



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 (CO2 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)]

Table with 6 columns: 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: