

Superior Consulting Corp.**INSPECTION & TESTING**

63, FLUSHING AVENUE UNIT#346

BROOKLYN, NEW YORK 11205

QW -484A SUGGESTED FORMAT A FOR WELDER PERFORMANCE QUALIFICATION (WPQ)

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

Scan Code ESHS1825544

TEL (718) 625-5890

FAX (718) 625-5890

Welder's name: NICK ROTUNDO SS# XXX-XX-9029 STAMP NO: N/AProcess (es) used: SMAW Type: Manual

Identification of WPS followed by welder during welding of test coupon

Base Material Welded: SA-53B Size: 6" PIPE Thickness: .280"

Manual or Semiautomatic Variables for Each Process (QW-350)
 Backing (metal, weld metal, double -welded, flux, etc.) (QW-402) F3
 ASME P-No. 1 to ASME P-No. (QW-403):
 PIPE DIAMETER 6"

Actual ValuesWithout16"**Range Qualified**With; F3 With or W/OP1 THRU P112 7/8 to UNLIMITEDFiller metal specification (SFA) 5.1 Classification: (QW-404)E6010&7018E6010 & 7018

Filler metal F- Number (s)

33,2,1

Consumable insert (GTAW or PAW)

N/AN/A

Welding deposit thickness for each process (inches)

.125.500

Welding position (1G, 5G, 6G, etc.) (QW- 405)

6GALL

Progression (uphill or downhill)

Backing Gas for GTAW, PAW or GMAW, fuel gas for OFW (QW-408)

GMAW transfer mode (QW-490)

UPHILLN/AUPHILLN/A

GTAW current type/polarity

Machine Welding Variables For The Process Used (QW-360)

Direct/remote visual control

Automatic voltage control (GTAW)

Automatic joint tracking

Welding position (1G, 5G, 6G etc.)

Consumable insert

Backing (metal, weld metal, welded from both sides, flux etc)

Actual ValuesN/AN/AN/AN/AN/AN/A**Range Qualified**N/AN/AN/AN/AN/AN/A

Guided Bend Test Type	QW-462.2 (Side) Results	QW-462.3(a) (Trans. R&F) Type	Qw-462.3(b0 (Long R&F) Results
FACE	SATISFACTORY	SATISFACTORY	
ROOT	SATISFACTORY	SATISFACTORY	

Visual examination results (QW-191) AcceptedDate: 11-13-14Radiographic test results (QW-304 and QW-305) N/A

(For alternative qualification of groove welds by radiography)

N/AFillet weld -Fracture Test N/A Length & percent of defects (inches)Macro test fusion NONE Fillet leg size (in): x Concavity/convexity (in)Welding test conducted by: National Mech. Services Plumbing LLCMechanical Testing by: D. GHAGHADA, SUPERIOR CONSULTING CORPRadiographing Testing by: N/AReport Date: 11-13-14

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 Code.

Organization National Mech. Services Plumbing LLCBy: Stuart IserDate: 11-13-14

Dinesh C Ghaghada
 CWI 97110061
 QC1 EXP. 11/1/2015