



PII-WPQ-01

Welder Performance Qualification ASME Section IX, QW-484 Format

Form PII-WPQ-01

Revision 01

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Signatures on file – available upon request

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Prime Inspections Inc.

1621 Primewest Parkway, Katy, TX 77449
(870) 291-1991

PRIME INSPECTIONS, INC.

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Welder Performance Qualification (WPQ)

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1.0 WELDER INFORMATION

Field	Value
Welder Name	
Welder Stamp / ID No.	
Identification No.	
Date Qualified	
Procedure Used (WPS No.)	B313-GF-001
PQR No. Supporting WPS	
Organization	Prime Inspections, Inc.
Test Supervisor (CWI)	
Location of Test	

2.0 POSITION QUALIFIED (QW-405)

Variable	Qualified Value	Range Qualified
Position of Groove Welds (QW-405.1) 6G (inclined fixed)	6G (inclined fixed)	All positions (QW-461.9)
Position of Fillet Welds (QW-405.1) 6G	6G	All positions
Welding Progression	Vertical-UP	Vertical-up only
Diameter Range (QW-452)	NPS 2-1/2 (2.875 in. OD)	NPS 2-1/2 and over (QW-452.1)

Thickness Qualified (QW-452.1)	0.375 in. wall	1/16 in. and over
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3.0 WELDING PROCESS (QW-404)

Process	Filler Metal	F-No.	AWS Class	Size
GTAW (Root)	ER70S-6	F-No. 6	SFA-5.18	3/32 in. (2.4 mm)
FCAW-G (Fill/Cap)	E71T-12M-J H4	F-No. 6	SFA-5.20	0.045 in. (1.2 mm)

4.0 JOINT DETAILS (QW-402)

Variable	Value
Joint Type	Single-V groove, CJP, single-sided, no backing
Included Angle	60 degrees nominal
Root Face	1/16 in. (1.6 mm)
Root Opening	3/32 in. (2.4 mm)
Backing	None
Position	6G (inclined fixed, 45 degrees)
Pipe Diameter	2.875 in. OD (NPS 2-1/2)
Wall Thickness	0.375 in. (9.53 mm)

5.0 VISUAL EXAMINATION AND NDE (QW-304 / QW-305)

5.1 The test coupon shall be visually examined per QW-304. The weld shall show no cracks, no incomplete fusion, no incomplete penetration exceeding the limits of the referenced code, and no porosity visible on the weld surface.

5.2 The test coupon shall be radiographed (RT) or ultrasonically tested (UT) per QW-305 over the full length of the weld. Acceptance per API 1104 21st Edition Section 9.3 (RT) or Section 9.4 (UT).

5.3 NDE Report No.: _____ Date: _____ Technician: _____ Level: _____

6.0 GUIDED BEND TEST (QW-452)

6.1 Two side-bend specimens shall be removed from the test coupon per QW-452.1 and tested per QW-160.

Specimen	Type	Result	Remarks
1	Root Bend		
2	Face Bend		
3	Side Bend		
4	Side Bend		

6.2 Acceptance per QW-163: No open discontinuity exceeding 1/8 in. (3 mm) measured in any direction on the convex surface.

7.0 RANGES QUALIFIED (QW-450)

Variable	Qualified	Production Range Permitted
Groove positions	6G	All positions (QW-461.9)
Fillet positions	6G	All positions
Pipe diameter	2.875 in. OD	NPS 2-1/2 and over
Wall thickness	0.375 in.	1/16 in. and over
Deposited thickness	0.375 in.	2T and under (QW-452.1)
GTAW filler F-No.	F-6	F-6 and F-6 limits
FCAW filler F-No.	F-6	F-6 and F-6 limits
Welding progression	Vertical-UP	Vertical-up only

8.0 CERTIFICATION

Role	Name	Signature	Date
Welder			
Test Supervisor (CWI)			
Welding Engineer			

NDT Level III (Review)			
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9.0 NOTES

- 9.1 This WPQ is valid only for the processes, positions, diameters, and thicknesses listed above.
- 9.2 Renewal per QW-304: The welder must re-qualify every 6 months if not using the process (QW-322).
- 9.3 If the welder uses the process within the 6-month period, the qualification remains valid indefinitely.
- 9.4 A separate WPQ is required for each combination of process (GTAW, FCAW-G) unless qualified on a combination procedure.
- 9.5 For production on NPS < 2-1/2, a separate qualification on small diameter pipe is required (QW-452.3).
- 9.6 All test results must be verified by a CWI or test supervisor and the NDT Level III.
- 9.7 This form is per ASME BPVC Section IX QW-484 format. API 1104 21st Edition Section 7 may also apply for pipeline applications.