Fermilab

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" Ø Minimum*			Qualified Diameter Range:

Filler:	**1st Process**		**2nd Process**	
	Specification: *5.9*	Class: *308/308L*	Specification:	Class:
	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: *1G*	If Vertical: *Flat*					
Gas (Type & Composition:	Shielding: *Argon 99.9%*			Root Side Backing - *Argon 99.9%*		
Electrical Characteristics	Type Current	~~AC~~	~~DCEP~~	*DCEN*	*Non-Pulsing*	
	~~Transfer GMAW~~	~~Spray~~		~~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	☐ Convex	☐ Concave
Test Conducted by:		Lab Test #:	

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

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 Authorized Representative	Date: *12/7/2009*