

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:

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Welder:

Visual Inspection Results per API 1104, Twentieth Edition						
Butt Weld	Pass		Fail		Notes:	
Branch Weld	Pass		Fail			
Inspector:			Date:			
Destructive Test Results per API 1104, Twentieth Edition, Appendix B						
_____ " Butt Weld						
Tensile Tests						
Specimen	Width	Thickness	Area	Max Load (Lbs.)	U.T.S.	Fracture Location
T-1						
T-2						
						ie Base Material
Face Bend Tests		Root Bend Test _____ " Butt Weld		Nick-Break Tests _____ " Butt Weld		
Specimen	Results	Specimen	Results	Specimen	Results	
FB-1		RB-1		NB-1		
FB-2		RB-2		NB-2		
Fillet Weld Nick-Break Tests _____ " x _____ " Branch Weld						
Specimen	Results		Specimen	Results		
NB-1			NB-5			
NB-2			NB-6			
NB-3			NB-7			
NB-4			NB-8			
<p>Tested by: _____</p> <p>Acceptable Date: _____ Unacceptable Date: _____</p> <p>6 Month Requalification Due Date: _____</p> <p>Additional Information: _____</p>						