


WELDER PERFORMANCE QUALIFICATION CERTIFICATE
ACCORDING TO ASME IX, Latest Edition

Welder Certificate No.:	BDDE/WQT/CERT/004-02	
Welder Name:	ABDUL ALI	
Welder ID No.:	W# 004	
Certification Date:	13 February, 2020	
WPS No.:	BDDE/WPS/CS/002	
Test Description:	<input checked="" type="checkbox"/> Test coupon <input type="checkbox"/> Production weld Size: Pipe OD 168 mm X 7.11 mm	
Specification & type/grade or UNS Number of base metal(s): ASTM A106 GR.B		

Testing Variables and Qualification Limits		
Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es)	GTAW+SMAW	GTAW+SMAW
Type (i.e. manual,semi-automatic) used	Manual	Manual
Backing (with/without)	Without	With / Without Backing
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (Enter diameter if pipe or tube)	OD 168 mm	OD ≥ 73 mm
Base metal P-Number to P-Number	1	1~15F, 34, 41~49
Filler metal or electrode specification(s)	ER70S-6 & E6013	As per F-Nos.
Filler metal F-Numbers(s)- Process 1 (GTAW)	6	6
Filler metal F-Numbers(s)- Process 2 (SMAW)	2	2, 1
Consumable inserts (GTAW or PAW)	None	Without
Filler metal Product Form (solid/metal or flux cored/powder)	Bare rods, covered electrode	Bare rods, covered electrode
Deposited thickness (mm) for Process 1 (GTAW)	3.00 mm	6.00 mm
Deposited thickness (mm) for Process 2	4.11 mm	8.22 mm
Position qualified (2G,6G,3F,etc.)	6G	Refer to Table 1
Vertical progression (uphill or downhill)	Uphill	Uphill
Type of fuel gas (OFW)	NA	NA
Inert gas backing (GTAW,PAW,GMAW)	None	With / Without Inert Backing
Transfer mode (spray/globular or pulse to circuit-GMAW)	NA	NA
Current type/polarity (AC,DCEP,DCEN)	GTAW:DCEN, SMAW:DCEP	GTAW:DCEN, SMAW:DCEP

Table 1: Position and Type weld qualified (Table QW-461.9)

Groove: Plate and Pipe OD ≥ 610 mm	Groove: Pipe OD 73 mm to 610 mm	Fillet: Plate and Pipe
All	All	All

INSPECTION & TESTING

Visual examination of completed weld (QW-302.4): Acceptable to Code
 Alternative Volumetric Examination Results (QW-191): Radiographic Examination

NON-DESTRUCTIVE TEST			
Method	Result	Report No.	Performed By
Visual Inspection	Satisfactory	NA	Bureau Veritas (Bangladesh) Private Ltd.
Radiography Test (RT)	Accept	BDDE/NCS/PQR/CS/RT/002	Nasata Contracting & Services
Other NDT Test	-----	-----	-----

DESTRUCTIVE TEST			
Method	Result	Report No.	Performed By
Side Bend (QW-462.2)	-----	-----	-----
Root Bend (QW-462.3)	Satisfactory	ME/NCS/092020/216	Technical Teachers Training College (TTTC)
Face Bend (QW-462.3)	Satisfactory	ME/NCS/092020/216	Technical Teachers Training College (TTTC)
Tension Test (QW-462.1)	Satisfactory	ME/NCS/092020/215	Technical Teachers Training College (TTTC)
Impact Test	-----	-----	-----
Macro Examination (QW-184)	-----	-----	-----
Fillet weld fracture test (QW-462.4)	-----	-----	-----
Hardness Survey	-----	-----	-----
Others	-----	-----	-----

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, Edition 2017.

Contractor	Third Party	Client / Vendor Representative
BDDE Project Solution Ltd.	Bureau Veritas (Bangladesh) Private Ltd.	Energypac Power Generation Ltd.
Name: Polak Saha	Name: Mohammed Nasir Uddin	Name:
Sign & Date:  13/02/2020 Polak Saha B.Sc. Engg. (ME) Coordinator (Design & Drafting) Bangladesh Development & Design Engineers Progoti Sarani, Middle Barida, Gulshan, Dhaka-1212	Sign & Date:  13-02-2020 	Sign & Date:  19-02-2020 