

Welder's name ID Number Date of birth Stamp number Company name Division	Jeong Jeonggil FCW001		Test date WPC record number Standard test number WPS record number Qualification code	11/11/2024 2527511 - 25294A ASME Section IX	Rev. Rev.
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Welded to	Product form	Specification (type or grade)	Pres.	Gr-no.	Size	Sch.	Thick.	Ex 1 Dia.	Ex 2
	Plate	Plate	SA-106 (B) A56 (UNS K02000)	1	1	1	80	0.178 0.500	1.315

Type of weld joint Base metal	Actual values			RANGE QUALIFIED		
	Pipe to Pipe - Fillet	Pipe to Pipe - Fillet			Fillet welds	

BASE METAL THICKNESS	Process	Fillet	Overlay	Process	Fillet	Overlay
	Plate thickness (in.)	-	-	-	-	60 limit
Pipe/Tube thickness (in.)	-	0.178	-	-	60 limit	-
Pipe diameter (in.)	-	1.315	-	-	1	-

PROCESS VARIABLES	Actual values			RANGE QUALIFIED		
	Welding process	GTAW		GTAW		
Type	Manual		Manual			
Backing	With		With			
Filler metal specification	E 718		E 718			
Filler metal classification	ER71S-G		Any			
Filler metal F-number	6		6			
Filler metal variety (QW-404.23)	Base (solid)		Solid, metal cored			
Consumable insert	None		Without			
Weld deposit thickness (in.)	0.178		0.178 max. Fillet			
Weld position	2F					
						FH
						FH
						FH
Progression	Without		With, without			
Backing gas	Without		DCEN (straight polarity)			
GTAW welding current/polarity	DCEN (straight polarity)					

TESTS	Type of test	Acceptance criteria	Result	Comments
Fillet weld macro test per QW-181.2 and QW-462.4(c) Fillet weld fracture test per QW-181.2 and QW-462.4(c)		QW-181	Acceptable	see - ASME IX - QW-452.5
		QW-182	Acceptable	see - ASME IX - QW-452.5

*Joseph A. Moore*  
 Joseph A. Moore  
 CWI, CSWIP, ISO 9001  
 QCC, EXP 10/21/2025

Notes: Qualified conformance with PQR/WPS 25294A

CERTIFICATION		
Tests conducted by	Proton Russell Moore Weld Professional Services	Laboratory test number
Mechanical tests by		Test file number

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

Signature 1		Signature 2	
Name	Signature	Name	Signature
Date		Date	