

## Electro Mechanical Solutions, Inc.

1555 Gunn Hwy Odessa, FL 33556

## Welder or Welding Operator Qualification Test Record (WPQR)

Welder's Name:	Main, Travis	Stamp:	0001							
Test WPS No.: El				WPQ No.:	3048-	-4		Date	e: <u>9/26/2019</u>	Page 1
Type of joint weld	ed: Pipe Groov	e weld	_	55						
Joint type(s) qualif			fillet, p	lug, and slot	welds					
Base metal(s) weld										
Variables (Table		Range Qualified								
Welding process /		(	GTAW / Mai	nual		GTAV	V / Manual ar	nd Semiautom	atic:	
Base metal thickne		0.154					1/8" to 3/4" PJP to unlimited			
Base metal thickne		N/A					1/8" to unlimited			
Pipe diameter - gro		2.375					3/4" to 4"			
Pipe diameter - fille		N/A					3/4" to 4"			
Box tube size (in.):		N/A					All sizes			
Dihedral angle - fill			N/A			30° to unlimited				
Backing:		No backing used					With or without backing			
Filler metal classific				ER5653						
Filler metal specific	cation:			5.10						
Filler metal F-No.:			50180				N/A			
Welding position -			60	G - 45 degree	pipe		All Positions			
Welding position -	fillet:			N/A			All Positions			
Weld progression:				Vertical up			Vertical up			
Shielding gas:				100% Argo						
Welding current / p		•		DCEP (rever	rse)					
Transfer mode (GN		N/A				N/A				
Single / multiple ele	ectrode:		N/A				N/A			
Notes:										
Visual inspection ac	cceptable: Yes	Other te	st resu	ılts:			-			
				Guided 1	Bend '	Test (4.22.5)				
Figure Numbe	r and Type		Result	2.477		gure Number :	er and Type Result			
None						None				
None						None				
None						None				
Organization: ND	Е							Test	No.: 3048-2	
Inspected	l by:	,	Steve F	Bartholome			9/25/2019			
mspecied			Sicve I	Jai molome		30.00 - 600 140	Date	_		
					Test	Results (4.31.3				7.
Film ID No.			Remarks			Film ID No.		sult	Rema	rks
A	Acceptab				-	В	Acce	ptable		
C	Acceptab	ie								
Organization: ND	E							Test	No.: 3048	
Interprete		Nelson Guerrero				<u>9/25/2019</u> RT Level II				
							Date			
We, the undersigned conformance with the				s record are c	correct	and that the tes	st welds were p	orepared, weld	led and tested is	n
	•									
ivianuiaci	urer or Contract	ior: EMS, in	ıc.							
Certified	u						9/26/19 AWS CWI			
			Steve Bartholome							
							10			
		Stever	A Barl	tholome Jr						
<b>《AWS》</b> CWI 08051891										
		001	FXP	5/1/2020						



## Electro Mechanical Solutions, Inc.

1555 Gunn Hwy Odessa, FL 33556

## Welder or Welding Operator Qualification Test Record (WPQR)

Welder's Name: Nam		Stamp: <u>0001</u> 01 Rev.: <u>0</u>	WPQ No.: <u>30</u>	48-1		Date:	9/26/2019	Page 1	
	fied: All application	able groove, fillet, p			i x				
Base metal(s) welded: ASTM A 106, Grade B to ASTM A 106, Grade B									
Variables (Table	4.12)	Ad	tual Values Us	ed		Range Qu	alified		
Welding process /		(	TAW / Manua	al	GTAW / Manual and Semiautomatic:				
Base metal thickne			0.154	-	1/8" to 3/4" PJP to unlimited				
Base metal thickne		-	N/A		1/8" to unlimited				
Pipe diameter - gro	oove (in.):		2.375		3/4" to 4"				
Pipe diameter - fill	let (in.):		N/A		3/4" to 4"				
Box tube size (in.)	:		N/A		All sizes				
Dihedral angle - fil	llet:		N/A		30° to unlimited				
Backing:		1	No backing used	<u> </u>	With or without backing				
Filler metal classif	ication:		ER70S-6						
Filler metal specifi	ication:		5.18						
Filler metal F-No .:			6		N/A				
Welding position -		60	3 - 45 degree pij	pe	All Positions				
Welding position -			N/A		All Positions				
Weld progression:			Vertical up		Vertical up				
Shielding gas:									
Welding current / I			DCEP (reverse)			and 2000s at			
Transfer mode (GN		_	N/A		N/A				
Single / multiple el	lectrode:	9	N/A		N/A				
Notes:									
Visual inspection a	cceptable: Yes	Other test resul	ts:						
			Guided Ben	d Test (4.22.5)					
Figure Numbe	er and Type	Result		Figure Number	r and Type Result				
None			None						
None			None			ie			
Non	e			None					
Organization: ND	Е				Test No.: 3048				
Inspected by: Steve Bartholome 9/25/2019									
Date									
Film ID No.	Result		adiographic Le Remarks	st Results (4.31 Film ID No.		sult	Remai	elze	
A A	Acceptab		Cemai KS	B		otable	Kemai	W2	
C	Acceptab			В	Acce	Diaole			
Organization: ND					Test No.: _3048				
Interprete	ed by:	Nelso	Nelson Guerrero			9/25/2019 RT Level II			
conformance with		ne statements in this s of Clause 4 of AW tor: EMS, Inc.					d and tested in		
Certified By: 9/26/15 AWS CWI									
Steve Bartholome Date AWS CWI									

