



Northern
Michigan
University

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

Name: Robert T. Larson

Test Date: December 13, 2014

Address: 1128 Washington Ave.
Escanaba, MI 49824

Phone: (906) 553-2489

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: **24.4 Volts, 145 Amps, 412 IPM Shielding AR 75 CO2 25: 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	2 cracks total 1/8"	3	4G Overhead	Side Bend	1 crack total 1/16"
2	3G Vertical	Side Bend	1 crack total 3/32"	4	4G Overhead	Side Bend	1 crack total 3/32"

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 LaCount

Jan LaCount

Tested/Evaluated by:

Carl O. Peterson

Carl O. Peterson