Pqr format as per asme sec. ix

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ASME Section IX - Welder Performance Qualification (WPQ)

Welder's name	Elder Z.W.	FOTO	Test date	9/15/00	
ID number	555-55-5555		WPQ record number	xyz	
Stamp number	ZWE-01		Standard test number	xyz	Rev. 0
Company name	Welding Ezine SOLDADURALATINOAMÉRICA		WPS record number	xyz	Rev. 0
Division	C-spec ASME and Welding Software Testing Lab		Qualification code	ASME Section IX	

BASE METALS (QW-403)

	Product form	Specification type or grade	P no.	Grp no.	Size	Sch.	Thick. (in.)	Dia. (in.)
	Pipe	SA-106 (B)	1	1	8	XX	0.875	8.625
Welded to:	Pipe	SA-106 (B)	1	1	8	XX	0.875	8.625

Joint type	Groove						
VARIABLES		Actual values			Range qualified		
Type of weld joint		Pipe - Groove			Groove and Fillet welds		
Base metal		P1 to P1			P-no./S-no. 1 thru 11, 34, 4X		
BASE METAL THICKNESS		Groove	Fillet	Overlay	Groove	Fillet	Overlay
Plate thickness	(in.)	-	-	-	no limit	no limit	-
Pipe/tube thickness	(in.)	0.875	-	-	no limit	no limit	-
Pipe diameter	(in.)	8.625	-	-	2.875 min	no limit	-
PROCESS VARIABLES		Actual values			Range qualified		
Welding process		GTAW	SMAW	FCAW	GTAW	SMAW	FCAW
Type		Manual	Manual	Semi-automatic	Manual	Manual	Semi-automatic
Backing:		None	Weld metal	Weld metal	With, without	With	With
Filler metal specification		5.18	5.1	5.20	5.xx	5.xx	5.xx
Filler metal classification		ER70S-2	E7018	E70T-1	Any	Any	Any
Filler metal F-number		6	4	6	6	1..4	6
Filler metal variety (QW-404.23)		Bare (solid)		Flux cored	Solid, metal cored		
Consumable insert		None			Without		
Weld deposit thickness (in.)		0.250	0.350	0.2625	0.5 max	0.7 max	0.525 max
Weld position	(Actual position tested)	6G	6G	6G			
Groove - Plate & Pipe >					All	All	All

[redacted]

SET 6
API 510 Preparatory Course

1. The purpose of the QPS and PQR is to accelerate that:
   a. the welder is qualified
   b. the base materials are properly brought
   c. the weldment has the desired properties
   d. the cost of the welder
2. The QPS lists:
   a. nonessential variables
   b. Essential variables
   c. Ranges of 1. & 2. above
   d. All of the above
3. The PQR must list:
   a. mechanical variables
   b. qualification test & examination results
   c. supplementary essential variables (where notch toughness is necessary)
   d. All of the above
4. What is the earliest Edition of Section IX recognized by the current edition?
   a. 1968
   b. 1950
   c. 1981
   d. 1962

S.N.	Outside diameter (OD) of the test coupon in mm (inches)	Qualified Outside diameter (OD) in mm (inches)	
		Minimum OD	Maximum OD
1	OD Less than 25 mm (1")	Size welded	Unlimited
2	25 mm (1") to 73 mm (2-7/8")	25 mm (1")	Unlimited
3	More than 73 mm (2-7/8")	73 mm (2-7/8")	Unlimited

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4. If $f(x)=\dfrac{x}{x-\frac{a}{x}}$ and $f'(1)=\dfrac{1}{2}$, what is the value of a?

(A) $-\dfrac{5}{2}$ (B) -1 (C) $\dfrac{1}{2}$ (D) 2 (E) $\dfrac{5}{2}$

---

5. If $y=4\sqrt{x}-16\sqrt[4]{x}$, then $y''=$

(A) $\sqrt[4]{x}-3$ (B) $-3\sqrt{x}+3$ (C) $\dfrac{-\sqrt[4]{x}-3}{x\sqrt{x}}$ (D) $\dfrac{\sqrt{x}-3}{x\sqrt[4]{x}}$ (E) $\dfrac{-\sqrt[4]{x}+3}{x\sqrt[4]{x^3}}$

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6. If $y=x^2\cdot f(x)$, then $y''=$

(A) $x^2f''(x)+xf'(x)+2f(x)$

(B) $x^2f''(x)+xf'(x)+f(x)$

(C) $x^2f''(x)+2xf'(x)+f(x)$

(D) $x^2f''(x)+4xf'(x)+2f(x)$

(E) $x^2f''(x)+4xf'(x)+4f(x)$

---

7. Let $f(x)=\dfrac{1}{2}x^4-10x^3+12x$. What is the value of $f(x)$, when $f''(x)=0$?

(A) $-\dfrac{23}{4}$ (B) $-\dfrac{3}{2}$ (C) $\dfrac{1}{2}$ (D) 1 (E) $\dfrac{5}{2}$

Abbreviation Finder
PQT
Preliminary/Professional Qualification Test

Asme sec ix welder qualification range. Asme section ix welding procedure qualification. Asme section ix f numbers. Pqr format as per asme sec.ix.

Welding Procedure Specification (WPS) : Welding Procedure Specification is written procedure prepare to Provide direction for Making Sound Production Weld as per Code Requirements.WPS Consist of Welding Variables Such as Essential Welding Variable, Supplementary Variables and Non Essential variables.Essential Welding Variables : This Variables are related to Mechanical Properties of Weld Joints. Any Changes in this variables affect Mechanical properties of Weld Joints so if you want to change any variables it needs to re-qualify Welding Procedure Specification (WPS)Supplementary Variables : This Variables are related to Toughness Properties of Weld Properties of Weld Joints. Any Changes in this variables affect Toughness properties of Weld Joints so if you want to change any variables it needs to re-qualify Welding Procedure Specification (WPS). But this variables are applicable only if material required toughness properties.Non Essential Variables : This Variables Does not affect any Mechanical Properties So any Changes in this variables does not required to re-qualify Welding Procedure Specification.Procedure Qualification Record (PQR) : Procedure Qualification Record is a compiled document of Recorded Values of All Variables during Welding and It also includes Test Result of Tested Specimen or Weld Coupon welded by Welder.PQR Consist of Real time values of welding variables and test result documents of weld coupon. All PQR data should be recorded during welding process in witness of Inspection Authority of this Procedure Qualification.Welder Performance Qualification (WPQ) : Welder Performance Qualification is written Document that Certify that welder or Welding Operator is capable of Producing Sound weld joints as per code requirements.WPQ Consist of all variables related to welder performance and range of qualified values of Welder Performance. this Performance Qualification Test should also conducted with witness of Inspection Authority of Performance Qualification.This is documents proves the ability of Welder or Welding Operator as per job requirement.If you want to learn all concept of WPS PQR WPQ in details in Hindi then you can learn with us by enrolling in our 28 Days Video Course on ” WPS PQR WPQ Pro”. To Know more Course Details Click here…Overview of ASME Section IX CodeASME Section IX Code : It is reference code of Welding, Brazing and Fusing Qualification.ASME Section IX Code is four Sub Parts :Part QG – General Requirement of Welding, Brazing and Fusing.Part QW – WeldingPrat QB – BrazingPart QF – FusingPart QG – General Requirement for Welding, Brazing and FusingProcedure Specification (QG-101)Procedure Qualification Record (QG-102)Performance Qualification (QG-103)Performance Qualification Record (QG-104)Variables (QG-105)Organisational Responsibility (QG-106)Ownership Tranfer (QG-107)Qualification Made to Previous Editions (QG-108)Defintions (QG-109)Part QW – WeldingArticle I – Welding General Requirements.Article II – Welding Procedure Qualification.Article III – Welding Performance QualificationArticle IV – Welding DataArticle V – Standard Procedure Specification.This is overview of ASME Section IX on the point of Welding aspect as this Post is only Related to WPS PQR WPQ so we had considered only part related to Welding Qualifications.If you want to learn all concept of WPS PQR WPQ in details in Hindi then you can learn with us by enrolling in our 28 Days Video Course on ” WPS PQR WPQ Pro”. To Know more Course Details Click here…If you want to increase you knowledge in fabrication Pressure Vessels, Heat Ex-changer, Storage Tank, Piping and other Process Equipment then you can join our various video course know more Click here… December 20, 2016 December 20, 2016/ Ed Laforest This week’s blog is the first of three parts regarding ASME IX welding requirements. We will provide a brief description of how ASME IX is organized, used in referred codes, and then get into PQRs!Before we get started a great resource for understanding ASME IX from an auditing point of view can be found here. This document contains valuable information from the ASME IX committee regarding what they consider important for PQRs and WPSs. IX OrganizationASME IX is organized in 4 parts. Part QG contains general requirementso It provides a scope description of ASME IX and definitions that apply to all material joining processes. Part QW contains the welding requirementso This will be the main focus of these parts in this blog, see below.Part QB contains the brazing requirementso Brazing is broken into 4 articles detailing the requirements for brazing.Part QF contains the plastic fusing requirements.o Plastic fusing is broken into 2 articles detailing the requirements for plastic fusing. Part QW is sub-divided into 5 articles.Article I – Welding general requirementso This article section defines the scope of this part, responsibilities in the organization, provides reference to test positions for groove and fillet welds located in article IV, and provides the types and purposes of tests and examinations used in the other articles for this part.Article II – Welding Procedure Qualificationso This article defines the requirements for welding procedure specifications (WPS) and procedure qualification records. It makes reference to article IV for essential and non-essential variables and testing.Article III – Welding Performance Qualificationso This article deals with the requirements for welding performance qualifications (WPQ). It makes reference to article IV for essential variables and testing related to welder qualifications.Article IV – Welding Datao This article contains the welding data referenced in the other articles. It contains the variables for welding procedure and welding performance qualifications, base metal groupings, F and A numbers, qualification ranges for WPS and WPQ, positional reference figures, and etching testing requirements.Article V – Standard Welding Procedure Specifications (SWPSs)o This article contains the requirements for use of Standard welding procedure specifications (SWPSS).ASME IX is not a standalone code for use. It is referenced is other construction codes such as ASME Section VIII Division 1, 2, and 3, and the ASME B31 codes (B31.3, B31.1, etc.). Its implementation is typically through these construction codes which may add or remove specific requirements. As a result the starting point for use of ASME IX is through the construction code of reference.ASME IX Procedure Qualification Record (PQR)What is a PQR?The starting point for procedure qualification records is in Part QW-200. The PQR is a record of variables recorded during the welding of the test coupons. It also contains the test results of the tested specimens. As stated in the introduction of ASME IX: “The purpose of the Procedure Qualification Record (PQR) is to ensure the material joining process proposed for construction is capable of producing joints having the required mechanical properties for the intended application. Personnel performing the material joining procedure qualification test shall be sufficiently skilled. The purpose of the procedure qualification test is to establish the mechanical properties of the joint produced by the material joining process and not the skill of the personnel using the material joining process. In addition, special consideration is given when toughness testing is required by other Sections of the Code. The toughness supplementary essential variables do not apply unless referenced by the construction codes.”. So essentially the purpose of the PQR is to prove the parameters you have used for a particular welding process on a particular material / welding metal group meets the minimum mechanical properties requirements in ASME IX. Toughness testing is a separate issue.How to prepare a PQR?Once you have determined the welding process(s) a review the referenced construction codes the WPS you plan to create based on this PQR will be used in is needed. The construction codes may have restrictions, addition requirements or exemptions to ASME IX and you want to make sure you understand them before you start. For example, ASME Section VIII Division 1 UG-84 has provisions that would make toughness testing mandatory for certain materials and thicknesses or UCS-56 or UW-2 has mandatory post weld heat treatment requirements. Understanding these requirements before you create a PQR can reduce the number of procedure qualification tests that you will need.Once you have determined if any requirements have been imposed by the construction code it is time to make reference to QW-250. The tables in QW-250 make reference to all the essential, non-essential, special process and supplementary essential variables. These variables are defined in QG-105. As noted in QW-200.2, a PQR shall document all essential and when required supplementary essential variables. This means that the PQR you create must as a minimum address the corresponding essential variables in the tables for the welding processes you have used in QW-250. Supplementary essential variables become essential variables when toughness testing is required, typically from the referenced construction code and become non-essential variables when toughness testing is not required. From a PQR standpoint non-essential variables are not required to be documented. Properly addressing essential variables can be issue as well. For example stating N/A or not applicable to essential variables in a PQR document technically has not addressed the variable if it is applicable to your process. The correct phrase would be not used, this clearly addresses the variable.For all PQRs the base metal thickness range (QW-403.8) and P. No. (QW-403.11) are essential variables. Section QW-451 provides qualification thickness ranges based on the test coupon that was used. For example, a 0.375” test coupon will qualify the referenced WPS from 0.0625” to 0.75” in material thickness. This thickness range can be affected by the welding process and other essential / supplementary essential variables referenced in QW-250, it is best to review all variables before you determine the thickness of your test coupon. An overlooked aspect of developing a PQR is nozzle or branch connection attachments. Typically the thickness of the shell and nozzle of the welded joint will have different thicknesses. Let’s say you qualify a WPS with a thickness range of 0.0625” to 0.75”, during fabrication you have to weld a nozzle with thickness of 0.2” to an ASME B16.5 blind flange that is 2” thick. Can you do this? The answer is it depends. Section QW-202.4 details these requirements.Base metals are assigned P-numbers to reduce the required number of welding procedures that are required. For example P. No. 8, represents 304, 316, 321, 347, and more base metals. Table QW-422 provides a complete list. A great lookup resource is filler metal selection is another important part of the PQR. Reviewing ASME II Part C is a great resource, below is a table reference to easily review the correction SFA specification. ASME SFA Specification Reference Table Welding Process Material Type OFW SMAW GTAW GMAW PAW FCAW SAW ESW EGW Brazing Carbon Steel SFA 5.2 SFA 5.1 SFA 5.18 SFA 5.36 SFA 5.20 SFA 5.36 SFA 5.17 SFA 5.25 SFA 5.26 SFA 5.8 Low-Alloy Steel SFA 5.2 SFA 5.5 SFA 5.28 SFA 5.36 SFA 5.29 SFA 5.36 SFA 5.23 SFA 5.25 SFA 5.26 SFA 5.8 Stainless Steel SFA 5.4 SFA 5.9 SFA 5.22 SFA 5.22 SFA 5.8 Cast Iron SFA 5.15 SFA 5.15 SFA 5.15 SFA 5.8 Nickel & Nickel Alloys SFA 5.11 SFA 5.14 SFA 5.34 SFA 5.8 Aluminum & Aluminum Alloys SFA 5.3 SFA 5.10 SFA 5.8 Copper & Copper Alloys SFA 5.6 SFA 5.7 SFA 5.8 Titanium & Titanium Alloys SFA 5.16 SFA 5.8 Zirconium &Zirconium Alloys SFA 5.24 SFA 5.8 Tungsten Electrodes SFA 5.12 SFA 5.8 Brazing Alloys SFA 5.8 Brazing Fluxes SFA 5.31 Consumable Inserts SFA 5.30 Shielding Gases SFA 5.32 SFA 5.32 Surfacing Alloys SFA 5.13 SFA 5.21 SFA 5.13 SFA 5.21 SFA 5.13 SFA 5.21 SFA 5.8 The guides in some of the referenced ASME SFA specification have great information concern the welding process, filler metal and appropriate gases to use. Another great resource is the weld metal material suppliers shall as Lincoln Electric, Kobelco, Air Liquid, etc.This post would be too large if we went into all the other essential and supplementary essential variables, the process would be to review the table is QW-250, lookup the variables and adequately address it in your PQR.Once you have developed your PQR from a document standpoint, the next step is to determine the welding parameter ranges that work for your procedure. The starting point can be from reference material such as the arc welding handbook or the weld metal material suppliers published documents.Once satisfactory test pieces have been made, the destructive testing requirements in QW-202 would need to be followed. If successful, the result would be included in the PQR and then signed and dated by the fabricator to certify the results.Below are a few other important things to consider:First, for Canada most provinces require registration of WPSs and PQRs. It is a common misconception that the provinces certify these documents. The provinces only register these procedures. They may point out errors or mistakes but the responsibility is solely with the fabricator. QW-200.2(b) highlights this as well by stating “…The PQR shall be certified accurate by the organization. The organization may not subcontract the certification function. This certification is intended to be the organization's verification that the information in the PQR is a true record of the variables that were used during the welding of the test coupon and that the resulting tensile, bend, or macro (as required) test results are in compliance with Section IX….”. Also changes to PQRs are permitted as outlined in QW-200.2(c) (and the Introduction) but only editorial corrections or addenda, as long as an essential variable has not changed and the PQR can be revised. Adding supplementary essential variable will require re-qualification. Re-registering procedures with these changes is not practical or worth the cost.Finally, the main focus of ASME IX PQR documents is to demonstrate mechanical properties for a given joining process. There is no mention of corrosion resistance or microstructure. For example no purging or nitrogen back purging can be used to weld 316 stainless steel. The finished product would be acceptable for ASME IX requirements but not for the service it may be intended for. Another example is duplex stainless steel. Fabricators typically do not perform macro etching to determine the ratio of austenite to ferrite in the base metal, HAZ and weld metal. This can have an affect on corrosion resistance.

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