



Dos Ref: L4-WI-023

J-PECO XXXXXXXX
XXXXXXXX XXXXXXXX

Welding Procedure Qualification Record

An Hui Ji Peng Project
Supervision and Consulting
Co.,Ltd
Floor 16th, FuSi Center, West
Train Station, Shu Shan
District,
He Fei City, An Hui Province,
PRC.230001
Tel: +86 551 63524022

INSERT CLIENT NAME - WELDING PROCEDURE QUALIFICATION RECORD

(QW-201.2 Section QW-483)

Procedure No.:

WPS No.:

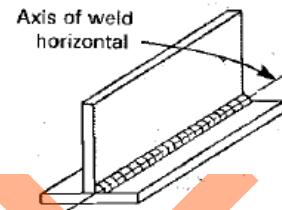
Welding Process(es):

Type (Manual, Automatic, Semi auto):

Date:

JOINTS (QW-402)

Joint Design :
Backing :
Test coupon :



BASE METAL (QW-403)

P.No. 1 Group No.1 to P.No.1 Group No.1
Material Specification :
Thickness of test coupon : Diameter of test coupon :
Heat No. (Pipe) :
Heat No. (Flanges) :

FILLER METAL (QW-404)

F No:
A No:
Specification No.(SFA)
AWS No.(Class)
Brand Name (ESAB)
Size of filler wire/ Electrode
Electrode Flux class

POST WELD HEAT TREATMENT (QW-407)

Temp. Range :
Holding Time :

GAS (QW-408)

Gas
Torch flow rate
Back purging
Other:

ELECTRICAL CHARACTERISTICS (QW-409)

Current
Polarity
Amperage
Voltage
Tungsten Electrode size

TECHNIQUE (QW-410)

String or Weave Bead
Max. Weave width
Initial and Inter pass
Cleaning Method
Multiple or Single Pass
Multiple/ Single Electrodes

POSITION (QW-405)

Positions of Groove :
Welding Progression :

PREHEAT (QW-406)

Preheat Temp.
Inter-pass Temp. Max
Preheat Maintenance



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WPS No.:

TENSILE TEST (QW-150)

Mark	Type	Dimensions (mm)	Area (mm ²)	UTL (kN)	UTS (N/mm ²)	Fracture Position	Comments Location

BEND TEST (QW-160)

Mark	Type	Bend Angle	Former diameter	Result	Comments /Location

MACRO EXAMINATION (QW-180)

Mark	Type	Position	Results	Comments
	Weld section			

HARDNESS SURVEY (VICKERS - 10 Kg LOAD)

Location	Spacing	TOP			BOTTOM			Maximum value
		1	2	3	1	2	3	

CHARPY IMPACT TEST

Mark	Location	Dimensions	Temperature	Absorbed Energy (Joules)	Average (J)	Comments

POSTWELD HEAT TREATMENT - Report No.

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RADIOGRAPHIC TEST - Report No.

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Welder/s Name & ID No. :

Mech. Tests conducted by:

Dye penetrant done by:

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of ASME code.

Technical Manager:

Date:

For Client