GIBBONS ERECTORS

WELDING PROCEDURE SPECIFICATION, **WELDING PROCEDURE QUALIFICATION TEST RECORD (PQR)** AND WELDER QUALIFCATION TEST RECORD

Company Name GIBBONS ERECTORS By GREG GIBBONS

Welding Procedure Specification No. . GE-AWS D1.4 WPS NO.1 Date OCTOBER 28, 2004

Supporting PQR No.(s) . GE AWS D1.4 PQR NO.1 Revision No. _____ Date _____

Material Specification ASTM A706 GR. 60

Bar Size #4

Bar Coating Type NA

Root Treatment NA

Backing Material NA

Position of Welding 1G

Welding Process SMAW

Manual, Semi-Automatic, or Automatic MANUAL

Filler Metal Specification 5.1

Filler Metal Classification E8018

Weld Metal Grade 80 KSI

Electrical Characteristics ____ AC. X DCEP ____ DCEN

Mode of Transfer NA

Shielding Gas/Combination NA

Gas Flow (CFH) NA

Carbon Equivalent .42

Preheat and Interpass Temperature NONE

TEST RESULTS

Tensile Strength, PSI

1. 89,681
2. 89,936

Macroetch Tests

1. ACCEPT
2. ACCEPT

Visual Examination Results

Fusion ACCEPT

Reinforcement ACCEPT

Porosity NONE

Undercut NONE

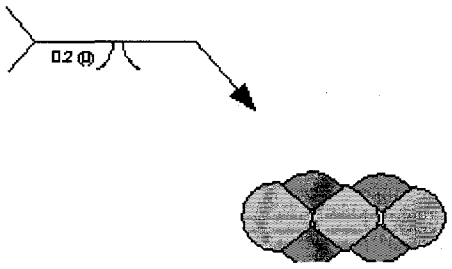
Cracks NONE

NDT Examination

Type NA

Results NA

WITNESSED BY: BOB POLLOCK QC-1/CWI

Pass No.	Electrode Size	Welding current		JOINT DETAIL
		Amperes	Volts	
1	1/8"	170	28	

AWS QC 1 J. H. FERGUSON, JR. 84010231 CWI

Welder or Welding Operator Name CHRIS HAYDEN

Identification No. _____ Date of Qualification OCTOBER 28, 2004

Welder's Social Security No. _____

Tests Conducted By: INTERMOUTAIN TESTING COMPANY By: J.H. FERGUSON Lab Test No. 541-04

The undersigned certifies that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of ANSI/AWS D1.4 (1998), Structural Welding Code – Reinforcing Steel.

(Year)

Manufacturer or Contractor GIBBONS ERECTORS

Authorized by GREG GIBBONS Date OCTOBER 28, 2004

GIBBONS ERECTORS

WELDING PROCEDURE SPECIFICATION, WELDING PROCEDURE QUALIFICATION TEST RECORD (PQR) AND WELDER QUALIFCATION TEST RECORD

Company Name GIBBONS ERECTORS By GREG GIBBONS

Welding Procedure Specification No. . GE-AWS D1.4 WPS NO.1 Date OCTOBER 28, 2004

Supporting PQR No.(s) . GE-AWS D1.4 PQR NO.1 Revision No. _____ Date _____

Material Specification D1.4 GROUP I or II

Bar Size #4 AND SMALLER

Bar Coating Type NA

Root Treatment NA

Backing Material NA

Position of Welding FLAT

Welding Process SMAW

Manual, Semi-Automatic, or Automatic MANUAL

Filler Metal Specification 5.1

Filler Metal Classification E8018

Weld Metal Grade 80 KSI

Electrical Characteristics _____ AC. X DCEP _____ DCEN

Mode of Transfer NA

Shielding Gas/Combination NA

Gas Flow (CFH) NA

Carbon Equivalent .42 & LOWER

Preheat and Interpass Temperature NONE REQ.

PQR WITNESSED BY BOB POLLOCK QC-1/CWI

TEST RESULTS

Tensile Strength, PSI

1. 89,681
2. 89,936

Macroetch Tests

1. ACCEPT
2. ACCEPT

Visual Examination Results

Fusion ACCEPT

Reinforcement ACCEPT

Porosity NONE

Undercut NONE

Cracks NONE

NDT Examination

Type NA

Results NA

Pass No.	Electrode Size	Welding current		JOINT DETAIL
		Amperes	Volts	
1	1/8"	160-200	26-29	PROCEDURE IS QUALIFIED FOR INDIRECT BUTT JOINTS BAR TO BAR PER FIGURE6.5 (D) 

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