

WELDER QUALIFICATION TECHNIQUE SHEET (SAMPLE)

PROCESS: _____

WQT No.: _____ **REVISION No.:** _____ **DATE:** _____ **M/HR:** _____

SUPPORTING WPS (s): 1. _____ 2. _____ 3. _____

MATERIAL: _____ to _____ **P No.:** _____ to _____

JOINT THICKNESS: _____ to _____ **DIAMETER/SIZE:** _____ **JOINT TYPE:** _____

PREPARATION: _____

BACKING: _____ **BACKING GAS FLOW RATE:** _____ - _____ **CFH**

SHIELDING GAS: * or _____ **FLOW RATE:** _____ - _____ **CFH**

WELDING POSITION: _____ **W or S BEAD:** _____ **PROGRESSION:** _____

BRAZING POSITION: _____ **TECHNIQUE:** _____ **FLAME ADJ:** _____

PH: °F MIN _____ **IPT: °F MAX** _____ **FUEL GAS:** _____ **CURRENT:** _____

BRAZING TEMP. RANGE: _____ °F to _____ °F **TEST TYPE:** _____

*See appropriate WPS for gas mixture

JOINT SKETCH

INSTRUCTIONS

1. Grind bevel edge to approximately 1/32 inch or less.
2. Perform fitup and tack weld coupons.
3. Contact Weld Test Supervisor for approval.
4. Complete root and notify Weld Test Supervisor for visual inspection.
5. Complete welding including cap and notify Weld Test Supervisor for final visual inspection and instruction on specimen removal.

FILLER METAL	SIZE	AMPS RANGE	VOLTS RANGE	GUN ANGLE°	
				to	

Above passes/layers are representative only, more or less may be required. Note: Inter-pass cleaning shall be performed using a file, wire brush, or chipping hammer only. Grinders are permitted only for feathering of tacks or with the inspector's approval. Grinding the cover pass is not allowed unless directed by the Weld Test Supervisor. Welding repairs are not allowed.

AUTHORIZED BY _____

DATE _____