



Fermi National Accelerator Laboratory

Technical Division-Machine Shop

Welder Performance Qualification Record

Welder's Name	James M. O'Neill			FNAL #	05066N	ASME #	W-1
Welding Process:	1st	GTAW	Type	Manual	2nd	Type	
Performed in accordance with:				Fermi WPS-SS-9-002			

Joint:	Fillet:	Production Weld		Test Coupon		
Groove:	Double Welded:	Yes	No			
	<i>Single Welded</i>	Metal Fused	Metal Non-Fused	Non-Metal	Open Root	Consumable Insert
		<i>With Solid Backing</i>	<i>Without Solid Backing</i>			

Base Metal:	Specification:	SA 213, Type 304/304L	TO	SA 213, Type 304/304L	ASME P #8, Gp 1	TO	ASME P # 8, Gp 1
Plate	Pipe			Tube			
Actual Thickness:	Nominal Diameter:	Actual Diameter		Overall Diameter: 0.500"			
Qualified Range:	Wt/Schedule:	Qualified Thickness Range		Wall: 0.095"			
	Actual Thickness	Qualified Diameter Range		Qualified Thickness Range: 0.190" Maximum			
				Qualified Diameter Range: 0.500" Minimum			

Filler:	1st Process			2nd Process		
	Specification: 5.9	Class: 308/308L		Specification:	Class:	
	Diameter(s): .045, 1/16, 3/32			Diameter(s):		
	F #: 6			F #:		
	Deposit Thickness: 0.095	Range Qualification: 0.190 Maximum		Deposit Thickness:	Range Qualification:	

Welding Position: 6G	If Vertical: Uphill Down	
Gas (Type & Composition):	Shielding: Argon 99.9%	Root Side Backing - Argon 99.9%
Electrical Characteristics	Type Current	AC <input type="checkbox"/> DCEP <input type="checkbox"/> DCEN <input type="checkbox"/>
	Transfer: GMAW	Spray <input type="checkbox"/> Globular <input type="checkbox"/> Pulse <input type="checkbox"/> Short Circuit <input type="checkbox"/>

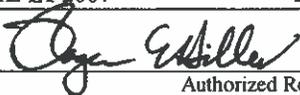
Visual Inspection			
Appearance: Satisfactory	Undercut: None	Piping Porosity: None	

Guided Bend Test					
Type and Figure	Results	Type and Figure	Results	Type and Figure	Results
Test Conducted by:			Lab Test #:	Date:	

Radiographic Test			
Results: Satisfactory		Per ASME IX-2007 and AWS D1.1-06	
Radiographer: Alloyweld Inspection Co., Inc.	Examiner: Jennifer Anaya-Level II	Register # 5088	Date: 5/24/2010

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 #5112010-1-RH	 Signature
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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:	6/7/2010
Authorized Representative			