

STRUCTURAL STEEL WELDING

Weld test conductor (WTC) Name : AWS QC1 Peter J. Prochnow 05080621				Weld test conductor (WTC) Address : Ironworkers Training Center Marquette, MI			
Personal Information IRONWORKERS LOCAL # 8							
Welders Name (First, Middle & Last) : Rich A. Kangas			Birth date / WI Welder Registration # : 2-26-80		Welder Symbol : RAK		
Address (Street or PO box) : 905 Erie Ave.			City : Crystal Falls		State : MI	Zip + 4 code : 49920	
Test Information AWS D1.1-10 WPS#1 Ironworkers SMAW w/backing bar							
Performance Qualification : <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No			Procedure Qualification : <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No				
Employer Name : Ironworkers Local#8		Address : 12034 W. Adler Lane		City : Milwaukee		State : MI	
Zip + 4 code : 53214		Welding Procedure Specification # : Ironworkers Local#8 WPS#1		Code Standard & Year Edition : AWS D1.1 2010		Welding Process : SMAW	
Base Material Specification : ASTM A-36 Group#1		Electrode Specification SFA # : 5.1		AWS Classification : E-7018 H-4 Low Hydrogen		AWS Group # : F-4	
Current Type & Polarity : DCEP		Thickness of Test Piece : 1 Inch		Tensile Strength : 58 KSI		Is Backing Strip Used ? <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	
Amperage : 100-170		Voltage : 18-28		Flux : Low Hydrogen		Weld Progression : <input checked="" type="checkbox"/> Up <input type="checkbox"/> Down	
Flux : Low Hydrogen		Shielding Gas Mixture : NA		Flowrate : NA		Interpass Temperature : See Table 3.2 AWS D1.1	
Qualification by Radiograph : <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		Indicate Joint Position and Type		Indicate Specimen Identification		In the blanks, briefly describe any defects revealed:	
Pass or Fail		Vertical-Up 3G B-U2a		Side Bend 1		3@ 1/16" breaks	
Pass		Butt Groove Single-Vee		Side Bend 2		3@ 1/16" breaks	
Pass		Overhead 4G B-U2a		Side Bend 1		2@ 1/16" breaks	
Pass		Butt Groove Single-Vee		Side Bend 2		2@ 1/16" breaks	
Character & Location of Failure		Tensile Specimen:		Ultimate Total Load: (lbs.)		Ultimate Unit Stress: (PSI)	
NA		Width: (in.)		NA		NA	
NA		Thickness (in.)		NA		NA	
NA		Area: (in.)		NA		NA	
Option: NA		Code Standard & Year: AWS D1.1 2010		Section: 4		Part: Peter J Prochnow CWI 05080621 QC1 EXP 8/1/2014 (148156)	
Expiration Date : 3-16-17		Test Conducted & Evaluated by: (Signature of WTC) Peter J. Prochnow		Paragraph # : 4.19.1.2		Test Date : 3-16-13	

This card certifies that: (Welder's Name) D1.1 Rich A. Kangas				Welding Specification # : IW WPS#1 D1.1-10		Process : SMAW		Base Mtrls Group : 1 and 2	
Birth date / WI Welder ID # : 2-26-80		Welder Symbol : RAK		Employer : Ironworkers Local#8		Address, City & Zip : 12034 W. Adler Lane Milwaukee, WI 53214			
Welder's Signature :		Filler Material: E7018 H-4		SFA # : 5.1		Group: F-4		Thickness Range: 1/8-Unlimited	
Passed the required welder qualification test. Extent of limitations listed below at right		Groove Limited : <input checked="" type="checkbox"/> 1G <input checked="" type="checkbox"/> 2G <input checked="" type="checkbox"/> 3G <input checked="" type="checkbox"/> 4G		Fillet Limited : <input checked="" type="checkbox"/> 1F <input checked="" type="checkbox"/> 2F <input checked="" type="checkbox"/> 3F <input checked="" type="checkbox"/> 4F		Pipe-Tubing : <input type="checkbox"/> Thru 4" <input checked="" type="checkbox"/> Over 24"		Positions Qualified : <input checked="" type="checkbox"/> All Backing <input checked="" type="checkbox"/> yes <input type="checkbox"/> no	
Weld Position Qualified: <input type="checkbox"/> 1G <input type="checkbox"/> 2G <input checked="" type="checkbox"/> 3G <input checked="" type="checkbox"/> 4G		Expiration Date : 3-16-17		Test Conducted by (WTC Name) : Peter J. Prochnow		WTC Cred # : 148156		Above is a Certificate of Competency Structural Welding card.	

Complete & present the card to the welder who passed the weld test.