



IOWA
ASSOCIATION OF MUNICIPAL
UTILITIES

WELDING TEST REPORT

DATE 9-20-18 WELDER RODNEY PARCEL
 STAMP NUMBER _____
 WELDING PROCESS SMAW ROLLED
 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 3.5 WALL THICKNESS .216
 WELD POSITION FIXED ROLLED
 WELDING MACHINE TYPE MILLER TRAILBLAZER WELDING MACHINE SIZE 325
 VOLTAGE 25-27 AMPERAGE 92-115
 FILLER METAL E-6010 JOINT TYPE GROOVE
 CURRENT TYPE & POLARITY: DC 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	
≥ 2.375" < 4.50"						
2 O'CLOCK	<u>5G 6G 2X8</u>		<u>PASS</u>			
4 O'CLOCK	<u>5G 6G 2X8</u>	<u>PASS</u>		<u>PASS</u>		
8 O'CLOCK	<u>5G 6G 2X8</u>	<u>PASS</u>				
10 O'CLOCK	<u>5G 6G 2X8</u>		<u>PASS</u>	<u>PASS</u>		
≥ 4.50" ≤ 12.75"						
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.

EVALUATED BY: Keith Simpson
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