



Welder Performance Qualification Test Record

Certificate No.: **97736** Date: **10/12/2024**
 Company Name: **BRANCH OF SINOPEC INT'L PETROLEUM SERVICES CO. LTD.**
 Welder Name: **MOBARAK HOSSAIN**
 Iqama/Passport: **2592396747** Symbol/Id No: **M30**



Test Description

Identification of WPS followed: **SIN-WPS-001.REV.2** Test Coupon Production Weld
 Specification of Base Metal(s): **API5L Gr. X60** Thickness: **6.35 MM** Group: **Grp. B To Grp. B**

Test Conditions and Qualification Limits

Welding Variables (6.2.2, 6.3.2)	Actual Values	Range Qualified
Welding Process(s)	<u>GTAW / SMAW</u>	<u>GTAW / SMAW</u>
Combination of Welding Processes	<u>GTAW+SMAW</u>	<u>GTAW+SMAW</u>
Type Used (Manual, semi-auto)	<u>MANUAL</u>	<u>MANUAL</u>
Joint Design Used	<u>V-Bevel</u>	<u>V-Bevel</u>
Backing (metal, weld metal, double-weld, etc)	<u>GTAW WITHOUT BACKING</u> <u>SMAW WITH BACKING</u>	<u>GTAW WITH / WITHOUT BACKING</u> <u>SMAW WITH BACKING</u>
Plate or Pipe (Enter dia of pipe or tube)	<u>12"Ø</u>	<u>OD 2.375" To OD 12.75"</u>
Base metals (Info Only)	<u>Group B To Group B</u>	<u>ANY BASE MATERIAL GROUP</u>
Filler metal or electrodes specs (SFA)(Info Only)	<u>SFA5.18 / SFA5.1</u>	=
Filler metal or electrode classifications (Info only)	<u>ER70S-3 / E7018</u>	=
Filler metal Groups	<u>WF-4 / WF-2</u>	<u>WF-4 / WF-2</u>
Base Metal Thickness	<u>6.35 MM</u>	<u>THK. 3.9 MM To 19.0 MM</u>
Deposit Thickness for each process		
Process1: GTAW 3 Layers Minimum <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	<u>2.0 MM</u>	<u>TWO PASSES MAX.</u>
Process2: SMAW 3 Layers Minimum <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<u>4.35 MM</u>	<u>MULTIPLE PASSES</u>
Position Qualified (2G, 6G, 3F etc)	<u>6G - FIXED</u>	<u>ALL (GROOVE / LAP FILLET WELDS)</u>
Vertical Progression (Uphill or Downhill)	<u>UPHILL</u>	<u>UPHILL</u>
Qualification (Single/Multiple)	<u>SINGLE</u>	<u>SINGLE</u>
Inert gas backing (GTAW, PAW, GMAW)	=	=
Transfer mode (Spray/global/ or pulse)(Info Only)	=	=
Current Type/Polarity (AC, DCEP, DCE/n) (Info Only)	<u>DCEN / DCEP</u>	<u>DCEN / DCEP / AC</u>

Test Results

Visual examination of completed weld (6.4): **ACCEPTABLE**

Root Bend Face Bend Side Bend Nick Break Test

Alternative Radiographic examination result (9.3): **ACCEPTABLE**

Report No.: **08/12/2024**

Fillet weld-fracture test (5.8):

Length and % of defect:

Macro examination:

Fillet size (In):

Concavity/Convexity (In):

Other Tests:

Film and specimen evaluated by **Subash Nair**

Company **NDT CCS CO.**

Mechanical Test conducted by:

Laboratory Test No.:

Welding Inspected by: **P. William**

Test Date: **20-Sep-2023**

We certify that statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with requirements of API 1104, 22nd Edition, 2021.

*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.

