

FORM QW-484A SUGGESTED FORMAT A FOR WELDER PERFORMANCE QUALIFICATIONS (WPQ)
(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

Welder's name _____ Identification no. _____

Test Description

Identification of WPS followed _____ Test coupon Production weld
 Specification and type/grade or UNS Number of base metal(s) _____ Thickness _____

Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es)	_____	_____
Type (i.e.; manual, semi-automatic) used	_____	_____
Backing (with/without)	_____	_____
<input type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube)	_____	_____
Base metal P-Number to P-Number	_____	_____
Filler metal or electrode specification(s) (SFA) (info. only)	_____	_____
Filler metal or electrode classification(s) (info. only)	_____	_____
Filler metal F-Number(s)	_____	_____
Consumable insert (GTAW or PAW)	_____	_____
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW)	_____	_____
Deposit thickness for each process	_____	_____
Process 1 _____ 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	_____	_____
Process 2 _____ 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No	_____	_____
Position qualified (2G, 6G, 3F, etc.)	_____	_____
Vertical progression (uphill or downhill)	_____	_____
Type of fuel gas (OFW)	_____	_____
Inert gas backing (GTAW, PAW, GMAW)	_____	_____
Transfer mode (spray/globular or pulse to short circuit-GMAW)	_____	_____
GTAW current type/polarity (AC, DCEP, DCEN)	_____	_____

RESULTS

Visual examination of completed weld (QW-302.4) _____
 Transverse face and root bends [QW-462.3(a)] Longitudinal bends [QW-462.3(b)] Side bends (QW-462.2)
 Pipe bend specimen, corrosion-resistant weld metal overlay [QW-462.5(c)]
 Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5(d)]
 Pipe specimen, macro test for fusion [QW-462.5(b)] Plate specimen, macro test for fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result

Alternative Volumetric Examination Results (QW-191): _____ RT or UT (check one)
 Fillet weld — fracture test (QW-181.2) _____ Length and percent of defects _____

Fillet welds in plate [QW-462.4(b)] Fillet welds in pipe [QW-462.4(c)]

Macro examination (QW-184) _____ Fillet size (in.) _____ × _____ Concavity/convexity (in.) _____
 Other tests _____

Film or specimens evaluated by _____ Company _____

Mechanical tests conducted by _____ Laboratory test no. _____

Welding supervised by _____

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.

Organization _____

Date _____

Certified by _____