IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 3-18-14 WELDER Rod Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1

WIND BREAK USED Shop

PIPE TYPE AND GRADE B Grade API 1104

OUTSIDE DIAMETER 1.315 WALL THICKNESS .133

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350

VOLTAGE 24 AMPERAGE 65

FILLER METAL E-6010 JOINT TYPE V-GROOVE BUTT

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST 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: Bill Morgan
BILL MORGAN

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IOWA ASSOCIATION OF MUNICIPAL UTILITIES

WELDING TEST REPORT

DATE 3-18-14 WELDER Rod Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE (192 APPENDIX C) (API-1104) WELDING PROCEDURE NUMBER A-2

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API 1104

OUTSIDE DIAMETER 2.375 WALL THICKNESS .154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE GROOVE

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS: Tensile pull 4 & 6 O'clock

WITNESSED BY: Bill Morgan

		API 1104				192 APPENDIX C	
SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	TENSILE PULL		ROOT BEND	
	≥ 2.375" < 4.50"						
2	2 o'CLOCK 6G		Pass	Pass			
4	4 o'CLOCK 6G	Pass					
6	6 o'CLOCK 6G	Pass					
8	8 o'CLOCK 6G		Pass	Pass			
	≥ 4.50" ≤ 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 GROOVE WELDS IN ALL POSITIONS, IN PIPE 2.375" OD - 12.750" OD OF 3/16" - 3/4" THICKNESS.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rod Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API - 1104

OUTSIDE DIAMETER 4.5" . 2.375 WALL THICKNESS .237 - .154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE FILLET

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST FAIL
2 o'clock	5G		Pass			
4 o'clock	5G		Pass			
6 o'clock	5G		Pass			
10 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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rod Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6

WIND BREAK USED Shop

PIPE TYPE AND GRADE B- Grade API 1104

OUTSIDE DIAMETER 2.375 WALL THICKNESS .154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350 Amp

VOLTAGE 85 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE FILLET, SERVICE TO MAIN

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rudy Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API 1104

OUTSIDE DIAMETER 1.315 WALL THICKNESS .133

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE Miller 350

VOLTAGE 23 AMPERAGE 65

FILLER METAL E-6010 JOINT TYPE V-GROOVE BUTT

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST 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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rudy Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE (192 APPENDIX C) (API-1104) WELDING PROCEDURE NUMBER A-2

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API-1104

OUTSIDE DIAMETER 4.5 WALL THICKNESS .237

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE GROOVE

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS: Tensile pull 4 & 6 O'clock.

WITNESSED BY: Bill Morgan

		API 1104				192 APPENDIX C	
SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	TENSILE PULL		ROOT BEND	
≥ 2.375" < 4.50"				Pass			
2 O'CLOCK	6G		Pass				
4 O'CLOCK	6G	Pass					
6 O'CLOCK	6G	Pass					
10 O'CLOCK	6G		Pass				
≥ 4.50" ≤ 12.75"				Pass			
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 GROOVE WELDS IN ALL POSITIONS, IN PIPE 2.375" OD - 12.750" OD OF 3/16" - 3/4" THICKNESS.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rucky Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API-1104

OUTSIDE DIAMETER 4.5 - 2.375 WALL THICKNESS .237 .154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE 350 Miller WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE FILLET

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST FAIL
2 O'CLOCK	5G		Pass			
4 O'CLOCK	5G		Pass			
8 O'CLOCK	5G		Pass			
10 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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Rudy Parcel

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API 1104

OUTSIDE DIAMETER 2.375 1.315 WALL THICKNESS .154 .133

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE Miller 350 WELDING MACHINE SIZE 350

VOLTAGE 23 AMPERAGE 60

FILLER METAL E-6010 JOINT TYPE FILLET, SERVICE TO MAIN

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Tyler Peterson

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-1

WIND BREAK USED Shop

PIPE TYPE AND GRADE B-Grade API 1104

OUTSIDE DIAMETER 1.315 WALL THICKNESS .133

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE miller 350 WELDING MACHINE SIZE 350

VOLTAGE 23 AMPERAGE 50

FILLER METAL E-6010 JOINT TYPE V-GROOVE BUTT

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST 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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Tyler Peterson

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE (192 APPENDIX C) (API-1104) WELDING PROCEDURE NUMBER A-2

WIND BREAK USED Shop

PIPE TYPE AND GRADE B - Grade API 1104

OUTSIDE DIAMETER 4.5 WALL THICKNESS .237

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE 350 Miller WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE GROOVE

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS: 2 - Tensile Pulls

WITNESSED BY: BILL MORGAN

		API 1104				192 APPENDIX C	
SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	TENSILE PULL		ROOT BEND	
≥ 2.375" < 4.50"				P			
2	2 o'clock 5G		Pass	Pass			
4	4 o'clock 5G	Pass					
8	8 o'clock 5G	Pass					
10	10 o'clock 5G		Pass	Pass			
≥ 4.50" ≤ 12.75"							
	2 o'clock 5G						
	4 o'clock 5G						
	8 o'clock 5G						
	10 o'clock 5G						

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 GROOVE WELDS IN ALL POSITIONS, IN PIPE 2.375" OD - 12.750" OD OF 3/16" - 3/4" THICKNESS.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Tyler Peterson

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-3

WIND BREAK USED Shop

PIPE TYPE AND GRADE B- Grade API 1104

OUTSIDE DIAMETER 4.5 - 2.375 WALL THICKNESS .237 - .154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE 350 Miller WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE FILLET

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

SAMPLE NO.	POSITION OF WELD	ROOT BEND	NICK BREAK	FILLET WELD FRACTURE	DESTRUCT TEST PASS	DESTRUCT TEST 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.

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WELDING TEST REPORT

DATE 3-18-14 WELDER Tyler Peterson

STAMP NUMBER

WELDING PROCESS SMAW [X] OXYACETYLENE WELD [ ]

CODE 192 APPENDIX C WELDING PROCEDURE NUMBER A-6

WIND BREAK USED shop

PIPE TYPE AND GRADE B-Grade API 1104

OUTSIDE DIAMETER 1.315 - 2.375 WALL THICKNESS .133-.154

WELD POSITION FIXED [X] ROLLED [ ]

WELDING MACHINE TYPE 350 miller WELDING MACHINE SIZE 350

VOLTAGE 25 AMPERAGE 95

FILLER METAL E-6010 JOINT TYPE FILLET, SERVICE TO MAIN

CURRENT TYPE & POLARITY: D C REVERSE

QUALIFING TEST [X] RE-QUALIFY TEST [ ]

REMARKS:

WITNESSED BY: BILL MORGAN

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.

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