



# Fermi National Accelerator Laboratory

Technical Division-Machine Shop

## Welder Performance Qualification Record

Date  
2/20/2009

In accordance with Fermi WPS Ti-5

Revision: 2      Revision Date : 6/25/2009      Remarks: Clerical corrections

<b>Welders Name:</b> Michael P. Reynolds	<b>Fermi ID#</b> 03993N	<b>Weld Stamp #</b> 9
<b>WPS Number:</b> Fermi WPS Ti-5	<b>Test Coupon</b>	<b>Production Weld</b>
<b>Welding Process/Type:</b> GTAW/Orbital	<b>Type of Joint Welded:</b> Pipe Groove Weld	
<b>Joint Types Qualified:</b> Groove and Fillet Welds-Autogenous ---AMI Orbital Machine Model 227-STD1.9		
<b>Base Metals Welded:</b> SB-861, Grade 2 to SB-861, Grade 2		

Welder Variables (QW-350)	Actual Variables Used	Range Qualified
<b>AWS Classification:</b>	ERTi-2	Qualified to weld any Qualified GTAW/Automatic WPS
<b>Filler Metal Specification (SFA)</b>	N/A	
<b>Filler Metal F-No.</b>	N/A	
<b>Filler Metal Product Form</b>	N/A	
<b>Consumable Insert</b>	No Insert Used	
<b>P- or S- Number to P- or S- Number:</b>	P-No. 51 to P-No. 51	
<b>Base Metal Thickness (inches):</b>	0.078"	
<b>Pipe Diameter (inches):</b>	3"	
<b>Deposit Thickness (inches)</b>	0.078"	
<b>Welding Position/Progression</b>	5G	
<b>Backing Gas</b>	Argon Backing Gas Used	
<b>GTAW-Current/Polarity</b>	DCEN	

Machine Welding Variables (QW-360)	Actual Variables	Range Qualified
<b>Direct/Remote Visual Control</b>	N/A	N/A
<b>Automatic Voltage Control</b>	N/A	N/A
<b>Automatic Joint Tracking</b>	N/A	N/A
<b>Welding Position</b>	N/A	N/A
<b>Consumable Insert</b>	N/A	N/A
<b>Backing</b>	N/A	N/A
<b>Single/Multiple Pass Per Side</b>	N/A	N/A

**Fillet Welds:** All within WPS Limits

<b>Guided Bend Test (QW-160)</b>	Face Bend #1-Acceptable Face Bend #2-Acceptable	Root Bend # 1-Acceptable Root Bend # 2-Acceptable	Bend Test Conducted by Bodycote Testing Group	Test Number
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**Visual examination results:** Visual exam satisfactory per QW-302.4 and QW-194

**Radiographic test results:** N/A

**Mechanical tests conducted by:** Bodycote Testing Group      Test Number 0302-09/01

**Welding of Test Coupon conducted by:** Fermi National Accelerator Laboratory      Verification Number 22009-RH

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code and AWS D1.9/D1.9M:2007

Fermi National Accelerator Laboratory

Authorized Representative

00362N  
Ferm ID #