature | Name      | Signature |
| Teresa Saldatrice |           | Lisa CWI  |           |
| Date              |           | Date      |           |
| 4/22/2024         |           | 4/22/2024 |           |

**ATF Supervisor**

|           |           |           |           |
|-----------|-----------|-----------|-----------|
| Name      | Signature | Name      | Signature |
| Harry ATF |           | Jenny AWS |           |
| Date      |           | Date      |           |
| 4/22/2024 |           | 4/22/2024 |           |