

ROYAL METALS INDUSTRIES

Welding Operator Qualification Test Record

Page 1 of 1

RMI-SMAW-V-DB

WQTR No. RMI-SMAW-V-DB Welder Name DAN BROWN Welder Id _____
WPS No. RMI-SMAW Revision _____ Date 2/27/2018

Variables Record Actual Values Used In Qualification

Process (Table 4.10, Item (1)) SMAW
Transfer Mode (GMAW): Short-Cir. ☐ Globular ☐ Spray ☐
Type Manual ☒ Machine ☐ Semi-Auto ☐ Auto ☐
Number of Electrodes Single ☐ Multiple ☐
Current/Polarity AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐
Position (Table 4.10, Item (4)) Vertical
Weld Progression: (Table 4.10, Item (6)) Up ☒ Down ☐
Backing [Table 4.10, Item (7)] Use Backing ☒
Consumable Insert (GTAW) Use Insert ☐
Material/Spec. A-36 to A-36
Thickness (Plate): Groove (in) .375
Fillet (in) .375
Thickness (Pipe/tube): Groove () _____
Fillet () _____
Diameter(Pipe): Groove () _____
Fillet () _____

Notes _____

Filler Metal (Table 10, Item (2))

Spec. 5.1

Class. E-7018 LH

F-No. 4

Gas/Flux Type (Table 4.10, Item (3)) _____

Other _____

Qualification Range

SMAW-MILD STEEL GROUPS

Short-Circuiting ☐ Globular ☐ Spray ☐
Manual ☒ Machine ☐ Semi-Auto ☐ Auto ☐
Single ☐ Multiple ☐
AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐
Flat, Vertical, Horizontal, 3G

Up ☒ Down ☐

With Backing ☒ Without Backing ☐

With Insert ☐ Without Insert ☐

MILD STEEL GROUPS

.125 .750 in
Any Any in

VISUAL INSPECTION (4.8.1) Acceptable Yes

GUIDED BEND TEST RESULTS (4.30.5)

Type	Result	Type	Result
ROOT	PASSED	FACE	PASSED
ROOT	PASSED	FACE	PASSED

Fillet Test Results (4.30.2.3 and 4.30.4.1)

Appearance GOOD Fillet Size .310" Macroetch SOUND
Fracture Test Root Penetration COMPLETE Description PASSED

Inspected By _____ Test No. RMI Organization A-Z WELDER Date 2/27/2018

RADIOGRAPHIC TEST RESULTS (4.30.3.1)

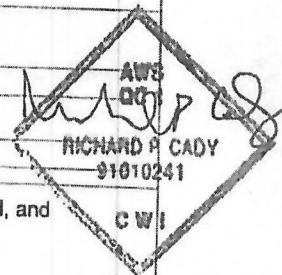
Film Identification No.	Result	Remark	Interpreted By _____
			Organization _____
			Test No. _____
			Date _____

We, the undersigned, 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 4 of ANSI/AWS D1.1, (2015) Structural Welding Code-Steel.

Manufacturer ROYAL METALS INDUSTRIES

Authorized By _____

Date 2/27/2018



ROYAL METALS INDUSTRIES

Welding Operator Qualification Test Record

Page 1 of 1

RMI-SMAW-OH-DB

WQTR No. RMI-SMAW-OH-DB

Welder Name DAN BROWN

Welder Id DB

WPS No. RMI-SMAW

Revision

Date 2/27/2018

Variables

Record Actual Values Used In Qualification

Process (Table 4.10, Item (1)) **SMAW**

Transfer Mode (GMAW): Short-Cir. ☐ Globular ☐ Spray ☐

Type Manual ☒ Machine ☐ Semi-Auto ☐ Auto ☐

Number of Electrodes Single ☐ Multiple ☐

Current/Polarity AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐

Position (Table 4.10, Item (4)) **Overhead**

Weld Progression: (Table 4.10, Item (6)) Up ☐ Down ☐

Backing [Table 4.10, Item (7)] Use Backing ☒

Consumable Insert (GTAW) Use Insert ☐

Material/Spec. A-36 to A-36

Thickness (Plate): Groove (in) .375

Fillet (in) .375

Thickness (Pipe/tube): Groove ()

Fillet ()

Diameter(Pipe): Groove ()

Fillet ()

Notes

Filler Metal (Table 10, Item (2))

Spec. 5.1

Class. E-7018 LH

F-No. 4

Gas/Flux Type (Table 4.10, Item (3))

Other

Qualification Range

SMAW-MILD STEEL GROUPS

Short-Circuiting ☐ Globular ☐ Spray ☐

Manual ☒ Machine ☐ Semi-Auto ☐ Auto ☐

Single ☐ Multiple ☐

AC ☐ DCEP ☒ DCEN ☐ Pulsed ☐

Flat, Overhead, Horizontal, 4G

Up ☐ Down ☐

With Backing ☒ Without Backing ☒

With Insert ☐ Without Insert ☐

MILD STEEL GROUPS

.125 .750 in

Any Any in

VISUAL INSPECTION (4.8.1) Acceptable Yes

GUIDED BEND TEST RESULTS (4.30.5)

Type	Result	Type	Result
ROOT	PASSED	FACE	PASSED
ROOT	PASSED	FACE	PASSED

Fillet Test Results (4.30.2.3 and 4.30.4.1)

Fillet Size .340"

Macroetch SOUND

Appearance GOOD

Fracture Test Root Penetration COMPLETE

Description PASSED

Inspected By

Test No. RMI

Organization A-Z WELDER

Date 2/27/2018

RADIOGRAPHIC TEST RESULTS (4.30.3.1)

Film Identification No.	Result	Remark	Interpreted By
			Organization
			Test No.
			Date

We, the undersigned, 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 4 of ANSI/AWS D1.1, (2015) Structural Welding Code-Steel.

Manufacturer ROYAL METALS INDUSTRIES

Authorized By

Date 2/27/2018

