



# Fermi National Accelerator Laboratory

Technical Division-Machine Shop

## WELDER PERFORMANCE QUALIFICATION TEST REPORT

Welder's Name William Gatfield #04609 ASME No. W-12

Welding Process(es) 1st SMAW Type \_\_\_\_\_ 2nd \_\_\_\_\_ Type \_\_\_\_\_

In accordance with WPS No. CS-2

Joint: Fillet \_\_\_\_\_  Production Weld  Test Coupon

Groove: Double Welded:  Yes  No

Single Welded:  Metal Fused  Metal Non-Fused  Non-Metal  Open Root  Consumable Insert

With Solid Backing  Without Solid Backing

Base Metal: Spec. SA105 to SA105 (ASME IX) P. No. 1 to P. No. 1

Plate

Pipe

Tube

Actual Thickness 1.125 Nominal Diameter \_\_\_\_\_ Actual Diameter \_\_\_\_\_ OD \_\_\_\_\_

Qualified Range Unlimited Wt/Sch \_\_\_\_\_ Qual. Thick Range \_\_\_\_\_ Wall \_\_\_\_\_

Actual Thickness \_\_\_\_\_ Qual. Dia. Range \_\_\_\_\_ Qual. Thick Range \_\_\_\_\_

Qual. Dia. Range \_\_\_\_\_

1st Process

2nd Process

Filler: Spec. SFA 5.1 Class E7018 Spec. \_\_\_\_\_ Class \_\_\_\_\_

Dia.(s) 5/32 Dia.(s) \_\_\_\_\_

F. No. 4 F. No. \_\_\_\_\_

Deposit Thickness 1.125 Range Qual. Unlimited Deposit Thickness \_\_\_\_\_ Range Qual. \_\_\_\_\_

Position(s) (IG, etc.): 1G If Vertical Up \_\_\_\_\_ Down \_\_\_\_\_

Gas (Type and Composition): Fuel \_\_\_\_\_ Shielding \_\_\_\_\_ Root Side Backing \_\_\_\_\_

Electrical: Type Current  AC  DC - Reverse  DC - Straight

Transfer: GMAW  Spray  Globular  Pulse  Short Circuit

### FOR INFORMATION ONLY

Filler Metal Trade Name: \_\_\_\_\_

S.A.W. Flux Trade Name: \_\_\_\_\_

Shielding Gas Trade Name: \_\_\_\_\_

### MACHINE WELDING

Control:  Visual  Remote Visual

Arc Voltage Control:  Auto  Other \_\_\_\_\_

Joint Tracking:  Yes  No

### VISUAL INSPECTION

Appearance Satisfactory Undercut \_\_\_\_\_ Piping porosity \_\_\_\_\_

### GUIDED BEND TEST

TYPE AND FIGURE	RESULTS	TYPE AND FIGURE	RESULTS	TYPE AND FIGURE	RESULTS

Test Conducted by \_\_\_\_\_ Lab Test No. \_\_\_\_\_

Date \_\_\_\_\_

### RADIOGRAPHIC TEST

Results Satisfactory Per ASME IX-07 and AWS D1.1-06

Radiographer Alloyweld Inspection Company, Inc. Examiner Jennifer Anaya Level II Test No. 175214 Date 4/20/2009

### FILLET WELD TEST RESULTS

Fracture Test \_\_\_\_\_

Location, Nature, and Size of Crack or Tear in Specimen

Length of Weld \_\_\_\_\_ inch, Length of Defect \_\_\_\_\_ inch, \_\_\_\_\_ % of Defect

Macro Test: Fusion \_\_\_\_\_

Appearance: Fillet size \_\_\_\_\_ inch x \_\_\_\_\_ inch  Convex  Concave

Test Conducted by \_\_\_\_\_ Lab Test No. \_\_\_\_\_

We 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 ASME IX-2007 and AWS D1.1-06 Fermi National Accelerator Laboratory

By Jorge G. Villa

Date 5/1/2009