



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-24-011**

Date of Issue : Mar. 23<sup>rd</sup> 2024



Welder Name: Mr. **LE QUOC KHANH**

Date of birth: **02 - Sep - 1990**

ID card: **040090023603**

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. 22<sup>nd</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

**Hi-tech 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 VX04-24-UT-7**

Sample/ Identification	Result
LE QUOC KHANH -3G	Acceptable

Operator: Mr. Nguyen Thanh Nam UT Level II  
Dated: March 22<sup>nd</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**.



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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.