



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 3-15-16 WELDER RUDY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.66 WALL THICKNESS .140
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 23 - 24 AMPERAGE 65 - 90
 FILLER METAL E-6010 3/32 - 1/8 JOINT TYPE V-GROOVE BUTT
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G	PASS				

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW V-GROOVE BUTT WELDS IN ALL POSITIONS, IN PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON



IOWA
ASSOCIATION OF MUNICIPALITIES

Welding Test Report

Date 3-15-16 Welder RUDY PARCEL
 Stamp number _____
 Welding process SMAW Oxyacetylene weld D
 Code (192 Appendix C) (API-1104) Welding procedure number A-2
 Wind break used SHOP
 Pipe type and grade GRADE B
 Outside diameter 2-375 Wall thickness .154
 Weld position Fixed Rolled D
 Welding machine type MILLER Welding machine size 350
 Voltage 250 Amperage 92
 Filler metal 1/8 Joint type _____
 current type & polarity: DC Reverse Re-qualify test D
 Qualifying test _____
 Remarks: _____

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
	<12.375" < 4.50"					
2 o'clock	6G		PASS	PASS		
4 o'clock	6G	PASS				
8 o'clock	6G	PASS				
10 o'clock	6G		PASS	PASS		
	2: 4.50" :s; 12.75"					
2 o'clock	6G					
4 o'clock	6G					
8 o'clock	6G					
10 o'clock	6G					

these test welds were prepared and tested in general accordance with above code and based on these test results, this welder Has qualified to perform SMAW;W G;ro"o:i"e _____
 welds in All positions, in Pipe 2.375" 00 - 12.750" 00 of
3/16" 314" thickness.

evaluated by: Keith Simpson
 Keith Simpson

1735 NE 70th Avenue - Ankeny, Iowa 50021-9353
 Phone 515/289-1999 - Fax 515/289-2499
 WEB SITE: www.iamu.org



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 3-15-16 WELDER RUBY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 2.375 - 3.5 WALL THICKNESS .154 - .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 25 - 25 AMPERAGE 95 - 115
 FILLER METAL E-6010 1/8 - 3/32 JOINT TYPE FILLET
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS _____ QUALIFIED TO PERFORM SMAW FILLET WELDS IN ALL _____ POSITIONS, IN _____ PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
 KEITH SIMPSON



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 3-15-16 WELDER RUDY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.315 - 2.375 WALL THICKNESS .133 - .154
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 24 AMPERAGE 65
 FILLER METAL E-6010 JOINT TYPE FILLET, SERVICE TO MAIN
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	DESTRUCT TEST			
		PASS	FAIL		
1	5G	PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW SERVICE TO MAIN WELDS IN ALL POSITIONS, IN _____ OF _____ THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 3-15-16 WELDER RODNEY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.315 WALL THICKNESS .133
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 305
 VOLTAGE 23 - 24 AMPERAGE 65 - 90
 FILLER METAL E-6010 3/32 - 1/8 JOINT TYPE V-GROOVE BUTT
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G	PASS				

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW V-GROOVE BUTT WELDS IN ALL POSITIONS, IN PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON



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UTILITIES

Welding Test Report

Date 3-15-16 Welder RODNEY PARCEL
 Stamp number _____
 Welding process SMAW Oxyacetylene weld D
 Code (192 Appendix C) (API-1104) Welding procedure number A-2
 Wind break used SHOP
 Pipe type and grade GRADE B
 Outside diameter 2.375 Wall thickness .154
 Weld position Fixed Rolled D
 Welding machine type MILLER Welding machinesize 305
 Voltage 25 Amperage 92
 Filler metal 1/8 Joint type _____
 current type & polarity: DC Reverse Re-qualify test D
 Qualifying test _____
 Remarks: _____

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
<u>< 2.375" < 4.50"</u>						
<u>2 o'clock</u>	<u>6G</u>		<u>PASS</u>	<u>PASS</u>		
<u>4 o'clock</u>	<u>6G</u>	<u>PASS</u>				
<u>8 o'clock</u>	<u>6G</u>	<u>PASS</u>				
<u>10 o'clock</u>	<u>6G</u>		<u>PASS</u>	<u>PASS</u>		
<u>2: 4.50" :s; 12.75"</u>						
<u>2 o'clock</u>	<u>6G</u>					
<u>4 o'clock</u>	<u>6G</u>					
<u>8 o'clock</u>	<u>6G</u>					
<u>10 o'clock</u>	<u>6G</u>					

these test welds were prepared and tested in general accordance with above code and based on these test results, this welder Has qualified to perform SMAW; W G; ro; o; i" e _____
 welds in All positions, in Pipe 2.375" 00 - 12.750" 00 of _____
3/16" 3/4" thickness.

evaluated by: Keith Simpson
 Keith Simpson



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WELDING TEST REPORT

DATE 3-15-16 WELDER RODNEY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 2.375" - 3.5" WALL THICKNESS .154 - .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 305
 VOLTAGE 25 - 25 AMPERAGE 95 - 115
 FILLER METAL E-6010 1/8 - 5/32 JOINT TYPE FILLET
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW FILLET WELDS IN ALL POSITIONS, IN PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
 KEITH SIMPSON

1735 NE 70th Avenue - Ankeny, Iowa 50021-9353

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UTILITIES

WELDING TEST REPORT

DATE 3-15-16 WELDER RODNEY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.315" - 2.375" WALL THICKNESS .133" - .154"
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 305"
 VOLTAGE 24 AMPERAGE 65"
 FILLER METAL E-6010 3/32 JOINT TYPE FILLET, SERVICE TO MAIN
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	DESTRUCT TEST			
		PASS	FAIL		
1	5G	PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW SERVICE TO MAIN WELDS IN ALL POSITIONS, IN _____ OF _____ THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON



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WELDING TEST REPORT

DATE 3-15-16 WELDER TYLER PETERSON
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1
 WIND BREAK USED _____
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.315 WALL THICKNESS .133
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 23-24 AMPERAGE 65-90
 FILLER METAL E-6010 3/2-1/8 JOINT TYPE V-GROOVE BUTT
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G	PASS				

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW V-GROOVE BUTT WELDS IN ALL POSITIONS, IN PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON

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Welding Test Report

Date 3-15-16 Welder TYLER PETERSON
 Stamp number _____
 Welding process SMAW Oxyacetylene weld D
 Code (192 Appendix C) (API-1104) Welding procedure number A-2
 Wind break used SHOP
 Pipe type and grade GRADE B
 Outside diameter 2.375 Wall thickness .154
 Weld position Fixed Rolled D
 Welding machine type MILLER Welding machine size 350
 Voltage E 6 0 1 0 25 Amperage G 0 10 0 V e 92
 Filler metal 1/8 Joint type _____
 current type & polarity: DC Reverse Re-qualify test D
 Qualifying test _____
 Remarks: _____

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
<u>< 2.375" < 4.50"</u>						
<u>2 o'clock</u>	<u>6G</u>		<u>PASS</u>	<u>PASS</u>		
<u>4 o'clock</u>	<u>6G</u>	<u>PASS</u>				
<u>8 o'clock</u>	<u>6G</u>	<u>PASS</u>				
<u>10 o'clock</u>	<u>6G</u>		<u>PASS</u>	<u>PASS</u>		
<u>2: 4.50" ; 12.75"</u>						
<u>2 o'clock</u>	<u>6G</u>					
<u>4 o'clock</u>	<u>6G</u>					
<u>8 o'clock</u>	<u>6G</u>					
<u>10 o'clock</u>	<u>6G</u>					

these test welds were prepared and tested in general accordance with above code and based on these test results, this welder Has qualified to perform SMAW; W G; r o; i; e _____
 welds in All positions, in Pipe 2.375" 00 - 12.750" 00 of _____
3/16" 3/4" thickness.

evaluated by: Keith Simpson
 Keith Simpson



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WELDING TEST REPORT

DATE 3-15-16 WELDER TYLER PETERSON
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 2.375 - 3.5 WALL THICKNESS .154 - .214
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 25-25 AMPERAGE 95-115
 FILLER METAL E-6010 1/8 - 1/2 JOINT TYPE FILLET
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST	
					PASS	FAIL
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			
2 O'CLOCK	5G		PASS			
8 O'CLOCK	5G		PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW FILLET WELDS IN ALL POSITIONS, IN PIPE LESS THAN 2.375" DIA. OF LESS THAN 3/16" THICKNESS.

EVALUATED BY: Keith Simpson
 KEITH SIMPSON

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WELDING TEST REPORT

DATE 3-15-16 WELDER TYLER PETERSON
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE GRADE B
 OUTSIDE DIAMETER 1.315" - 2.375" WALL THICKNESS .133" - .154"
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350
 VOLTAGE 24 AMPERAGE 65
 FILLER METAL E-6010 3/32 JOINT TYPE FILLET, SERVICE TO MAIN
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	DESTRUCT TEST			
		PASS	FAIL		
1	5G	PASS			

THESE TEST WELDS WERE PREPARED AND TESTED IN GENERAL ACCORDANCE WITH ABOVE CODE AND BASED ON THESE TEST RESULTS, THIS WELDER HAS QUALIFIED TO PERFORM SMAW SERVICE TO MAIN WELDS IN ALL POSITIONS, IN _____ OF _____ THICKNESS.

EVALUATED BY: Keith Simpson
KEITH SIMPSON