AMERICAN WELDING SOCIETY (AWS) National Certification

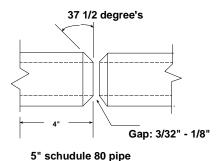
Using Welding Procedure Specification (WPS) per

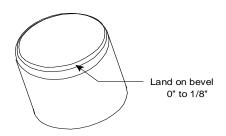
AMERICAN SOCIETY of MECHANICAL ENGINEERS (ASME)

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

