

Seismic Energy Products  
518 Progress Way  
Athens, Texas 75751

Welder or Welding Operator Qualification Test Record (WPQR)

Welder's Name: Whitley, Jeremy Stamp: 7442  
 Test WPS No. SEP.312, .375, .500 Rev.: 0 WPO No.: 7442 Date: 6/20/2011 Page 1  
 Type of joint welded: Plate Fillet weld  
 Joint type(s) qualified: All applicable fillet welds (except T-, Y- & K-connection fillet welds)  
 Base metal(s) welded: ASTM 709 Grade 50W (A588) to ASTM 709 Grade 50W (A588)

Variables (Table 4.12)	Actual Values Used		Range Qualified
	FCAW / Semiautomatic	FCAW / Semiautomatic, Machine, and Automatic	
Welding process / type	N/A		N/A
Base metal thickness - groove (in.)	1/2"		1/8" to unlimited
Base metal thickness - fillet (in.)	N/A		N/A
Pipe diameter - groove (in.)	N/A		All diameters
Pipe diameter - fillet (in.)	N/A		All sizes
Box tube size (in.)	90		60° to 135°
Dihedral angle - fillet	Backing used		With backing only
Racking	E8111-Ni1		
Filler metal classification	5.29		
Filler metal specification	6		N/A
Filler metal F-No.	N/A		N/A
Welding position - groove	2F - Horizontal		Flat & Horizontal
Welding position - fillet	N/A		N/A
Weld progression	100% CO2		
Shielding gas	DCEP (reverse)		
Welding current / polarity	N/A		N/A
Transfer mode (GMAW)	N/A		N/A
Single / multiple electrode			

Notes:

Visual inspection acceptable: Yes Other test results:

Fillet Test Results

Appearance: Acceptable Fillet size: 5/16"  
 Fracture test root penetration: Acceptable Macroetch: Acceptable  
 Organization: Red Ball Oxygen Test No.: 7442-06-20-2011

Inspected by: Steven D. Downing



STEVEN D. DOWNING  
 Date: 6/20/2011 CWI/CWECRI/ASNT Lv II

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in conformance with the requirements of AASHTO/AWS D1.5M/D1.5, 2010 Bridge Welding Code

Manufacturer or Contractor: Seismic Energy Products

Certified By: \_\_\_\_\_ Date: \_\_\_\_\_

Vermont Agency of Transportation

**RECEIVED**

CK'D BY \_\_\_\_\_ OK'D BY JC

February 13, 2015

RESUBMIT NO Approved

BY KH DATE 3-5-2015