



Fermi National Accelerator Laboratory

Technical Division-Machine Shop

Welder Performance Qualification Record

Welder's Name	William Gatfield			FNAL #	04609N	ASME #	W-12
Welding Process:	1st	GTAW	Type	Manual	2nd	Type	
Performed in accordance with:	Fermi WPS-SS-8-001						

Joint:	Fillet:	Production Weld		Test Coupon		
Groove:	Double Welded:	Yes	No	With Solid Backing		Without Solid Backing
	Square Butt Groove	Metal Fused		Metal Non-Fused	Non-Metal	Open/closed Root Consumable Insert

Base Metal:	Specification:	SA 240, Type 304	TO	SA 240, Type 304	ASME P #8, Gp 1	TO	ASME P # 8, Gp 1
Plate		Pipe			Tube		
Actual Thickness: 0.035"		Nominal Diameter:		Actual Diameter		Overall Diameter:	
Qualified Range: 0.070 Maximum		Wt/Schedule:		Qualified Thickness Range		Wall:	
		Actual Thickness		Qualified Diameter Range:		Qualified Thickness Range:	
Qualified Diameter Range: 2.875" ϕ Minimum				Qualified Diameter Range:			

Filler:	1 st Process			2 nd Process		
	Specification: 5.9		Class: 308/308L		Specification:	
	Diameter(s): .035" & 1/16"				Diameter(s):	
	F #: 6				F #:	
	Deposit Thickness: 0.035		Range Qualification: 0.070 Maximum		Deposit Thickness:	
				Range Qualification:		

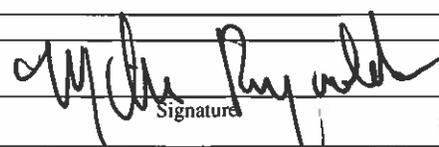
Welding Position:	IG	If Vertical:	Flat
Gas (Type & Composition):	Shielding: Argon 99.9%		Root Side Backing - Argon 99.9%
Electrical Characteristics	Type Current	AC	DCEP
	Transfer	GMAW	Spray
		DCEN	Non-Pulsing
		Globular	Pulse
			Short Circuit

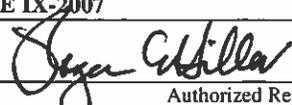
Visual Inspection			
Appearance:	Satisfactory	Undercut:	None Visually Observed
Piping Porosity:	None Visually Observed		

Guided Bend Test QW 462.3					
Tensile	Fracture/Results	Type and Figure	Results	Type and Figure	Results
001 Cross Weld	Haz/Ductile	003 Face Bend	Pass	005 Root Bend	Pass
002 Cross Weld	Weld Ductile	004 Face Bend	Pass	006 Root Bend	Pass
Test Conducted by:			Reference #: T914242	Date: 12/07/2009	

Radiographic Test			
Results: Satisfactory		Per ASME IX-2007	
Radiographer:	Examiner:	Register #	Date:

Fillet Weld Test Results			
Fracture Test:			
(Location, Nature, and size of Crack or Tear in Specimen)			
Length of Weld:	Length of Defect:	Percent of Defect	
Macro Test: Fusion			
Appearance: Fillet Size	inch X	inch	<input type="checkbox"/> Convex <input type="checkbox"/> Concave
Test Conducted by:		Lab Test #:	

Test Verified by:		Verification Report #11272009-1-RH	11/27/2009
Mike Reynolds 03993N	Signature		

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		Fermi National Accelerator Laboratory	
By: Roger Hiller 00362N		Date:	12/7/2009
		Authorized Representative	