



**Continuing Education & Workforce Development
Welder Qualification Test
Unlimited GS-FCAW**

Name: Randy R. Johnson

Test Date: December 14, 2014

Address: P.O. Box 105
Wells, MI 49894

Phone: (906) 280-1821

Company: Ironworkers Local #8

Employee ID Number:

Qualifies for ASME group p-1 to p-1

Type of Welding Process: Semi-Automatic

Range Qualified: Thickness .125 to UNLIMITED

Base Material: Thickness 1.00

Diameter: over 24 in.

Electrical Characteristics: Current - Direct

Polarity - Reverse

Filler Metal: F No. 6 A No. 1

ASME Spec. SFA - 5.20

AWS Class E-71T-1

Filler Metal: Diameter - .035

Trade Name - DUAL SHIELD

Base Material: Plate

Specification A36

Thickness 1.00

Joint: Single Vee

Backing: Yes

Type A36

Describe any special preparation or procedure: 25 Volts, 150 Amps, 400 IPM Shielding AR 75 CO2 25: 26 CFH

VISUAL INSPECTION

Appearance: Acceptable

Undercut: Acceptable

Piping Porosity: Acceptable

Unlimited - Guided Bend Test Results

No.	Pos.	Type	Results	No.	Pos.	Type	Results
1	3G Vertical	Side Bend	1 crack total 1/32"	3	4G Overhead	Side Bend	No Discontinuities
2	3G Vertical	Side Bend	No Discontinuities	4	4G Overhead	Side Bend	No Discontinuities

Positions Qualified: Flat, Horizontal, Vertical,* and Overhead
(*Up unless otherwise stated in remarks)

PASSED

PROCESSES QUALIFIED: FCAW, GS-FCAW - PER 5.16.4 D1.1

We certify that the statements made in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of the AWS structural welding code D1.1.

Witnessed by:

James Marra

James Marra

Tested/Evaluated by:

Carl O. Peterson

Carl O. Peterson