



**ATLANTIC STEAM**  
 5 SILVER PARK, SILVER STREET, BRACKENFELL, 7560  
**ASME IX - Welder Performance Qualification (WPQ)**  
 Welderqual

Welder's name	R.RABIE	Test date	2017/11/13
ID Number	7009155186087	WPQ record number	ATLANTIC -2017-2
Date of birth	1970/09/15	Standard test number	-
Stamp number	RR	WFS record number	ATST001SS
Company name	ATLANTIC STEAM	Qualification code	ASME Section IX
Division	WELDING		

BASE METALS							
	Product form	Spec. (Type or Grade), UNS #	P no.	Grp-no.	Size	Sch.	Thick. mm Dia. mm
Welded to:	Pipe	SA-358 (316), UNS S31600	8	1	38.10	40	3.68 48.26
	Pipe	SA-358 (316), UNS S31600	8	1	38.10	40	3.68 48.26
Joint type	Groove						

VARIABLES		Actual values		RANGE QUALIFIED	
Type of weld joint		Pipe - Groove		Groove and Fillet welds	
Base metal		P8 to P8		P-no. 1 thru 15F, 34, 41 thru 49	

BASE METAL THICKNESS							
		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness	mm	-	-	-	no limit	no limit	-
Pipe/tube thickness	mm	3.68	-	-	no limit	no limit	-
Pipe diameter	mm	48.26	-	-	25.4 min	no limit	-

VARIABLES		Actual values		RANGE QUALIFIED	
Welding process		GTAW		GTAW	
Type		Manual		Manual	
Backing		No backing used		With, without	
Filler metal specification				5.xx	
Filler metal classification		ER316L		Any	
Filler metal F-number		6		6	
Filler metal variety (QW-404.23)		Bare		Bare	
Consumable insert		None		Without	
Number of layers deposited		2			
Weld deposit thickness	mm	3.68		7.36 max	
Weld position (Actual position tested)		6G			
Groove - Plate & Pipe > 610mm				All	
Groove - Pipe 73mm to 610mm				All	
Groove - Pipe < 73mm				All	
Fillet - Plate & Pipe > 610mm				All	
Fillet - Pipe 73mm to 610mm				All	
Fillet - Pipe < 73mm				All	
Progression		Up		Up	
Backing gas		Without		With, without	
Welding current/polarity		DCSP		DCSP	

TESTS		Type of test	Acceptance criteria	Result	Comments
		RT per QW-191 and QW-302.2 Visual examination per QW-302.4	QW-191.2 QW-194	Acceptable Acceptable	see - see ASME IX - QW-142/3, QW-304 see - ASME IX - QW-452.1 (a)

Notes: SEE RT REPORT : 26996- RT 03

CERTIFICATION			
Tests conducted by	RITC (Pty) Ltd	Laboratory test number	-
Mechanical tests by	-	Test file number	26996- RT 03

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.

INSPECTION AUTHORITY		CLIENT	
Name	Signature	Name	Signature
RITC (Pty) Ltd		ATLANTIC STEAM	
Date		Date	
2017/11/23		2017/11/23	
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	