



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 - 2023**

Welder Performance Record No.: **WPQ-IEMM- BMVP-24-004**

Date of Issue : Mar. 09th 2024



Welder Name: Mr. **NGUYEN VAN QUAN**

Date of birth: **29 - Aug - 1988**

ID card: **030088019967**

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

Type: **Manual**

Identification of WPS followed: **IEMM-WPS-HB-02**

Rev.: **0**

Specification of base metal(s): **SCH80 to SCH80**

Test Dated: Mar. 08th 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)	GTAW+SMAW	GTAW + SMAW
Type (ie: manual, semi-auto) used	Manual	Manual
Backing (metal, weld metal, double-welded, etc.)	Without/ Base metal	With/ Without
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter if pipe or tube)	OD 114.3mm	75mm to unlimited
Thickness (mm)	8.56 mm	from 1.5 mm to 17.12 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-5.1	SFA-5.xx
AWS Classification	ER70S-6/ E7015	All
Filler metal F-Number(s)	F6/ F4	All F6/ F1 thru F4
Filler type (solid/metal or flux cored/powder)	Solid/ Electrode	Bare/ Solid/ Electrode
Single or Multiple Electrodes	Single	Single
Deposit thickness for each process (GTAW/ SMAW)	GTAW: 3.00 mm SMAW: 5.56 mm	GTAW: max 6.0 mm SMAW: max 11.12 mm
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)	GTAW: DCEN SMAW: DCEP	GTAW: DCEN (-) SMAW: 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
- Alternative radiographic examination results: the report No.: **VCN-VX03 -24-RT**

Sample/ Identification	Result
NGUYEN VAN QUAN - 6G	Acceptable

Operator: Mr. Nguyen Van Tan RT Level II

Dated: March 08th 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 - 2023.**

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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.