

Welder Qualification Form

Initial / Requalification

(circle one)

Welding Procedure Number Followed MANGO Welding Procedure NO. 2 - LH Rev. 11/5/15 Reference Procedure Qualification Record No. : MANGO#2LH-11/9-10/2015									
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:			
Test Pipe Material Grade:						Sleeve Material Grade:			
Test Pipe Dia. / W. T.:						Sleeve Material WT.:			
Direction of Welding:						Direct Current Reverse Polarity /EP:			
Position of Test Weld Sample:			45° Angle Seam @ 1:30 & 7:30						
Initial Qualification Test Conducted with Water Flowing Through Test Pipe <input type="checkbox"/>									
Welding Parameters and Electrical Characteristics									
Pass No.	Process	Filler Material		Electrical Characteristics		Minimum Heat Input (kJ/in)	Time Between Passes	Travel Speed (IPM)	Cleaning Method
		Size	Classification	Amperage Range	Voltage Range				
Seam Weld Side 1 or 2									
1									
2									
3									
4									
5									
Top Fillet Weld Side 1 or 2									
1									
2									
3									
4									
5									
Bottom Fillet Weld Side 1 or 2									
1									
2									
3									
4									
5									

Preheat: _____

Postheat: _____

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

Note: Heat Input (kJ/in) = (Amps x Volts x 60) / [Travel Speed (in/Min) x 1000]

Welder Qualification Data Report

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Welder:

Visual Inspection Results per API 1104, Twentieth Edition						
Pass			Fail			
Inspector:			Date:		Notes:	
Destructive Test Results per API 1104, Twentieth Edition, Appendix B						
Seam 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		Nick-Break Tests		
Specimen	Results	Specimen	Results	Specimen	Results	
FB-1		RB-1		NB-1		
FB-2		RB-2		NB-2		
Fillet Weld Nick-Break Tests						
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>						