



## WELDER QUALIFICATION RECORD (WQR)

Welder's Name: \_\_\_\_\_ Symbol No.: \_\_\_\_\_

Identification of WPS followed by welder during welding of test coupon: \_\_\_\_\_

Base material(s) welded: \_\_\_\_\_ Thickness: \_\_\_\_\_  Test Coupon  Prod. Weld

### Testing Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(es) Used:		
Type of Welding (i.e., Manual, Semi-Automatic) Used:		
Base Metal P- or S-Number: _____ To P- or S-Number: _____		
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube):		
Backing (metal, weld metal, double-welded, etc):		
Filler Metal or Electrode Specification(s) (SFA) (Info only):		
Filler Metal or Electrode Classification(s) (info only):		
Filler Metal or Electrode F-Number(s):		
Filler Type (solid/metal or flux cored/powder) (GTAW or PAW):		
Consumable Insert for GTAW or PAW:		
Deposit Thickness for each process or electrode type, etc. (in.):		
Process/Electrode 1: 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	Process/Electrode 2: 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	
Welding Position (2G, 6G, 3F, etc.):		
Vertical Progression (Uphill or Downhill):		
Fuel Gas for OFW or Inert Gas Backing for GTAW, PAW, GMAW:		
Transfer Mode (spray/globular or pulse to short circuit- GMAW):		
GTAW Current Type/Polarity (AC, DCEP, DCEN):		

### Results

Visual Examination of Fit-Up; Root Gap: \_\_\_\_\_ Tack Welds: \_\_\_\_\_ (Length: \_\_\_\_\_ Number: \_\_\_\_\_)

Root Pass (Describe Discontinuity if unacceptable): \_\_\_\_\_

Completed Weld (Describe defects if unacceptable): \_\_\_\_\_

Bend Test:  Transverse Root and Face [QW-462.3(a)]  Longitudinal Root and 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	Type	Result	Type	Result

(For alternative qualification of groove welds by radiography to QW-191)

Radiographic Results: \_\_\_\_\_

Appearance-Fillet Size (leg.): \_\_\_\_\_ X \_\_\_\_\_ inch. Convexity: \_\_\_\_\_ inch. or Concavity: \_\_\_\_\_ inch.

Other Tests: \_\_\_\_\_

### Record Information

Film or Specimens Evaluated by: \_\_\_\_\_ Company: \_\_\_\_\_

Welding Supervised by: \_\_\_\_\_

Mechanical Tests Conducted by: \_\_\_\_\_ Laboratory Test No: \_\_\_\_\_

We certify that the statements 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 Boiler and Pressure Vessel Code.

Certified by: \_\_\_\_\_ Date: \_\_\_\_\_