

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-24-006

Date of Issue: Mar. 23rd 2024



Welder Name:

Mr. LE DUC CHIEN

Date of birth:

20 - Sep - 1984

FCAW

ID card: 042084009141

Welding process(es) used:

Specification of base metal(s):

FCAW

Type: Semi-Automatic

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

A36 to A36

Rev.: 0

Test Dated: Mar. 22nd 2024

Testing Centre:

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

CONTROL CONDITIONS and Qualification Limits

Walding Wariables	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	
☑Plate ☑Pipe (enter diameter if pipe or tube)		Plate, OD ≥ 600 mm	
	ickness (mm) 12.0mm	Groove:	from 3.0 mm to 30 mm
I nickness (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.)	3 G	Groov	e: 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	
	CALL AND THE RESIDENCE AND AND ADDRESS OF THE PARTY NAMED IN		

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:	
☑ Alternative ultrasonic examination results: the report N	o.: VCN VX04-24-UT-2
Sample/ Identification	Result
LE DUC CHIEN -3G	Acceptable
C	

Operator: Mr. Nguyen Thanh Nam UT Level II

Dated: March 22nd 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.

Nguyen Van Tan
VN-SL-Hanoi
1178-140616-031-IIW

VINACOMIN – INSTITUTE OF ENERGY AND MINING MECHANICAL ENGINEERING

MINING MECHANICAL ENGINEERING

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HOÙNG

THẨU CHÁNG

VÀ MỘ

VÌNACONN

HOÙNG

THÁI

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.