



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 9-18-14 WELDER RUDY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE (192 APPENDIX C) (API 1104) WELDING PROCEDURE NUMBER A-2
 WIND BREAK USED Shop
 PIPE TYPE AND GRADE API 1104 GR B
 OUTSIDE DIAMETER 3.5 WALL THICKNESS .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE LINCOLN WELDING MACHINE SIZE 250
 VOLTAGE _____ AMPERAGE _____
 FILLER METAL E-6010 JOINT TYPE GROOVE
 CURRENT TYPE & POLARITY: D C REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: **RUDY PARCEL**

SAMPLE NO.	POSITION OF WELD	API 1104			192 APPENDIX C	
		ROOT BEND	NICK BREAK	TENSILE PULL	ROOT BEND	
≥ 2.375" < 4.50"						
2 O'CLOCK	5G 6G		PASS			
8 O'CLOCK	5G 6G	PASS				
4 O'CLOCK	5G 6G	PASS				
10 O'CLOCK	5G 6G		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.

EVALUATED BY: Bill Morgan
RUDY PARCEL

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 9-18-14 WELDER ROD PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE (192 APPENDIX C) (API 1104) WELDING PROCEDURE NUMBER A-2
 WIND BREAK USED _____
 PIPE TYPE AND GRADE SLIP API-1104 GR B
 OUTSIDE DIAMETER 3.5 WALL THICKNESS .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE _____
 VOLTAGE _____ AMPERAGE _____
 FILLER METAL E-6010 JOINT TYPE GROOVE
 CURRENT TYPE & POLARITY: DC REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: RUDY PARCEL

SAMPLE NO.	POSITION OF WELD	API 1104			192 APPENDIX C	
		ROOT BEND	NICK BREAK	TENSILE PULL	ROOT BEND	
≥ 2.375" < 4.50"						
2 O'CLOCK	5G 6G		Pass			
4 O'CLOCK	5G 6G	Pass				
8 O'CLOCK	5G 6G	Pass				
10 O'CLOCK	5G 6G		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.

EVALUATED BY: Bill Morgan
~~RUDY PARCEL~~



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UTILITIES

WELDING TEST REPORT

DATE 9-18-14 WELDER TYLER PETERSON
 STAMP NUMBER _____
 WELDING PROCESS SMAW OXYACETYLENE WELD
 CODE (192 APPENDIX C) (API-1104) WELDING PROCEDURE NUMBER A-2
 WIND BREAK USED SHOP
 PIPE TYPE AND GRADE API 1104-GR B
 OUTSIDE DIAMETER 3.5 WALL THICKNESS .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE Lincoln WELDING MACHINE SIZE 225
 VOLTAGE _____ AMPERAGE _____
 FILLER METAL E-6010 JOINT TYPE GROOVE
 CURRENT TYPE & POLARITY: D C REVERSE
 QUALIFYING TEST RE-QUALIFY TEST
 REMARKS: _____

WITNESSED BY: RUDY PARCEL

SAMPLE NO.	POSITION OF WELD	API 1104			192 APPENDIX C	
		ROOT BEND	NICK BREAK	TENSILE PULL	ROOT BEND	
≥ 2.375" < 4.50"						
2 O'CLOCK	5G 6G		PASS			
8 O'CLOCK	5G 6G	PASS				
4 O'CLOCK	5G 6G	PASS				
10 O'CLOCK	5G 6G		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.

EVALUATED BY: Bill Morgan
RUDY PARCEL