

Weld qualification test report

Report number	LW21-1306-1 WPWQ
Customer	Asme Welding Pty Ltd
Address	14 Industrial Drive Sunshine VIC Australia 3020
Requested by	Kenny Nguyen
Purchase Order	PO-1782
Test activity dates	17/07/2021
Description	Welder qualification testing
Identification	DOW-034
WPS No.	FP-035
Weld No.	F35-L
Welders name	Not Provided
Welders ID	AP-052
Material shape	Pipe to pipe
Joint type	Butt weld - single V
Thickness	T1: 6.02mm T2: 6.02mm
Diameter (NB/OD)	Pipe 1: 100mm Pipe 2: 100mm
Weld process	GTAW
Weld position	6G
Material Grade	ASTM A106/A106M-18 Grade B
Heat number	Not advised by the client
Weld consumable	ER70S-6
Test results	Refer to the following summary and details on the following pages.

Macro test	Complied
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ISO/IEC 17025 – Testing
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Refer to the following pages for details of test conducted and Signatories.

Macro test

Accredited branch LMATS Melbourne Laboratory
Job address 14 Industrial Drive Sunshine VIC Australia 3020
Test specification AS 3992:2020 - Clause 6.1.5 (WPWQ qualification), AS/NZS 2885.2:2020
Test method AS/NZS 2205.5.1:2019 (ISO 17639:2003)
Specimen location Location as per specification Standard
Preparation Cold cutting followed by stage grinding to P#1000 coated abrasives
Etchant & process 10% Nital swabbing
Weld geometry Refer to the photographs (0.5mm graduation on scale, if available) on the following pages.
Approved tester Nandkishore Chavan

Specimen 1	Magnification x 5 approximately (refer to the photograph)	Test date	17/07/2021
Weld passes	5		
Discontinuities	Nil		
Comments	Nil		
Test results	The test results comply with the specification requirements.		



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Signatory
(AINDT MT PT L2)



Prakash Salian
19/07/2021



Image 1 of 1 - Macro Specimen 1

Normative notes:

1. All test and inspection items will be discarded after 6 weeks, unless retrieved by the clients representative
2. Samples, identification of samples and all job specific details were supplied by the client.
3. Any stated nominal pipe sizes and nominal thickness of the material were provided by the client.
4. Where applicable, the Measurement Uncertainty (MU) applies to the test results as per LMATS procedure. MU can be obtained by contacting one of the LMATS ISO 17025 accredited laboratory.
5. If this report does not specify acceptance criteria, then the test or inspection results should be referred to a competent authority for further action.
6. This report shall not be reproduced except in full without approval of the issuing laboratory to ensure that parts of a report are not taken out of context. The client or their representatives shall not edit this report.
7. LMATS or its professional indemnity insurance provider do not indemnify the contents within this report or the conformity of a tested product unless the invoice for the reported work is paid in full within the agreed credit terms. Reports will be revoked if the invoice for the completed work is not paid in full.

Abbreviations used in this report

A - No discontinuities detected	KC - Crater crack	SED - Excessive Dressing (underflushing)
BT - Burn (melt) Through	KL - Longitudinal crack	SGL - Incompletely filled Groove
C - Comply	KT - Transverse crack	SGS - Shrinkage Groove
CP - Crater Pipe	LI - lack of Inter-run fusion	SMG - Grinding Mark
DNC - Does Not Comply	LP - Incomplete root Penetration	SMH - Hammer Mark
EC - Elongated Cavity (hollow bead)	LR - lack of Root fusion (missed edge)	SMT - Tool Mark (chipping mark)
GP - Gas Pore	LS - lack of Side fusion	SRC - Root Concavity (Suck back)
HiLo - Linear misalignment	NRRD - No Recordable Reflections Detected	SSP - Spatter
IC - Copper Inclusion	NUSID - No unacceptable Surface Indications Detected	SUC(e) - Undercut External
IL - Linear Inclusion (slag line)	p.d. - Processing / film Defects	SUC(i) - Undercut Internal
IN - Inclusion	PG - Localized Porosity	SXP - Excessive Penetration
IO - Oxide Inclusion (wagon tracks)	PL - Linear Porosity	WH - Worm Hole
IT - Tungsten Inclusion	PU - Uniform Porosity	

End of LMATS report. Information included on the following pages (if any) was provided by the client.