

# Keystone - API-1104 Welder Qualification Form

Form W8 Rev 0



Welder's Name (print) <b>Mathew K. Linehan (DL#082143627 Ok.)</b>	Welder's ID Stamp <b>3177</b>	Test Location, Project and/or Spread No. <b>Livingston West Pipe Yard Gulf Coast - Spread 3</b>
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### TEST CONDITIONS

	Test 1 Single Qual	Test 2 Multiple Qualification	
Weld Type	Butt	Butt	Branch
Pipe Specification & Grade	API 5L X70		
Diameter of Test Pipe	36"		
Wall Thickness	.465"		
Centerline of Pipe Axis 2G, 5G, 6G	5G		
AWS Filler Metal Identification	A.5.1/A.5.5		
Welding Procedure Specification No.	KXL-SMAW-RP		

### WELDER QUALIFICATION BASED ON DESTRUCTIVE TEST AND RESULTS

Number of Test Completed Per Test	Nick	N/A		
	Face	N/A		
	Root	N/A		
	Side	N/A		

Visual Acceptable  Visual Not Acceptable  Welder Qualified  Welder Disqualified

### WELDER QUALIFICATION BASED ON NDE OF TEST BUTT WELD

NDT Method	<input checked="" type="checkbox"/> Radiographic Testing	Weld ID No. 3177	Radiographic Report No. Shaw D/67	X-Ray Film No.'s. 1
	<input type="checkbox"/> Ultrasonic Testing	Weld ID No.	Ultrasonic Report No.	Ultrasonic Data file name or No. (if applicable)

Visual Acceptable  NDE Acceptable  Welder Qualified  Welder Disqualified

### ESSENTIAL VARIABLES FOR WELDER QUALIFICATION (Mark With an 'X')

WELDING					Welding Equipment			API Filler Metal Group No. (1,2,3)	Welding Electrode Direction of Travel		Qualification	
SMAW	GMAW	SAW	GTAW	FCAW	Manual	Semi-Automatic	Automatic		Up	Down	Multi-Qual (All diameters, wall thickness, and positions)	Single (See Additional Limitations Below)
X					X			1,3	F/C	R	N/A	X

### ADDITIONAL LIMITATIONS (Mark with an 'X') ONLY COMPLETE THIS SECTION FOR SINGLE QUALIFICATION

Pipe						Position				Butt Weld		Fillet Weld	
Outside Diameter Inches		Wall Thickness Inches		Centerline of Pipe (Axis)		Position		Fixed	Rolled	60-70 Deg. Bevel	Mech. GMAW Welding Bevel	Branch Fillet	Lap Fillet
<2.375	≥2.375 ≤12.75	<.188	≥.188 ≤.750	>.750	Vertical 2G	Horizontal 5G	All Pipe Axis Positions						
	X		X			X		X		X			

Welding Inspector's Name (Please Print) | Welding Inspector's Signature | Date Of Test | Date of Qualification Expiry

Allen Le Blanc | *Allen Le Blanc* | Nov. 10, 2012 | 6 mths of Last Accepted weld

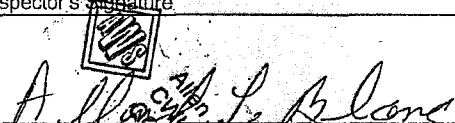

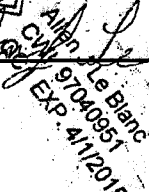
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Form W8 Rev 0



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## WELD PARAMETER DETAILS

Welding Consumables:							
Welding Position:	5 G	Welding Direction:	Root Down /Fill and Cap UP				
Welding Procedure:	KXL-SMAW-RP						
Weld pass # :	Root	Hot Pass	Fill/Strip	Cap			
Electrode Size:	1/8" E6010	3/32" E8018-C3	1/8" E8018-C3	1/8" E8018-C3			
Weld current:	DCRP	DCRP	DCRP	DCRP			
Weld voltage:	A=60-120 V=21-35	A=70-110 V=20-27	A=110-160 V=19-26	A=110-160 V=19-26			
Travel Speed:	3"-7" IPM 11.8-90.0 KJ/IN	2"-6" IPM 22.7-68.5 KJ/IN	3"-8" IPM 44.7-92.4 KJ/IN	3"-8" IPM 23.7-92.4 KJ/IN			
Welding Consumables:							
Welding Position:		Welding Direction:					
Welding Procedure:							
Weld pass # :							
Electrode Size:							
Weld current:							
Weld voltage:							
Travel Speed:							
Welding Inspector's Name (Please Print)			Welding Inspector's Signature				
Allen Le Blanc			 			Nov. 10, 2012	
							

# Keystone - API-1104 Welder Qualification Form

Form W8 Rev 1



Welder's Name (print) Larry J. Guilbeaux (DL#009297642 La.)	Welder's ID Stamp 3224	Test Location, Project and/or Spread No. Livingston West Pipe Yard Gulf Coast Spread 3
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### TEST CONDITIONS

	Test 1	Test 2
	Single Qual	Multiple Qualification
Weld Type	Butt	Butt Branch
Pipe Specification & Grade	API 5L X70	
Diameter of Test Pipe	36"	
Wall Thickness	.465"	
Centerline of Pipe Axis 2G, 5G, 6G	5G	
AWS Filler Metal Identification	A.5.1/A.5.5	
Welding Procedure Specification No.	KXL-SMAW-ML	

### WELDER QUALIFICATION BASED ON DESTRUCTIVE TEST AND RESULTS

Number of Test Completed Per Test	Nick	8	Accept
	Face	2	Accept
	Root	2	Accept
	Side	N/A	

Visual Acceptable  Visual Not Acceptable  Welder Qualified  Welder Disqualified

### WELDER QUALIFICATION BASED ON NDE OF TEST BUTT WELD

NDT Method	<input type="checkbox"/> Radiographic Testing	Weld ID No.	Radiographic Report No.	X-Ray Film No.'s.
	<input type="checkbox"/> Ultrasonic Testing	Weld ID No.	Ultrasonic Report No.	Ultrasonic Data file name or No. (if applicable)

Visual Acceptable  NDE Acceptable  Welder Qualified  Welder Disqualified

### ESSENTIAL VARIABLES FOR WELDER QUALIFICATION (Mark With an 'X')

WELDING					Welding Equipment			API Filler Metal Group No. (1,2,3)	Welding Electrode Direction of Travel		Qualification	
Welding Process					Manual	Semi-Automatic	Automatic		Up	Down	Multi-Qual (All diameters, wall thickness, and positions)	Single (See Additional Limitations Below)
SMAW	GMAW	SAW	GTAW	FCAW								
X					X			1,2	X	N/A	X	

### ADDITIONAL LIMITATIONS (Mark with an 'X') ONLY COMPLETE THIS SECTION FOR SINGLE QUALIFICATION

Pipe						Butt Weld			Fillet Weld				
Outside Diameter Inches		Wall Thickness Inches		Centerline of Pipe (Axis)		Position		Butt Weld		Fillet Weld			
<2.375	≥2.375 ≤12.75	<.188	≥.188 ≤.750	>.750	Vertical 2G	Horizontal 5G	All Pipe Axis Positions	Fixed	Rolled	60-70 Deg. Bevel	Mech. GMAW Welding Bevel	Branch Fillet	Lap Fillet
		X	X			X		X		X			

Welding Inspector's Name (Please Print) Allen Le Blanc	Welding Inspector's Signature 	Date Of Test Jan. 30, 2013	Date of Qualification Expiry 6 Months of Last Accepted Weld
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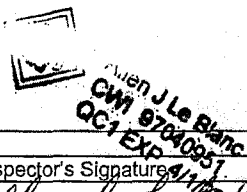
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**WELD PARAMETER DETAILS**

<b>Welding Consumables:</b>							
<b>Welding Position:</b>	5G			<b>Welding Direction:</b>	Down		
<b>Welding Procedure:</b>	KXL-SMAW-ML						
<b>Weld pass # :</b>	Root	Hot Pass	Fill	Cap			
<b>Electrode Size:</b>	5/32" E6010	5/32" E8010G/P1	3/16" E8010G/P1	3/16" E8010G/P1			
<b>Weld current:</b>	DCRP	DCRP	DCRP	DCRP			
<b>Weld voltage:</b>	A=108-171 V=19-27	A=149-216 V=20.7-32.0	A-140-220 VV=20.7-32	A=126-198 V=22.5-34			
<b>Travel Speed:</b>	10.8"-16.5" Kj 9-19.1	14.5"-18.7" kj 12.0-23.2	5.1"-12.4" kj 20.0-64.4	8.6"-16.2" kj 12.8-44.7			
<b>WFS (GMAW only):</b>	N/A	N/A	N/A	N/A			
<b>Welding Consumables:</b>							
<b>Welding Position:</b>				<b>Welding Direction:</b>			
<b>Welding Procedure:</b>							
<b>Weld pass # :</b>							
<b>Electrode Size:</b>							
<b>Weld current:</b>							
<b>Weld voltage:</b>							
<b>Travel Speed:</b>							
<b>WFS (GMAW only):</b>							
<b>Remarks:</b>							
							
<b>Welding Inspector's Name (Please Print)</b>				<b>Welding Inspector's Signature</b>			
Allen J. Le Blanc				