



the pressure equipment safety authority

WELDER QUALIFICATION RECORD (WQR)

AB-76A 2010-09

Welder's Name: _____ ABSA File No.: _____ Stamp No.: _____
 Identification of WPS followed by welder during welding of test coupon: _____ W.P. Reg. # WP- _____
 Base material(s) welded: _____ Thickness: _____ Test Coupon Prod. Weld

Testing Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(es) Used: _____		
Type of Welding (i.e., Manual, Semi-Automatic) Used: _____		
Base Metal P Number: _____ To P Number: _____		
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube): _____		
Backing (metal, weld metal, double-welded, etc.): _____		
Filler Metal or Electrode Specification(s) (SFA) (info only): _____		
Filler Metal or Electrode Classification(s) (info only): _____		
Filler Metal or Electrode F-Number(s): _____		
Filler Type (solid/metal or flux cored/powder) (GTAW or PAW): _____		
Consumable Insert for GTAW or PAW: _____		
Deposit Thickness for each process or electrode type, etc. (in.): _____		
Process/Electrode 1: _____ 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	Process/Electrode 2: _____	3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No
Welding Position (2G, 6G, 3F, etc.): _____		
Vertical Progression (Uphill or Downhill): _____		
Fuel Gas for OFW or Inert Gas Backing for GTAW, PAW, GMAW: _____		
Transfer Mode (spray/globular or pulse to short circuit- GMAW): _____		
GTAW Current Type/Polarity (AC, DCEP, DCEN): _____		

Results

Visual Examination of Fit-Up; Root Gap: _____ Tack Welds: _____ (Length: _____ Number: _____)
 Root Pass (Describe Discontinuity if Unacceptable): _____
 Completed Weld (Describe defects if unacceptable): _____
 Bend Test: Transverse Root and Face [QW-462.3(a)] Longitudinal Root and Face [QW-462.3(b)] Side [QW-462.2]
 Pipe Bend Specimen, corrosion-resistant overlay [QW-462.5(c)] Plate Bend Specimen, corrosion-resistant overlay [QW-462.5(d)]
 Macro Test for Fusion [QW-462.5(b)] Macro Test for Fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result

(For alternative qualification of groove welds by volumetric examination to QW-191)

R.T. Results: _____ U.T. Results: _____
 Fillet Weld - Fracture Test (Describe location, nature and size of any crack or tearing of specimen): _____
 Length and Per Cent of Defects: _____ inches _____
 Macro Test-Fusion: _____
 Appearance-Fillet Size (leg.): _____ X _____ inch. Convexity: _____ inch. or Concavity: _____ inch.
 Other Tests: _____

Record Information

Film or Specimens Evaluated by: _____ Company: _____
 Welding supervised by: _____
 Mechanical tests conducted by: _____ Laboratory test no.: _____
 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 Boiler and Pressure Vessel Code.
 ACCREDITED ORGANIZATION: _____ AOQP No.: _____ Expiry Date: _____
 Certified by: _____ Examiner File No. _____ Date: _____
 P.Q. Card No. (When issued): _____ Performance Test Reference No.: _____
 Test Coupon I.D. No.: _____ Date Coupon is to be retained to: _____