



VINACOMIN – INSTITUTE OF ENERGY AND MINING MECHANICAL ENGINEERING  
**TESTING AND VERIFICATION CENTER FOR INDUSTRY (TVCI)**

**WELDER PERFORMANCE QUALIFICATION CERTIFICATION**

According to ASME BPV Code Sec. IX - 2021

Welder Performance Record No.: **WPQ-IEMM- BMVP-24-001**

Date of Issue : Jan. 29<sup>th</sup> 2024



Welder Name: **Mr. NGUYEN DANH HOA**

Date of birth: **26 - Oct - 1985**

ID card: **038085001268**

Welding process(es) used: **GTAW**

Type: **Manual**

Identification of WPS followed: **BM-WPS-GTAW-01**

Rev.: **0**

Specification of base metal(s): **SA210C to SA210C**

Test Dated: Jan. 27<sup>th</sup> 2024

Testing Centre: **TESTING AND VERIFICATION CENTER FOR INDUSTRY (TVCI)  
 HIGH TECHNICAL LABORATORY OF MATERIALS- VILAS 182**



**Testing Conditions and Qualification Limits**

Welding Variables	Actual Values Used in Qualification	Qualification Range
Welding process(es)	GTAW	GTAW
Type (ie: manual, semi-auto) used	Manual	Manual
Backing (metal, weld metal, double-welded, etc.)	No/ Without	With/ Without
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter if pipe or tube)	OD 80mm	75mm to unlimited
Thickness (mm)	5.50 mm	from 1.5 mm to 11.00 mm
Base metal P-Number to P-Number	P-No. 1 to P-No.1	P1 through 15F, 34, 41 though 49
Filler metal or electrode specification(s) (SFA)	SFA-5.18	SFA-5.xx
AWS Classification	ER70S-G	All
Filler metal F-Number(s)	F6	All F6
Filler type (solid/metal or flux cored/powder)	Bare/ Solid	Bare/ Solid
Single or Multiple Electrodes	Single	Single
Position qualified (2G, 3G, 6G, 3F, 4F, etc.)	6G	Groove: All - F, H, V, O
		Fillet: All - F, H, V, O
Vertical progression (uphill or downhill)	Uphill	Uphill
Shielding gas (GTAW, PAW, GMAW, FCAW,...)	AWS A5:32 SG-A	Approved by AWS A5.32/ A5.xx
Current type/polarity (AC, DCEP, DCEN)	DCEN(-)	DCEN(-)
Other	N/A	N/A

**RESULTS**

- Visual Examination of Completed Weld: .....No defects. Results in Acceptable
- Bend test;  Transverse root and face:.....NA
- Longitudinal root and face: .....NA
- Pipe bend specimen, corrosion-resistant overlay: .....NA
- Alternative radiographic examination results: the report No.: **VCN VX01 -24-RT**

Sample/ Identification	Result
NGUYEN DANH HOA - 6G	Acceptable

Operator: Mr. Nguyen Van Tan RT Level II

Dated: January. 27<sup>th</sup> 2024

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Boiler & Pressure Vessel Code - 2021.

**CERTIFIED INTERNATIONAL WELDING INSPECTOR**

*Signature*

**Nguyen Van Tan**  
 Cert No.: VN-SL-Hanoi  
 1178-140616-031-IIW

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**TRƯỞNG VIỆN CÔNG NGHIỆP THAN - KHÍ VÀ MỎ NĂNG LƯỢNG VÀ MỎ VINACOMIN**

*Signature*

**TRUNG TÂM TN-KĐCN**

This certificate according this code shall be considered as remaining in effect indefinitely unless: the welder is not engaged in a given process of welding for a period exceeding 6 months or there is some specific reason to question a welder's ability.