



CERTIFIED TESTING LABORATORIES, INC.



## QW-484 WELDER PERFORMANCE QUALIFICATIONS

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

|              |                         |                    |      |
|--------------|-------------------------|--------------------|------|
| Welders name | J. Alex Bautista Contla | Identification No. | 8231 |
|--------------|-------------------------|--------------------|------|

### Test Description

|                                |         |             |     |                 |  |
|--------------------------------|---------|-------------|-----|-----------------|--|
| Identification of WPS followed | QW191.2 | Test coupon | X   | Production weld |  |
| Specification of base metal(s) | SA-106B | Thickness   | 280 |                 |  |

### Testing Conditions and Qualification Limits

| Welding Variables (QW-350)                                    |     |                                       |    | Actual Values | Range Qualified         |
|---------------------------------------------------------------|-----|---------------------------------------|----|---------------|-------------------------|
| Welding process                                               |     |                                       |    | SMAW          | SMAW                    |
| Type (Manual, Semi-auto) used                                 |     |                                       |    | Manual        | Manual                  |
| Backing (metal, weld metal, double-welded, etc.)              |     |                                       |    | Without       | With or Without         |
| Plate                                                         | X   | Pipe (enter diameter if pipe or tube) |    | 6"            | 2 7/8" to Unlimited     |
| Base metal P-or-S Number to P-or-S- Number                    |     |                                       |    | P1 to P1      | P1 Thru P11, P34, & P4X |
| Filler metal or electrode specification(s) (SFA) (info. only) |     |                                       |    | A5.1          | A5.1                    |
| Filler metal or electrode classification(s) (info. only)      |     |                                       |    | E6011 & E7018 | E60XX & E70XX           |
| Filler metal F-Number(s)                                      |     |                                       |    | F3, F4        | F1, F2, F3, F4          |
| Consumable insert (GTAW or PAW)                               |     |                                       |    | N/A           | N/A                     |
| Filler type (solid/metal or flux cored/power) (GTAW or PAW)   |     |                                       |    | N/A           | N/A                     |
| Deposit thickness for each process                            |     |                                       |    | .280"         | .125" to .560"          |
| Process1: E6011 (1/8") 1 layer minimum                        | yes | X                                     | No | .125" (1/8")  | .125" (1/8")            |
| Process2: E7018 (3/32") 3 layer minimum                       | yes | X                                     | No | .187" (3/16") | .187" (3/16")           |
| Position qualified (2G, 6G, 3G, etc.)                         |     |                                       |    | 6G            | ALL                     |
| Vertical progression (uphill or downhill)                     |     |                                       |    | Uphill        | Uphill                  |
| Type of fuel gas (OFW)                                        |     |                                       |    | N/A           |                         |
| Inert gas backing GTAW, PAW, GMAW                             |     |                                       |    | N/A           |                         |
| Transfer Mode (spray/globular or pulse to short circuit-GMAW) |     |                                       |    | N/A           |                         |
| GTAW current type/polarity (AC, DCEP, DCEN)                   |     |                                       |    | DCEP          | DCEP                    |

### RESULTS

|                                                               |  |                                        |  |                                                                 |  |                |  |
|---------------------------------------------------------------|--|----------------------------------------|--|-----------------------------------------------------------------|--|----------------|--|
| Visual Examination of Completed Weld (QW-302.4)               |  |                                        |  | ACCEPTABLE                                                      |  |                |  |
| Bend test                                                     |  | Transverse root and face (QW-462.3(a)) |  | Longitudinal root and face (QW-462.3(b))                        |  | Side (QW-62.2) |  |
| 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                                                          |  | Results                                |  | Type                                                            |  | Result         |  |
|                                                               |  |                                        |  |                                                                 |  |                |  |
|                                                               |  |                                        |  |                                                                 |  |                |  |

|                                                       |  |                               |  |                           |                     |                                    |  |
|-------------------------------------------------------|--|-------------------------------|--|---------------------------|---------------------|------------------------------------|--|
| Alternative radiographic examination results (QW-191) |  |                               |  | 6G-ACCEPTABLE             |                     |                                    |  |
| Fillet weld – fracture test (QW-180)                  |  | Length and percent of defects |  |                           |                     |                                    |  |
| Macro examination (QW-184)                            |  | Fillet Size (in.)             |  | Concavity/convexity (in.) |                     |                                    |  |
| Other tests:                                          |  |                               |  |                           |                     |                                    |  |
| Film or Specimens evaluated by:                       |  | D. Schultz ASNT LEVEL II RT   |  |                           | Company             | Certified Testing Laboratories Inc |  |
| Mechanical tests conducted by:                        |  |                               |  |                           | Laboratory test No. | AB-8231                            |  |
| Welding supervised by                                 |  | D. SCHULTZ CWI # 05120211     |  |                           |                     |                                    |  |

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and test in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.



DANIEL F. SCHULTZ  
CWI 05120211  
ECI SEP 12/04/11

Organization: Ward Mechanical

By: *[Signature]*

Date: 8-19-2010  
Main Office

155 U.S. Route 130 • Bordentown, NJ 08505 • (609) 298-3255 • Fax (609) 298-7288