



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

**WELDER PERFORMANCE QUALIFICATION CERTIFICATION**

According to **AWS D1.1/D1.1M:2020**

Welder Performance Record No.: **WPQ-IEMM-BMVP-24-003**

Date of Issue : Mar. 09<sup>th</sup> 2024



Welder Name: Mr. **HO VAN DUONG**

Date of birth: **18 - Dec - 1994**

ID card: **042094001776**

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

Type: **Semi-Automatic**

Identification of WPS followed: **BM-WPS-FCAW-002**

Rev.: **0**

Specification of base metal(s): **A36 to A36**

Test Dated: Mar. 08<sup>th</sup> 2024

Testing Centre: **TESTING AND VERIFICATION CENTER FOR INDUSTRY (TVCI)  
 LABORATORY OF MATERIALS – NDT – EMC (VILAS 182)**

**Testing Conditions and Qualification Limits**

Welding Variables	Actual Values Used in Qualification	Qualification Range
Welding process(es)	FCAW	FCAW
Type (ie: manual, semi-auto) used	Semi-Automatic	Semi-Auto/ Mechanized/ Auto
Backing (metal, weld metal, double-welded, etc.)	With/ Ceramic backing	With backing
<input checked="" type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter if pipe or tube)	-	Plate, OD ≥ 600 mm
Thickness (mm)	12.0mm	Groove: from 3.0 mm to 30 mm
		Fillet: from 3.0 mm to Unlimited
Base metal Group-Number to Group-Number	G-Number I to I	Any AWS D1.1 Qualified Base Metal/ Any Gr. I to Gr. I
Filler metal or electrode specification(s) (SFA)	SFA-5.20	SFA-5.xx
AWS Classification	E71T-1C	All
Filler metal F-Number(s)	F6	All F6
Filler type (solid/metal or flux cored/powder)	Flux core	Flux core
Single or Multiple Electrodes	Single	Single
Position qualified (2G, 3G, 4G, 3F, 4F, etc.)	3G	Groove: F, H, V
		Fillet: F, H, V
Vertical progression (uphill or downhill)	Uphill	Uphill
Shielding gas (GTAW, PAW, GMAW, FCAW,...)	AWS A5.32 SG-C	Approved by AWS A5.32/ A5.xx
Current type/polarity (AC, DCEP, DCEN)	DCEP(+)	DCEP(+)
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 ultrasonic examination results: the report No.: **VCN VX03-24-UT**

Sample/ Identification	Result
HO VAN DUONG -3G	Acceptable

Operator: Mr. Nguyen Thanh Nam UT Level II

Dated: March 08<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 the **AWS D1.1/D1.1M:2020 – Structural Welding Code Steel.**

VINACOMIN – INSTITUTE OF ENERGY AND MINING MECHANICAL ENGINEERING  
 VIEN TRUONG



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.