

**AMERICAN WELDING SOCIETY (AWS) National Certification**  
**Using Welding Procedure Specification (WPS) per**  
**AMERICAN SOCIETY of MECHANICAL ENGINEERS (ASME)**

Refer to ASME Section IX

## Welder Certification Test - Pipe

The diagram below shows the layout of the actual certification test.



**Test # 1: WPS# B2.1-1-201-96: SMAW - 3 hour time limit**

Open root: 1st pass (root) E6010 electrode  
 Fill and cover passes: E7018 electrode  
 Stringer beads (maximum bead width: 2 to 3 times the core diameter of the electrode).  
 Electrode size is either 3/32", 1/8" or a combination of the two.

**Test # 2: WPS# B2.1-1-209-96: GTAW / SMAW - 3 hour time limit**

Open root: 1st pass (root) ER70S-2 electrode - 2 additional fill passes with GTAW (1/2 wall thickness of pipe)  
 Remainder of pipe fill and cover passes: E7018 electrode  
 Stringer beads (maximum bead width: 2 to 3 times the core diameter of the electrode).  
 Electrode size is either 3/32", 1/8" or a combination of the two.

Pipe coupon is to be welded in the 6G - 45° (see diagram) position.

Location of Guided Bend Test Specimens  
 Each Specimen 1 1/2" wide

