



# Fermi National Accelerator Laboratory

Technical Division-Machine Shop

## Welder Performance Qualification Record

Welder's Name	Daniel Watkins			FNAL #	03991N	ASME #	W-24
Welding Process:	1st	GTAW	Type	Manual	2nd	Type	
Performed in accordance with:	Fermi WPS-SS-8-001						

Joint:	Fillet:	Production Weld		Test Coupon		
Groove:	Double Welded:	Yes	No			
	Single Welded:	Metal Fused	Metal Non-Fused	Non-Metal	Open Root	Consumable Insert
		With Solid Backing	Without Solid Backing			

Base Metal:	Specification:	SA 213, Type 304/304L	TO	SA 213, Type 304/304L	ASME P #8, Gp 1	TO	ASME P # 8, Gp 1
Plate	Pipe			Tube			
Actual Thickness:	Nominal Diameter:	Actual Diameter		Overall Diameter: 0.250"			
Qualified Range:	Wt/Schedule:	Qualified Thickness Range		Wall: 0.035"			
	Actual Thickness	Qualified Diameter Range:		Qualified Thickness Range: 0.070" Maximum			
				Qualified Diameter Range: 0.250" Minimum			

Filler:	1 <sup>st</sup> Process			2 <sup>nd</sup> Process	
	Specification: 5.9	Class: 308/308L		Specification:	Class:
	Diameter(s): .035			Diameter(s):	
	F #: 6			F #:	
	Deposit Thickness: 0.035	Range Qualification: 0.070 Maximum		Deposit Thickness:	Range Qualification:

Welding Position: 6G	If Vertical: Uphill	Down			
Gas (Type & Composition):	Shielding: Argon 99.9%		Root Side Backing - Argon 99.9%		
Electrical Characteristics	Type Current	AC	DCEP	DCEN	
	Transfer: GMAW	Spray	Globular	Pulse	Short-Circuit

Visual Inspection					
Appearance:	Satisfactory	Undercut:	None	Piping Porosity:	None

Guided Bend Test					
Type and Figure	Results	Type and Figure	Results	Type and Figure	Results
Test Conducted by:			Lab Test #:	Date:	

Radiographic Test			
Results: Satisfactory		Per ASME IX-2007	
Radiographer: Alloyweld Inspection Co., Inc.	Examiner: Jennifer Anaya-Level II	Register #	Date:

Fillet Weld Test Results			
Fracture Test:			
(Location, Nature, and size of Crack or Tear in Specimen)			
Length of Weld:	Length of Defect:	Percent of Defect	
Macro Test: Fusion			
Appearance: Fillet Size	inch X	inch	<input type="checkbox"/> Convex <input type="checkbox"/> Concave
Test Conducted by:		Lab Test #:	

Test Verified by: Roger Hiller, 00362N	Verification Report #	Signature
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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 ASME IX-2007		Fermi National Accelerator Laboratory	
By: Roger Hiller 00362N	Authorized Representative		Date: