



# 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-9-001					

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: 0.105"	Nominal Diameter:	Actual Diameter			Overall Diameter:		
Qualified Range: 0.210"	Wu/Schedule:	Qualified Thickness Range			Wall:		
		Actual Thickness	Qualified Diameter Range:			Qualified Thickness Range:	
Qualified Diameter Range: 2.875" $\emptyset$ Minimum				Qualified Diameter Range:			

Filler:	1 <sup>st</sup> Process			2 <sup>nd</sup> Process		
	Specification: 5.9	Class: 308/308L		Specification:	Class:	
	Diameter(s): .035" & 1/16"			Diameter(s):		
	F #: 6			F #:		
	Deposit Thickness: 0.105"			Range Qualification: 0.210 Maximum		Deposit Thickness: Range Qualification:

Welding Position:	IG	If Vertical:	Flat	Root Side Backing - Argon 99.9%		
Gas (Type & Composition):	Shielding: Argon 99.9%		Non-Pulsing			
Electrical Characteristics	Type Current	AC	DCSP	DCEN		
	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	Haz/Ductile	004 Face Bend	Pass	006 Root Bend	Pass
Test Conducted by: Exova			Reference #: T914243	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: Roger Hiller, 00362N	Verification Report #	11/27/2010
	11272009-2RH	
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		
By: Roger Hiller 00362N		Date: 1/15/2010
Authorized Representative		