ABSA
the pressure equipment safety authority

WELDING OPERATOR QUALIFICATION RECORD (WOQR)

AB-76B 2010-09

Welding Operator's Name: _____ ABSA File No.: _____ Stamp No.: _____
Identification of WPS followed by operator during welding of test coupon: _____ W.P. Reg. # WP- _____
Base material(s) welded: _____ Thickness: _____ ☐ Test Coupon ☐ Prod. Weld
Base Metal P Number: _____ To P Number: _____ Welding Position (2G, 6G, 3F, etc.): _____
☐ Plate ☐ Pipe (enter diameter if pipe or tube): _____
Filler Metal (SFA) Specification: _____ Filler Metal or Electrode Classification: _____

Testing Conditions and Qualification Limits When Using Automatic Welding Equipment

Welding Variables (QW-361.1)	Actual Values	Range Qualified
Welding Process(es) Used:		
Type of Welding (Automatic):		
Addition or Deletion of Filler Metal (EBW or LBW):		
Type of Laser for LBW (CO_2 to YAG, etc.):		
Continuous Drive or Inertia Welding (FW):		
Vacuum or Out of Vacuum (EBW):		

Testing Conditions and Qualification Limits When Using Machine Welding Equipment

Welding Variables (QW-361.2)	Actual Values	Range Qualified
Welding Process(es) Used:		
Type of Welding (Machine):		
Direct or Remote Visual Control:		
Automatic Arc Voltage Control (GTAW):		
Consumable Inserts (GTAW or PAW):		
Automatic Joint Tracking:		
Backing (metal, weld metal, backwelded, etc.):		
Welding Position (2G, 6G, 3F, etc.):		
Single or Multiple Passes per Side:		

Results

Visual Examination of 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 test conducted 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 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: _____