Northern Michigan University

Continuing Education & Workforce Development

Welder Qualification Test

Unlimited GS-FCAW

Name: Richard A. Kangas

Address: 905 Erie Ave.
Marquette, MI 49855

Company: Ironworkers Local #8

Test Date: March 15, 2014

Phone: (906) 236-0139

Employee ID Number:

Qualifies for **ASME group p-1 to p-1**
Range Qualified: **Thickness .125 to UNLIMITED**
Diameter: **over 24 in.**
Filler Metal: F No. **6** A No. **1**
Filler Metal: Diameter – **.035**
Base Material: **Plate**
Joint: **Single Vee**

Type of Welding Process: **Semi-Automatic**
Base Material: **Thickness 1.00**
Electrical Characteristics: Current – **Direct**
ASME Spec. **SFA – 5.20**
Trade Name – **DUAL SHIELD**
Specification **A36**
Backing: **Yes**

Polarity – **Reverse**
AWS Class **E-71T-1**

Thickness **1.00**
Type **A36**

Describe any special preparation or procedure: **20 Volts, 163 Amps, 280 IPM Shielding AR 75 CO2 25: ___ 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	4 cracks total 7/32"	3	4G Overhead	Side Bend	1 crack 3/32"
2	3G Vertical	Side Bend	No Discontinuities	4	4G Overhead	Side Bend	2 cracks total 5/32"

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: Jan F LaCourt Jan F. LaCourt

Tested/Evaluated by: Carl O Peterson Carl O. Peterson