

**WELDER, WELDING OPERATOR, OR TACK WELDER
PERFORMANCE QUALIFICATION TEST RECORD**
QPE-ITA-19-00211-rev.0

Name	Oudjane Said	Test Date	03/10/2019	Rev.	
ID Number	/	Record No.			0
Stamp No.	OS	Std. Test No.	/		/
Company	San Michele srl	WPS No.			0
Division	/	Qualified To	AWS D1.		

BASE METALS	Specification	Type or Grade	AWS Group No.	Size (NPS)	Schedule	Thickness	Diameter
Base Material	EN 10025-2	S275 JR	/	/	/	10 [mm]	/
Welded To	EN 10025-2	S275 JR	/	/	/		70 [mm]

VARIABLES	Actual Values	RANGE QUALIFIED
Type of Weld Joint	Fillet Weld pipe to plate (Fig.9.21)	Fillet Weld pipe to plate
Base Metal	S275 JR	S275 JR

	Groove	Fillet	Plate	Fillet
Plate Thickness	/	10 [mm]	3 [mm] to unlimited	3 [mm] to unlimited
Pipe/Tube Thickness	/	8 [mm]	3 [mm] to unlimited	3 [mm] to unlimited
Pipe Diameter	/	70 [mm]	70 [mm] to unlimited	70 [mm] to unlimited

Welding Process	GMAW	GMAW
Type (Manual, Semiautomatic, Mechanized, Automatic)	semiautomatic	semiautomatic
Backing	with	with
Filler Metal (AWS Spec.)	A5.18	A5.XX
AWS Classification	ER70S-6	all
F-Number	/	/
Position	2F	/
Groove – Plate & Pipe ≥ 24 in	/	/
Groove – Pipe < 24 in	/	/
Fillet – Plate & Pipe ≥ 24 in	/	F, H
Fillet – Pipe < 24 in	/	/
Progression	/	/
GMAW Transfer Mode	Spray arc	Spray arc, globular and pulsed
Single or Multiple Electrodes	single	single
Gas/Flux Type	Ar+ (2+3+1)%	appropriated shielding gas protection

TEST RESULTS

Type of Test	Acceptance Criteria	Results	Remarks
1 Macroetch	4.22.2.1	Acceptable	/

CERTIFICATION

Test Conducted by	
Laboratory	Veritas&Tests srl
Test Number	275/19
File Number	

We certify that the contents in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Clause 4.22 of AWS D1.1/D1.1M: 2015 Structural Welding Code—Steel.

Manufacturer or Contractor _____

Authorized by _____

Date _____

