ABSA
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:		
☐ Plate ☐ 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 ☐ Yes ☐ No	Process/Electrode 2: 3 layers minimum ☐ Yes ☐ 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:_____