

Fermilab *Fermi National Accelerator Laboratory*
 Technical Division-Machine Shop

Welder Performance Qualification Record Date 9/21/2009
In accordance with Fermi WPS Ti-7

Revision 0 Revision Date Remarks:

Welders Name: Michael P.Reynolds **Fermi ID#** 03993N **Weld Stamp #** 9
WPS Number: Fermi WPS Ti-7 **Test Coupon** PRN 122717 **Production Weld** N/A
Welding Process/Type: GTAW/Orbital **Type of Joint Welded:** Pipe Groove Weld
Joint Types Qualified: Groove and Fillet Welds-Autogenous ---AMI Orbital Machine Model 227-STD1.9
Base Metals Welded: ASTM B-861, Grade 2 to ASTM B-861, Grade 2

Welder Variables (QW-350)	Actual Variables Used	Range Qualified
AWS Classification:	ERTi-2	N/A
Filler Metal Specification (SFA)	N/A	N/A
Filler Metal F-No.	N/A	N/A
Filler Metal Product Form	N/A	N/A
Consumable Insert	No Insert Used	Without Insert Only
P- or S- Number to P- or S- Number:	P-No. 51 to P-No. 51	P-No. 51, 52, 53, 61, 62
Base Metal Thickness (inches):	0.109"	WPS Limit
Pipe Diameter (inches):	2"	1" and up
Deposit Thickness (inches)	0.109"	0.218"
Welding Position/Progression	5G	All
Backing Gas	Argon Backing Gas Used	With Backing Gas Only
GTAW-Current/Polarity	DCEN	DCEN -Pulsing

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

Fillet Welds: All within WPS Limits

Guided Bend Test (QW-160)	Face Bend #1-Acceptable Face Bend #2-Acceptable	Root Bend # 1-Acceptable Root Bend # 2-Acceptable	Bend Test Conducted by Exova Testing Group	Test Number T910488
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Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194

Radiographic test results: Acceptable **Radiographic Test by:** Alloyweld Inspection Inc. Register #528 PRN122717

Mechanical tests conducted by: Exova Testing Group **Test Number** T 910488 **PRN** 123110

Welding of Test Coupon conducted by: Fermi National Accelerator Laboratory **Verification Number** 9142009-1RH

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 D1.9/1.9M-2007.

Fermi National Accelerator Laboratory  00362N  9/21/2009 Date
 Authorized Representative