



Welder Performance Qualification Test Record

Certificate No.: **98448** Date: **28-Jun-2024**
 Company Name: **DAEAH SAUDI ARABIA LTD.**
 Welder Name: **MOHAMMAD UJJAL**
 Iqama/Passport: **2292880362** Symbol/Id No: **MDA-135**



Test Description

Identification of WPS followed: **DA-GTSM-003, REV. 1** Test Coupon Production Weld
 Specification of Base Metal(s): **SA106 Gr. B** Thickness: **18.26 MM**

Test Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(s)	<u>GTAW / SMAW</u>	<u>GTAW / SMAW</u>
Type Used (Manual, semi-auto)	<u>MANUAL</u>	<u>MANUAL</u>
Weld Backing (Process-1)	<u>GTAW - WITHOUT BACKING</u>	<u>WITH / WITHOUT BACKING</u>
Weld Backing (Process-2)	<u>SMAW - WITH WELD BACKING</u>	<u>WITH BACKING</u>
Plate or Pipe (Enter dia of pipe or tube)	<u>6"Ø</u>	<u>PLATE & PIPE 2-7/8"OD To UNLIMITED</u>
Base Metal (P- or S-Number to P- or S Number)	<u>P1 To P1</u>	<u>P1 THRU P15F, P34 & P41 THRU P49</u>
Filler metal or electrodes specs (SFA)(Info Only)	<u>SFA 5.18 / SFA 5.1</u>	<u>=</u>
Filler metal or electrode classifications (Info only)	<u>ER70S-3 / E7018</u>	<u>=</u>
Filler metal F-Numbers	<u>F6 / F4</u>	<u>ALL F6 : F4 & BELOW WITH BACKING</u>
Consumable Insert (GTAW or PAW)	<u>NONE</u>	<u>WITHOUT CONSUMABLE INSERT</u>
Filler type (solid/metal or flux cored/power) (GTAW or PAW)	<u>SOLID</u>	<u>SOLID</u>
Desposit Thickness for each process		
Process1: <u>GTAW</u> 3 Layers Minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	<u>5.0 MM</u>	<u>GTAW - 10.0 MM MAX.</u>
Process2: <u>SMAW</u> 3 Layers Minimum <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<u>13.26 MM</u>	<u>SMAW - MAX. TO BE WELDED</u>
Position Qualified (2G, 6G, 3F etc)	<u>6G</u>	<u>GROOVE - ALL / FILLET - ALL</u>
Vertical Progression (Uphill or Downhill)	<u>UPHILL</u>	<u>UPHILL</u>
Type of fuel gas (OFW)	<u>=</u>	<u>=</u>
Inert gas backing (GTAW, PAW, GMAW)	<u>WITHOUT GAS BACKING</u>	<u>WITH / WITHOUT GAS BACKING</u>
Transfer mode (spray/globular or pulse to shor circuit-GMAW)	<u>=</u>	<u>=</u>
GTAW current type/polarity (AC, DCEP, DCEN)	<u>GTAW - DCEN</u>	<u>DCEN</u>
Others	<u>SMAW - DCEP</u>	<u>DCEP / DCEN / AC</u>

Test Results

Visual examination of completed weld (QW-302.4): **ACCEPTABLE**
 Bend Test Transverse root and face (QW-462.3a) Longitude root and face (QW-462.3b) Side (QW-462.2)
 Pipe bend specimen, corrosion-resistanct overlay (QW-462.5c) Pipe bend specimen, corrosion-resistanct overlay (QW-462.5d)
 Macro test for fusion (QW-462.5b) Macro test for fusion (QW-462.5e)

Alternative Radiographic examination result (QW-191): **ACCEPTABLE** Report No.: **RT/23/139846**

Fillet weld-fracture test (QW-182); **==** Length and % of defect: **==**

Macro examination (QW-184): **==** Fillet size (In) **==** Concavity/Convexit(In): **==**

Other Tests: **==**

Film and specimen evaluated by: **Subash Nair** Company: **NDT CCS CO.**

Mechanical Test conducted by: **==** Laboratory Test No.: **==**

Welding Inspected by: **Sarathchandran** Test Date: **25-Jun-2024**

We certify that statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with requirements of ASME BPVC Sec. IX- 2021 Edition.

*Customers encouraged to validate the certificate in our official website.

Organisation: **NDT Corrosion Control Services Co.**
 Approved by: **S. Thomas Jude, Department Head - Inspection**

This is system generated report, doesn't require a signature.

