

# WELDING TEST REPORT

**DATE** 9-22-17 **WELDER** RUDY PARCEL  
**STAMP NUMBER** NA  
**WELDING PROCESS** SMAW  **WELDING PROCEDURE NUMBER** A-2  
**CODE** 192 APPENDIX C & API 1104 20TH ED.  
**WIND BREAK USED** SHOP  
**PIPE TYPE AND GRADE** GRADE B  
**OUTSIDE DIAMETER** 2.375 **WALL THICKNESS** .218  
**WELD POSITION** **FIXED**  **ROLLED**   
**WELDING MACHINE TYPE** LINCOLN **WELDING MACHINE SIZE** 225  
**VOLTAGE** 25-27 **AMPERAGE** 92-115  
**FILLER METAL** E-6010 **JOINT TYPE** GROOVE  
**CURRENT TYPE & POLARITY:** D C REVERSE  
**QUALIFYING TEST**  **RE-QUALIFY TEST**   
**REMARKS:** \_\_\_\_\_

**WITNESSED BY: KEITH SIMPSON**

SAMPLE NO.	POSITION OF WELD	API 1104			192 APPENDIX C	
		ROOT BEND	NICK BREAK	TENSILE PULL	ROOT BEND	
<b>≥ 2.375" &lt; 4.50"</b>						
2 O'CLOCK	5G 6G HXJ		PASS	PASS		
4 O'CLOCK	5G 6G HXJ	PASS				
8 O'CLOCK	5G 6G HXJ	PASS				
10 O'CLOCK	5G 6G HXJ		PASS	PASS		
<b>≥ 4.50" ≤ 12.75"</b>						
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" WALL THICKNESS.

EVALUATED BY: Keith Simpson  
**KEITH SIMPSON**

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## WELDING TEST REPORT

DATE 9-22-17 WELDER RODNEY PARCEL  
 STAMP NUMBER N/A  
 WELDING PROCESS SMAW   
 CODE 192 APPENDIX C & API 1104 20TH ED. WELDING PROCEDURE NUMBER A-2  
 WIND BREAK USED SHOP  
 PIPE TYPE AND GRADE GRADE B  
 OUTSIDE DIAMETER 2.375 WALL THICKNESS .218  
 WELD POSITION FIXED  ROLLED   
 WELDING MACHINE TYPE LINCOLN WELDING MACHINE SIZE 225  
 VOLTAGE 25-27 AMPERAGE 92-115  
 FILLER METAL E-6010<sup>1/8</sup>-<sup>5/32</sup> JOINT TYPE GROOVE  
 CURRENT TYPE & POLARITY: D C REVERSE  
 QUALIFYING TEST  RE-QUALIFY TEST   
 REMARKS:

WITNESSED BY: KEITH SIMPSON

SAMPLE NO.	POSITION OF WELD	API 1104			192 APPENDIX C	
		ROOT BEND	NICK BREAK	TENSILE PULL	ROOT BEND	
<b>≥ 2.375" &lt; 4.50"</b>						
2 O'CLOCK	<u>5G 6G 2HB</u>		<u>PASS</u>			
4 O'CLOCK	<u>5G 6G 2HB</u>	<u>PASS</u>		<u>PASS</u>		
8 O'CLOCK	<u>5G 6G 2HB</u>	<u>PASS</u>				
10 O'CLOCK	<u>5G 6G 2HB</u>		<u>PASS</u>	<u>PASS</u>		
<b>≥ 4.50" ≤ 12.75"</b>						
2 O'CLOCK	<u>5G</u>					
4 O'CLOCK	<u>5G</u>					
8 O'CLOCK	<u>5G</u>					
10 O'CLOCK	<u>5G</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 GROOVE WELDS IN ALL POSITIONS, IN PIPE 2.375" OD - 12.750" OD, OF 3/16" - 3/4" WALL THICKNESS.

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