

# WELDING TEST REPORT

DATE 9-12-16 WELDER RODNEY 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 ASTM A53 GRADE B

OUTSIDE DIAMETER 2.375 WALL THICKNESS .154

WELD POSITION FIXED  ROLLED

WELDING MACHINE TYPE LINCOLN WELDING MACHINE SIZE 250

VOLTAGE 23 AMPERAGE 90

FILLER METAL E-6010 JOINT TYPE GROOVE

CURRENT TYPE & POLARITY: DC REVERSE

QUALIFYING TEST  RE-QUALIFY TEST

REMARKS: \_\_\_\_\_

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
< 2.375" < 4.50"						
2 o'clock	6G	PASS				
4 o'clock	6G		PASS	PASS		
8 o'clock	6G	PASS				
10 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 in all positions, in Pipe 2.375" 00 - 12.750" 00 of thickness 3/16" 314"

evaluated by: Keith Simpson  
Keith Simpson

1735 NE 70th Avenue - Ankeny, Iowa 50021-9353  
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# WELDING TEST REPORT

DATE 9-12-16 WELDER RODNEY PARCEL

STAMP NUMBER \_\_\_\_\_

WELDING PROCESS SMAW  OXYACETYLENE WELD

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

WIND BREAK USED SHARP WALL THICKNESS .154

PIPE TYPE AND GRADE ASTM A53 GRADE B

OUTSIDE DIAMETER 2.375 WELD POSITION  ROLLED

WELDING MACHINE TYPE LINCOLN WELDING MACHINE SIZE 250

VOLTAGE 23 AMPERAGE 90

FILLER METAL E-6010 JOINT TYPE GROOVE

CURRENT TYPE & POLARITY: DC REVERSE

QUALIFYING TEST  RE-QUALIFY TEST

REMARKS: \_\_\_\_\_

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
< 2.375" < 4.50"						
2 o'clock	6G	PASS				
4 o'clock	6G		PASS	PASS		
8 o'clock	6G	PASS				
10 o'clock	6G		PASS	PASS		
2.450" to 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" 00 - 12.750" 00 of 3/16" 3/4" thickness.

evaluated by: Keith Simpson  
Keith Simpson



IOWA  
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UTILITIES

### WELDING TEST REPORT

DATE 9-12-16 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 ASTM A53 GRADE B  
 OUTSIDE DIAMETER 2.375 WALL THICKNESS .154  
 WELD POSITION FIXED  ROLLED   
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350  
 VOLTAGE 23 AMPERAGE 90  
 FILLER METAL E-6010 JOINT TYPE GROOVE  
 CURRENT TYPE & POLARITY: DC REVERSE  
 QUALIFYING TEST  RE-QUALIFY TEST   
 REMARKS: \_\_\_\_\_

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
<u>&lt; 2.375" &lt; 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>PASS</u>		
<u>10 o'clock</u>	<u>6G</u>	<u>PASS</u>				
<u>2: 4.50" to 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, WGT, or other \_\_\_\_\_ welds in All positions, in Pipe 2.375" 00 - 12.750" 00 of 3/16" 314" thickness.

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Keith Simpson

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 PIPE TYPE AND GRADE ASTM A53 GRADE B  
 OUTSIDE DIAMETER 2.375 WALL THICKNESS .154  
 WELD POSITION FIXED  ROLLED   
 WELDING MACHINE TYPE MILLER WELDING MACHINE SIZE 350  
 VOLTAGE 23 AMPERAGE 90  
 FILLER METAL E-6010 JOINT TYPE GROOVE  
 CURRENT TYPE & POLARITY: DC REVERSE  
 QUALIFYING TEST  RE-QUALIFY TEST   
 REMARKS: \_\_\_\_\_

witnessed by: Keith Simpson

		API1104			192 Appendix C	
sample no.	position of weld	root bend	nick break	Tensile Pull	root bend	
< 2.375" < 4.50"						
2 o'clock	6G		PASS	PASS		
4 o'clock	6G	PASS				
8 o'clock	6G		PASS	PASS		
10 o'clock	6G	PASS				
2: 4.50" to 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 in 6G positions, in Pipe 2.375" 00 - 12.750" 00 of 3/16" 3/4" thickness.

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