



Welder Performance Qualification Test Record

Certificate No.: **93023** Date: **14-Oct-2024**
 Company Name: **SINOPEC E&C MIDDLE EAST LTD.CO**
 Welder Name: **MD AHAD SAKH**
 Iqama/Passport: **2590066995** Symbol/Id No: **SB-IN-011**



Test Description

Identification of WPS followed: **SAS-357/16. REV. 1** Test Coupon Production Weld
 Specification of Base Metal(s): **SA106 Gr. B** Thickness: **8.74 MM**

Test Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(s)	GTAW / SMAW	GTAW / SMAW
Type Used (Manual, semi-auto)	MANUAL	MANUAL
Weld Backing (Process-1)	GTAW - WITHOUT BACKING	WITH / WITHOUT BACKING
Weld Backing (Process-2)	SMAW - WITH WELD BACKING	WITH BACKING
Plate or Pipe (Enter dia of pipe or tube)	2"Ø	PLATE & PIPE 1"OD To UNLIMITED
Base Metal (P- or S-Number to P- or S Number)	P1 To P1	P1 THRU P15E, P34 & P41 THRU P49
Filler metal or electrodes specs (SFA)(Info Only)	SFA 5.28 / SFA 5.5	=
Filler metal or electrode classifications (Info only)	ER80S-Ni1 / E8018-C3 H4R	=
Filler metal F-Numbers	F6 / F4	ALL F6 : F4 & BELOW WITH BACKING
Consumable Insert (GTAW or PAW)	=	=
Filler type (solid/metal or flux cored/power) (GTAW or PAW)	SOLID	SOLID
Deposit Thickness for each process		
Process1: GTAW 3 Layers Minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	3.0 MM	GTAW - 6.0 MM MAX.
Process2: SMAW 3 Layers Minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	5.74 MM	SMAW - 11.48 MM MAX.
Position Qualified (2G, 6G, 3F etc)	6G	GROOVE & FILLET - ALL (PIPE & PLATE)
Vertical Progression (Uphill or Downhill)	UPHILL	UPHILL
Type of fuel gas (OFW)	=	=
Inert gas backing (GTAW, PAW, GMAW)	WITHOUT GAS BACKING	WITH / WITHOUT GAS BACKING
Transfer mode (spray/globular or pulse to shor circuit-GMAW)	=	=
GTAW current type/polarity (AC, DCEP, DCEN)	GTAW - DCEN	DCEN
Others	SMAW - DCEP	DCEP / DCEN / AC

Test Results

Visual examination of completed weld (QW-302.4): **ACCEPTABLE**

Bend Test Transverse root and face (QW-462.3a) Longitude root and face (QW-462.3b) Side (QW-462.2)
 Pipe bend specimen, corrosion-resistanct overlay (QW-462.5c) Pipe bend specimen, corrosion-resistanct overlay (QW-462.5d)
 Macro test for fusion (QW-462.5b) Macro test for fusion (QW-462.5e)

Alternative Radiographic examination result (QW-191): **ACCEPTABLE** Report No.: **RT/23/018294**

Fillet weld-fracture test (QW-182): **==** Length and % of defect: **==**

Macro examination (QW-184): **==** Fillet size (In) **==** Concavity/Convexit(In): **==**

Other Tests: **==**

Film and specimen evaluated by: **A. V. Rajeev** Company: **NDT CCS CO.**

Mechanical Test conducted by: **==** Laboratory Test No.: **==**

Welding Inspected by: **M. Maiyappen** Test Date: **11-Oct-2024**

We certify that statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with requirements of ASME BPVC Sec. IX- 2021 Edition.

*Customers encouraged to validate the certificate in our official website.

Organisation: **NDT Corrosion Control Services Co.**

Approved by: **S. Thomas Jude, Department Head - Inspection**

This is system generated report, doesn't require a signature.

