HCC

QW-484A WELDER PERFORMANCE QUALIFICATIONS (WPQ)

(See QW-301, Section IX, ASME Boiler & Pressure Vessel Code)

Welder's Name: VIKAS KUMAR

Identification Number: HCC/WD-24 (31)

Identification of WPS followed: HCC/BARC/SMAW/WPS/05

[X] Test Coupon [ ] Production weld

Specification of base metal(s) IS 2062 Gr B to IS 2062 Gr B Thickness 15mm

Testing Conditions and Qualification Limits

Welding Variables (QW-350)

	Actual Values	Range Qualified
Welding Process(es)	SMAW	SMAW
Type (ie. manual, semi-auto) used	Manual	Manual
Backing (Metal, weld metal, double welded, etc)	Without	F4 (With & without backing)
Base metal P- or S- Number To P- or S- Number	P-1 to P-1	P1 through P15F
[x] Plate [ ] Pipe (If pipe or tube, enter the diameter)	Plate	Plate & Pipe (OD ≥610mm)
Filler Metal or electrode specification(s) (SFA) (info. Only)	SFA 5.1	SFA 5.1
Filler Metal or electrode classification(s) (AWS) (info. Only)	E 7018	E 7018
Filler Metal F Number(s)	4	F1 to F3 (with backing), F4
Consumable Insert (GTAW or PAW)	NA	NA
Filler type (solid/metal or flux cored/powder) (GTAW or PAW)	Solid	Solid
Deposit thickness for each process		
Process 1 SMAW 3 layers minimum [X] Yes [ ] No	15 mm	upto 30 mm
Process 2 .....3 layers minimum [ ] Yes [ ] No	NA	NA
Position qualified (2G, 6G, 3F, etc)	3G	3G, 1G, 3F, 2F, 1F
Vertical progression (uphill or downhill)	Uphill	Uphill
Type of fuel gas (OFW)	NA	NA
Inert gas backing (GTAW,PAW,GMAW)	NA	NA
Transfer mode (spray/globular or pulse to short circuit-GMAW)	NA	NA
GTAW welding current type / polarity (AC, DCEP,DCEN)	DCEP	DCEP

Results

Visual Examination of completed weld (QW-302.4) ...Satisfactory

[x] Bend Test ; [ ]Transverse root & face{QW-462.3(a)} ; [ ]Longitudinal root & face{QW-462.3(b)} , [ ] side{ QW-462.2},
[ ]Pipe bend specimen, corrosion-resistant overlay{QW-462.5(c)} ; [ ]Plate bend specimen, corrosion-resistant overlay{QW-462.5(d)}
[ ] Macro test for fusion {QW-462.5(b)} ; [ ] Macro test for fusion{ QW-462.5(e)}

TYPE	RESULT
Root bend	NA
Face Bend	NA
Other tests	NA

Alternative radiographic examination Results (QW-191) ... Satisfactory, Rep. No.: RIR 4073 Dtd 20.02.2021
Fillet Weld - Fracture test (QW-180) ..... NA
Macro examination (QW-184) ..... Fillet size .....mm X .....mm Concavity / Convexity .....mm
Other tests.....
Film or specimens evaluated by
Mechanical Test conducted By: NA Laboratory Test No.
Weld witnessed by Mr. B. N. SHINDE, QA, NRB, BARC

We certified that the statement in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME B & PV Code.

For,
M/s. HCC .....

For,
(BARC, NRB(T), QA)

WELDER IDENTITY CARD

HCC

Project: Phase-1, INRP, NRB, BARC

Contractor: Hindustan Construction Company

Welder Name: VIKAS KUMAR

Welder ID No.: HCC/ WD/ 24(31)

Date of Testing: ~~10.05.2016~~ 20/02/21 **Valid Upto:** Till satisfactory performance

Ref. WPS: HCC/BARC/SMAW/WPS/05

Sign		
Name		
Date		

HCC - QA

BARC, NRB(T) - QA

Welding variables	**Range Qualified**
WPS followed	WPS 05
Welding process type	SMAW/Manual
Backing(Metal,Weld metal)	With & Without
Base Metal P No.	P1 to P15F
Size (Plate or pipe)	Plate & pipe ≥ OD 610mm
F No. & Filler type	F.No.4 & 7018
Weld Metal deposition	Up to 30 mm
Positions	3G, 1G, 3F, 2F, 1F
Inert Gas Backing	NA
Current type/ Polarity	DCEP

HCC - QA

BARC, NRB(T) - QA