

**Jax Certified Welding Services, LLC**  
 10195 New Berlin Road Suite #111  
 Jacksonville, Florida 32226

**Welder or Welding Operator Performance Qualification (WPQ)**

Welder's Name: Butler, Joseph B. Stamp: B-6  
 Test WPS No.: 1-3G-6010-7018 Rev.: 0 WPQ No.: 1-3G-6010-7018 Date: 3/31/2011  
 Welding process(es) / type(s) used: SMAW / Manual and SMAW / Manual  
 Type of joint welded: Plate Groove weld Joint type(s) qualified: Groove and Fillet Welds  
 Base metal(s) welded: SA-36 to SA-36

Welder Variables (QW-350)	Actual Values Used		Range Qualified	
	P-No. 1 to P-No. 1		P-1 thru P-15F, P-34 & P-4X	
P- or S-Number to P- or S-Number	0.375		WPS Limits	
Base metal thickness (in.)	N/A		2.875" minimum ( n1 )	
Pipe diameter (in.)	<u>SMAW / Manual</u>	<u>SMAW / Manual</u>	<u>SMAW / Manual</u>	<u>SMAW / Manual</u>
	No backing used	Backing used	With or without backing	With backing only
Backing **	E6010	E7018		
AWS classification	5.1	5.1	5.xx	5.xx
Filler metal specification (SFA)	3	4	F 3 (F 1 - F 2 w/backing)	F-No. 1 to F-No. 4
Filler metal F-No.	N/A	N/A	N/A	N/A
Filler metal product form	N/A	N/A	N/A	N/A
Consumable insert	0.187 [N/A]	0.188 [N/A]	0.3740" maximum	0.3760" maximum
Deposit thickness (in.) [ $\geq$ 3 layers]	3G - Vertical	3G - Vertical	F & V (Filletts - F, H, & V)	F & V (Filletts - F, H, & V)
Welding position	Vertical up	Vertical up	Vertical up (n4)	Vertical up (n4)
Weld progression	N/A	N/A	N/A	N/A
Backing gas				

Machine Welding Variables (QW-360)	Actual Values Used		Range Qualified	
	Direct / remote visual control	N/A	N/A	N/A
Automatic voltage control	N/A	N/A	N/A	N/A
Automatic joint tracking	N/A	N/A	N/A	N/A
Welding position	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Backing **	N/A	N/A	N/A	N/A
Single / multiple pass per side	N/A	N/A	N/A	N/A

Fillet Welds: Qualified to make fillet welds of any size on all base material thicknesses and pipe diameters of any size.  
 \*\* Welds with backing include fillets and double-welded groove welds.  
 Notes: ( n1 ) Pipe with O.D.  $\leq$  24" limited to flat rotated only.

**Guided Bend Test (QW-160)**

Figure Number and Type	Result	Figure Number and Type	Result
QW-462.3(a) Face bend	Satisfactory	QW-462.3(a) Root bend	Satisfactory
QW-462.3(a) Face bend	Satisfactory	QW-462.3(a) Root bend	Satisfactory
None		None	

Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194  
 Volumetric test results: None  
 Welding test conducted by: Jax Certified Welding Services, LLC  
 Mechanical tests conducted by: Jax Certified Welding Services, LLC. Lab test no.: 03312011

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

Organization: Jax Certified Welding Services, LLC

Certified By: Phillip E. Baker  
 Phillip E. Baker

Date: 3/31/2011 Quality Control



PHILLIP E. BAKER  
 CWI 02050321  
 QCI EXP. 05/01/11

**Jax Certified Welding Services, LLC**  
 10195 New Berlin Road Suite #111  
 Jacksonville, Florida 32226

**Welder or Welding Operator Performance Qualification (WPQ)**

Welder's Name: Butler, Joseph B. Stamp: B-6  
 Test WPS No.: 1-4G-6010-7018 Rev.: 0 WPQ No.: \_\_\_\_\_ Date: 3/31/2011  
 Welding process(es) / type(s) used: SMAW / Manual and SMAW / Manual  
 Type of joint welded: Plate Groove weld Joint type(s) qualified: Groove and Fillet Welds  
 Base metal(s) welded: SA-36 to SA-36

Welder Variables (QW-350)	Actual Values Used		Range Qualified	
	P-No. 1 to P-No. 1		P-1 thru P-15F,P-34 & P-4X	
P- or S-Number to P- or S-Number	0.375		WPS Limits	
Base metal thickness (in.)	N/A		2.875" minimum (n1)	
Pipe diameter (in.)	SMAW / Manual	SMAW / Manual	SMAW / Manual	SMAW / Manual
	No backing used	Backing used	With or without backing	With backing only
Backing **	E6010		E7018	
AWS classification	5.1		5.1	
Filler metal specification (SFA)	3		4	
Filler metal F-No.	N/A		N/A	
Filler metal product form	N/A		N/A	
Consumable insert	N/A		N/A	
Deposit thickness (in.) [ $\geq$ 3 layers]	0.187 [N/A]		0.188 [N/A]	
Welding position	4G - Overhead		4G - Overhead	
Weld progression	N/A		N/A	
Backing gas	N/A		N/A	

Machine Welding Variables (QW-360)	Actual Values Used		Range Qualified	
	Direct / remote visual control	N/A	N/A	N/A
Automatic voltage control	N/A	N/A	N/A	N/A
Automatic joint tracking	N/A	N/A	N/A	N/A
Welding position	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Backing **	N/A	N/A	N/A	N/A
Single / multiple pass per side	N/A	N/A	N/A	N/A

Fillet Welds: Qualified to make fillet welds of any size on all base material thicknesses and pipe diameters of any size.  
 \*\* Welds with backing include fillets and double-welded groove welds.  
 Notes: (n1) Pipe with O.D.  $\leq$  24" limited to flat rotated only.

**Guided Bend Test (QW-160)**

Figure Number and Type	Result	Figure Number and Type	Result
QW-462.3(a) Face bend	Satisfactory	QW-462.3(a) Root bend	Satisfactory
QW-462.3(a) Face bend	Satisfactory	QW-462.3(a) Root bend	Satisfactory
None		None	

Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194  
 Volumetric test results: None

Welding test conducted by: Jax Certified Welding Services, LLC  
 Mechanical tests conducted by: Jax Certified Welding Services, LLC. Lab test no.: 03312011A

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Codes.

Organization: Jax Certified Welding Services, LLC

Certified By: Phillip E. Baker  
 Phillip E. Baker

3/31/2011 Quality Control  
 Date



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