

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-24-010

Date of Issue: Mar. 23rd 2024

Welder Name:

Mr. LE VIET THANG

Date of birth:

06 - Dec - 1992

ID card: 038092049558

Welding process(es) used:

FCAW

Type: Semi-Automatic

Specification of base metal(s):

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

Rev.: 0

Testing Centre:

Test Dated: Mar. 22nd 2024 A36 to A36 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	
☑Plate ☐Pipe (enter diameter if pipe or tube)		Plate, OD ≥ 600 mm	
Thickness (mm)	12.0mm	Groove:	from 3.0 mm to 30 mm
			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 Ģ	Groove	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	

RESULTS

☑ Visual Examination of Completed Weld:No def	ects. Results in Acceptable		
☐ Bend test; ☐ Transverse root and face:	NA		
□ Longitudinal root and face:			
☐ Pipe bend specimen, corrosion-resistant overlay:			
☑ Alternative ultrasonic examination results: the report No.: VCN VX04-24-UT-6			
Sample/ Identification	Result		
LE VIET THANG -3G	Acceptable		

Operator: Mr. Nguyen Thanh Nam 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.

UT Level II

CERTIFIED INTERNATIONAL WELDING INSPECTOR Nguyen Van Tan Cert No.: VN-SL-Hanoi 1178-140616-031-IIW VINACOMIN - INSTITUTE OF ENERGY AND

MINING MECHANICAL/ENGINEERING C 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.