

Universal Laboratory, Inc.

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AWS B2.1/B2.1M:2009 PERFORMANCE QUALIFICATION TEST RECORD (SMAW, GMAW, GTAW, FCAW, SAW, OFW, PAW) Supporting PQR: FFF-2g

NAME LONG TRAN
ID NO. 6468
Process(es) GMAW
Test Base Metal Specification A53
Material Number M1
Fuel Gas (OFW) ARGON/CO² 75/25
AWS Filler Metal Classification(s) ER70S
BACKING: YES () NO (X)
Current/Polarity: AC () DCEP (X) DCEN ()
Consumable Insert: Yes () No (X)

Welder X Welding Operator _____
WPS Used 09.01.2g
Transfer Mode GMAW
To A53
To M1

Test Joint Sketch

A = 30. +10. -0
F = 1/16 in ± -1/32
R = 1/8 in ± -1/16
IO mismatch = 1/16 in max.

F No. 5
Double Side () Single Side (X)

Backing Gas: Yes () No (X)

Test Weldment Position Tested
Groove: Pipe 1G 2G(X) 5G 6G
Plate 1G 2G 5G 6G
Fillet: Pipe 1F 2F 2FR 4F 5F
Plate 1F 2F 3F 4F
Cladding: 1C 2C 3C 4C 5C 6C
Hardfacing: 1C 2C 3C 4C 5C 6C
Progression: Vertical Up () Vertical Down ()

Weldment Thickness (T)

Thickness	Diameter
<u>0.203</u>	<u>2.5"</u>
_____	_____
_____	_____
_____	_____
_____	_____

Test Results

Test	PASS (X)	FAIL ()	NA ()
Visual Test	PASS (X)	FAIL ()	NA ()
Bend Test	PASS (X)	FAIL ()	NA ()
Macro Test	PASS (X)	FAIL ()	NA ()
Break Test	PASS ()	FAIL ()	NA (X)
Radiographic Test	PASS ()	FAIL ()	NA (X)

Remarks SATISFACTORY
ROOT And FACE BENDS

Qualification Limits

Process(es) GMAW 1G; 2G; 1F; 2F

Weldment Position
Groove: Pipe F(x) H V(x) O All
Plate F(x) H V(x) O All
Cladding: F H V O All
Hardfacing: F H V O All

Fillet: Pipe F(x) H V(x) O All
Plate F H V O All

Deposited Thickness

t min.	t max.	Dia. min.
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

Base Metal Thickness

t min.	t max.	Dia. min.
<u>.085"</u>	<u>.674"</u>	<u>1 1/2"</u>
_____	_____	_____

Progression: Vertical Up () Vertical Down ()

Base Metal M No(s) A53, 106, A795, A135

Filler Metal F No(s) E1-E3

Current/Polarity: AC DCEP (X) DCEN

Backing Gas NA

Fuel Gas (OFW) 75% Argon/25% CO²

Backing: Yes () No (X)

Consumable Insert: Yes () No (X)

Transfer Mode: GMAW

I certify that the statements in this record are correct and the test welds were prepared, welded, and tested in accordance with the requirements of AWS B2.1/B2.1M, (2009), Specification for Welding Procedure and Performance Qualification.

Test No.: 37668-E

DATE: November 11 2009

SIGNED BY: _____

Certified Welding Inspector

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