

**Welder or Welding Operator Qualification Test Record (WPQR)**

Welder's Name: Smith, Goerge Stamp: 12345  
 Test WPS No.: WPS231 Rev.: 0 WPQ No.: 271 Date: 7/9/2008 Page 1  
 Type of joint welded: Plate Groove weld  
 Joint type(s) qualified: All applicable groove, fillet, plug, and slot welds (except CJP T-, Y-, & K-connections)  
 Base metal(s) welded: ASTM A 131, Grade A to ASTM A 131, Grade A

Variables (Table 4.11)	Actual Values Used	Range Qualified
	FCAW / Semiautomatic	FCAW / Semiautomatic, Machine, and Automatic
Welding process / type		
Base metal thickness - groove (in.)	1	1/8" to unlimited
Base metal thickness - fillet (in.)	N/A	1/8" to unlimited
Pipe diameter - groove (in.)	N/A	24" and over with backing, back gouging or both
Pipe diameter - fillet (in.)	N/A	Over 24"
Box tube size (in.)	N/A	All sizes with backing, back gouging or both
Dihedral angle - fillet	N/A	30° to unlimited
Backing	Backing used	With backing only
Filler metal classification	E71T-1	
Filler metal specification	5.20	
Filler metal F-No.	N/A	N/A
Welding position - groove	4G - Overhead	Flat & Overhead
Welding position - fillet	N/A	Flat, Horizontal, & Overhead
Weld progression	N/A	N/A
Shielding gas	100% CO2	
Welding current / polarity	DCEP (reverse)	
Transfer mode (GMAW)	N/A	N/A
Single / multiple electrode	N/A	N/A

**Notes:**  
 Visual inspection acceptable: Yes Other test results: \_\_\_\_\_

**Guided Bend Test (4.30.5)**

Figure Number and Type	Result	Figure Number and Type	Result
Side Bend 4G	Satisfactory	Side Bend 4G	Satisfactory
None		None	
None		None	

Organization: ACME Welding Lab Test No.: 2453

Inspected by: \_\_\_\_\_ 7/9/2008 Quality Control  
Date

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section 4 of AWS D1.1/D1.1M, 2006 Structural Welding Code-Steel.

Manufacturer or Contractor: Pyramid Corp.

Certified By: \_\_\_\_\_ 7/9/2008 Quality Control  
Date