

Welding Procedure Number Followed
MANGO Welding Procedure NO. 1
Reference Procedure Qualification Record No. : MANGO1104 1-1 through 1-13 (04-25-00)

Date: _____ Welder's I.D. Mark: _____
 Welder: _____ Employee # : _____
 Contractor/Company: _____ Test Location: _____
 Certifying Company: _____

Test Pipe/Fitting Material and Test Conditions for Welder Qualification

Ambient Test Temp.: _____ Weather conditions: _____ Type of Machine: _____
 Butt Weld Material Grade: _____ Branch Weld Material Grade: _____
 Butt Weld Pipe Dia. / W. T.: _____ Branch Weld Pipe Dia. / W. T.: _____
 Direction of Welding: _____ Direct Current Reverse Polarity /EP _____
 Position of Butt Weld Test Sample: _____
 Position of Branch Weld Test Sample: _____

Welding Parameters and Electrical Characteristics

Pass No.	Process	Filler Material		Electrical Characteristics		Time Between Passes	Travel Speed (IPM)	Cleaning Method	
		Size	Classification	Amperage	Voltage				

Butt Weld

1									
2									
3									
4									
5									

Branch Weld

Pass No.	Process	Filler Material		Electrical Characteristics		Time Between Passes	Travel Speed (IPM)	Cleaning Method	
		Size	Classification	Amperage	Voltage				

1									
2									
3									
4									
5									

Preheat: _____ Postheat: _____

Check here if voltage is measure across the terminals of welding machine

NOTES:
