Alaska Piledrivers Local 2520 JATC
825 E. 8th Ave.
Anchorage, AK 99501

Welder or Welding Operator Performance Qualification (WPQ)

Welder's Name: **Jackson, Adam** Stamp: **1191-96** Welder ID: **1191-96**

Test WPS No.: **RC-SMAW-7018-B31 & ASME** Rev.: **0** WPQ No.: **PD11-009** Date: **1/14/2011**

Welding process(es) / type(s) used: SMAW / Manual and SMAW / Manual

Type of joint welded: Pipe Groove weld Joint type(s) qualified: Groove and Fillet Welds

Base metal(s) welded: SA-106, Grade B to SA-106, Grade B

Welder Variables (QW-350)	**Actual Values Used**		**Range Qualified**	
P- or S-Number to P- or S-Number	P-No. 1 to P-No. 1		P-1 thru P-11,P-34 & P-4X	
Base metal thickness (in.)	0.432		Unlimited	
Pipe diameter (in.)	6.625		2.875" minimum	
	SMAW / Manual	**SMAW / Manual**	**SMAW / Manual**	**SMAW / Manual**
Backing **	No backing used	Backing used	With or without backing	With backing only
AWS classification	E6010	E7018		
Filler metal specification (SFA)	5.1	5.1	5.xx	5.xx
Filler metal F-No.	3	4	F 3 (F 1 - F 2 w/backing)	F-No. 1 to F-No. 4
Filler metal product form	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Deposit thickness (in.) [>= 3 layers]	0.182 [N/A]	0.25 [N/A]	0.3640" maximum	0.5000" maximum
Welding position	6G - 45 degree pipe	6G - 45 degree pipe	All Positions	All Positions
Weld progression	Vertical down	Vertical up	Vertical down (n4)	Vertical up (n4)
Backing gas	N/A	N/A	N/A	N/A

Machine Welding Variables (QW-360)	**Actual Values Used**		**Range Qualified**	
Direct / remote visual control	N/A	N/A	N/A	N/A
Automatic voltage control	N/A	N/A	N/A	N/A
Automatic joint tracking	N/A	N/A	N/A	N/A
Welding position	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Backing **	N/A	N/A	N/A	N/A
Single / multiple pass per side	N/A	N/A	N/A	N/A

Fillet Welds: Qualified to make fillet welds of any size on all base material thicknesses and pipe diameters of any size.

** Welds with backing include fillets and double-welded groove welds.

Notes: (n4) The root pass, when removed to sound weld metal in preparation for welding the second side, and the cover or wash pass may be up or down.

Guided Bend Test (QW-160)

Figure Number and Type	Result	Figure Number and Type	Result
None		None	
None		None	
None		None	

Visual examination results: Visual Exam satisfactory per QW302.4 and QW194

Radiographic test results: Acceptable Per QW-302.2 and QW-191

Welding test conducted by: Alaska Piledrivers & Divers Local 2520 JATC

Mechanical/Radiographic tests conducted by: Alaska Industrial X-Ray Lab test no.: PD11-009

We certify that the statements in this record are correct and that the test c TC requirements of Section IX of the ASME code.

Certified By: Kevin Hanley

KEVIN B. HANLE
CWI 0111125
EXP. 11/

Submittal/Shop Drawing Review

APPROVED
NO EXCEPTIONS TAKEN

By: John F. Conway, Sr. Project Manager
Conway Management Group, LLC
jconway@conwaymgt.net
4721 Haru Ln, Anchorage, AK 99517
(907) 243-0656, FAX (907) 243-2078

Alaska Industrial X-ray Inc.
4047 Kingston Drive
Anchorage, Alaska 99504
907-344-4061 Fax 349-3875

Customer: Piledrivers
Address: 825 E. 8th Ave.
Anchorage, Alaska 99501

P.O. No. PD11-010
Date: 1/14/2011
Report No. AIX-001
Description: Welder Qualification
Page: 1 of 1

IDENTIFICATION	WELD NO.	VIEW	ACC.	REJ.	REMARKS	DEFECT CODE
Adam Jackson	AJ	0-1	✓			
Welder ID 1191-96	6G	1-2	✓			P-Porosity
PD11-009		2-3	✓			GP-Gas Pocket
		3-0	✓			SP-Spherical Porosity
						CP-Cluster Porosity
						WP-Wormhole Porosity
						HB-Hollow Bead
						C-Crack
						CC-Crater Crack
						IF-Incomplete Fusion
						IFD-Incomplete Fusion due to Cold Lap
						IU-Internal Undercut
						EU-External Undercut
						IP-Incomplete Penetration due to High-Low
						BT-Burn Through
						S-Slag Lines
						ESI-Elongated Slag Inclusions
						ISI-Isolated Slag Inclusions
						TI-Tungsten Inclusion
						CV-Root Concavity
						CX-Root Convexity
						LR-Low Reinforcement

TECHNIQUE DATA

Acceptance Code/STD: ASME - Section IX 2010
R.T. Procedure: 6" XS
Source: Ir-192 Focal Spot Size: .145"
Material Thickness: .432" SFD: 7"
Film Type: AGFA D4 No. 1 Size: 4.5"x 10'
SWE DWE XX SWV XX DWV

Technician: Peter Millar Level: III
Technician: Joe Krivenko Level: II
Film Inter.: Don Millar Level: III

Customer: Piledrivers

AIX INC.- assumes no responsibility for losses of any kind which are the result of decisions of judgment or interpretation.

Piledrivers & Divers Local 2520
825 East 8th Avenue
Anchorage, Alaska 99501
907-272-7577

Welder Certification Card

Be it known that

Adam Jackson

Has successfully qualified to perform within the categories defined on the back of this card

Welding Inspectors Signature

January 14, 2011 — Date

Anchorage, Alaska — Location

Welder/Welding Operator Certification Record

		Inspector's Initials
Procedure:	RC-SMAW-7018-B3	RY
Process:	SMAW Open Root	RY
Code:	ASME	RY
Position(s):	6G	RY
Pipe/Plate:	Pipe-6.625"	RY
Thickness:	.432"	RY

U-1191-9683
Welder's UBC No.

Welder's Signature

Piledrivers & Divers Local 2520
825 East 8th Avenue
Anchorage, Alaska 99501

Welder or Welding Operator Performance Qualification (WPQ)

Welder's Name: **Stewart, Doug** Stamp: **3635-7602**

Test WPS No.: **BIC #11** Rev.: **0** WPQ No.: **WPQ-BIC #11** Date: **5/23/2011**

Welding process(es) / type(s) used: SMAW / Manual and SMAW / Manual

Type of joint welded: Pipe Groove weld Joint type(s) qualified: Groove and Fillet Welds

Base metal(s) welded: SA-106, Grade B to SA-106, Grade B

Welder Variables (QW-350)	**Actual Values Used**		**Range Qualified**	
P- or S-Number to P- or S-Number	P-No. 1 to P-No. 1		P-1 thru P-15F,P-34 & P-4X	
Base metal thickness (in.)	0.432		WPS Limits	
Pipe diameter (in.)	6.625		2.875" minimum	
	SMAW / Manual	**SMAW / Manual**	**SMAW / Manual**	**SMAW / Manual**
Backing **	No backing used	Backing used	With or without backing	With backing only
AWS classification	E6010	E7018		
Filler metal specification (SFA)	5.1	5.1	5.xx	5.xx
Filler metal F-No.	3	4	F 3 (F 1 - F 2 w/backing)	F-No. 1 to F-No. 4
Filler metal product form	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Deposit thickness (in.) [>= 3 layers]	0.093 [N/A]	0.339 [N/A]	0.1860" maximum	0.6780" maximum
Welding position	6G - 45 degree pipe	6G - 45 degree pipe	All Positions	All Positions
Weld progression	Vertical down	Vertical up	Vertical down (n4)	Vertical up (n4)
Backing gas	N/A	N/A	N/A	N/A

Machine Welding Variables (QW-360)	**Actual Values Used**		**Range Qualified**	
Direct / remote visual control	N/A	N/A	N/A	N/A
Automatic voltage control	N/A	N/A	N/A	N/A
Automatic joint tracking	N/A	N/A	N/A	N/A
Welding position	N/A	N/A	N/A	N/A
Consumable insert	N/A	N/A	N/A	N/A
Backing **	N/A	N/A	N/A	N/A
Single / multiple pass per side	N/A	N/A	N/A	N/A

Fillet Welds: Qualified to make fillet welds of any size on all base material thicknesses and pipe diameters of any size.
** Welds with backing include fillets and double-welded groove welds.
Notes: (n4) The root pass, when removed to sound weld metal in preparation for welding the second side, and the cover or wash pass may be up or down.

Guided Bend Test (QW-160)

Figure Number and Type	Result	Figure Number and Type	Result
QW-462.3(a) Face bend	Satisfactory	QW-462.3(a) Root bend	Satisfactory
QW-462.3(b) Face bend	Satisfactory	QW-462.3(b) Root bend	Satisfactory
QW-462.2 Side bend	Satisfactory	QW-462.2 Side bend	Satisfactory

Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194

Volumetric test results: None

Welding test conducted by: Kevin Hanley - AWS CWI 01111251

Mechanical/Radiographic tests conducted by: Alaska Industrial X-Ray Lab test no.: PD11-144

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 the ASME Code.

Organization: Piledrivers & Divers Local 2520 JATC

Certified By: Kevin Hanley Kevin B Hanley CWI 01111251 QC1 EXP. 11/1/2013 5/24/11 Certified Welding Inspector

Date

Alaska Industrial X-ray Inc.
4047 Kingston Drive
Anchorage, Alaska 99504
907-344-4061 Fax 349-3875

Customer: Piledrivers
Address: 825 E. 8th Ave.
Anchorage, Alaska 99501

P.O. No. PD11-144
Date: 5/24/2011
Report No. AIX-001
Description: Welder Qualification
Page: 1 of 1

IDENTIFICATION	WELD NO.	VIEW	ACC	REJ.	REMARKS
Doug Stewert	DS	0-1	✓		
U-3635-7602	6G	1-2	✓		
PD11-144		2-3	✓		CP
		3-0	✓		

DEFECT CODE

P-Porosity
GP-Gas Pocket
SP-Spherical Porosity
CP-Cluster Porosity
WP-Wormhole Porosity
HB-Hollow Bead
C-Crack
CC-Crater Crack
IF-Incomplete Fusion
IFC-Incomplete Fusion due to Cold Lap
IU-Internal Undercut
EU-External Undercut
IP-Incomplete Penetration due to High-Low
BT-Burn Through
SL-Slag Lines
ESI-Elongated Slag Inclusions
ISI-Isolated Slag Inclusions
TI-Tungsten Inclusion
CV-Root Concavity
CX-Root Convexity
LR-Low Reinforcement

TECHNIQUE DATA

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Material Thickness: .432" SFD: 7"
Film Type: AGFA D4 No. 1 Size: 4.5"x 10"
SWE DWE XX SWV XX DWV

Technician: Don Millar Level: III
Technician: Ryan Hanley Level: I
Film Inter.: Don Millar Level: III

Customer: Piledrivers

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825 East 8th Avenue
Anchorage, Alaska 99501
907-272-7577

Welder Certification Card

Be it known that

Doug Stewart

Has successfully qualified to perform within the categories defined on the back of this card.

Welding Inspectors Signature

May 23, 2011 — Date

Anchorage, Alaska — Location

Welder/Welding Operator Certification Record

		Inspector's Initials
Procedure:	BIC #11	KH
Process:	SMAW Open Root	KH
Code:	ASME	KH
Position(s):	6G	KH
Pipe/Plate:	Pipe-6.625"	KH
Thickness:	.432"	KH

AWS QC1 KEVIN HANLEY 01111251 CWI

U-3635-7602
Welder's UBC No.

Welder's Signature