

Welder's Name: Michael Opdendries ABSA File No.: W-23699 Stamp No.: M
Identification of WPS followed by welder during welding of test coupon: WPS # HT-6-C.I.T & LT-8 W.P.Reg.: 2617.2
Base material(s) welded: SA 106 Gr B Wall Thickness: 8.7 mm Test Coupon ☒ Prod. Weld ☐

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)

Welding Process(es) Used:
Type of Welding (ie. Manual, Semi Automatic) Used:
Base Metal P No:
Plate ☐ Pipe ☒ (enter diameter if pipe or tube):
Backing (metal, weld metal, double welded, etc):
Filler metal or Electrode specification(s) (SFA) (info only):
Filler metal or Electrode Classification(s) (info only):
Filler metal or Electrode F-Number(s):
Filler Type (solid/metal or flux cored/powder) (GTAW or PAW):
Consumable Insert for GTAW or PAW:

ACTUAL VALUES		RANGE QUALIFIED	
GMAW (SC)	SMAW	GMAW (SC)	SMAW
MANUAL	MANUAL	MANUAL	MANUAL
P1 to P1		P1 thru P15F, P34 & P4X	
2.375" O.D.		25 mm OD Min	
Without	Weld Metal	With/Without	With
SFA 5.18	SFA5.1		
ER70S-6	E7018-1		
F6	F4	F6	F4
SolidWire	N.A.	SolidWire	N.A.
None	N.A.	None	N.A.
3 mm	5.7 mm	3.3 mm	11.4 mm

Deposit Thickness for each process or electrode type, etc. (in.):

Process/Electrode 3 layers minimum ☐ YES ☒ NO

3 layers minimum ☐ Yes ☒ No

Welding Position (2G,6G,3F, etc.):
Vertical Progression (Uphill or Downhill):
Fuel Gas for OFW or Inert Gas Backing for GTAW, PAW, GMAW:
Transfer Mode (spray/globular or pulse to short circuit- GMAW):
GTAW Current Type/Polarity (AC, DCEP, DCEP):

S/P (30 Degree)	1G	S/P (15 to 45 degree) & Flat	Flat
Downhill	N.A.	Downhill	N.A.
Without	N.A.	With/Without	N.A.
Short Circuit	N.A.	Short Circuit	N.A.
N.A.	N.A.	N.A.	N.A.

RESULTS

Visual Examination of Fit-Up; Root Gap: OK
Root Pass (Describe discontinuity if Unacceptable):
Completed Weld (Describe discontinuity if Unacceptable):
Bend Test: ☒ Transverse Root and Face(QW-462.3a)
☐ Pipe Bend Specimen, Corrosion-resistant overlay (QW-462.5c)
☐ Macro Test for Fusion (QW-462.5b)

Tack Welds: OK (Length: OK Number: OK)
OK
☐ Longitudinal Root and Face (QW-462.3b) ☐ Side (QW-462.2)
☐ Plate Bend Specimen, Corrosion-resistant overlay (QW-462.5d)
☐ Macro Test for Fusion (QW-462.5b)

Type	Result	Type	Result	Type	Result
Coupon 1 - Face Bend	Acceptable	-	-	-	-
Coupon 2 - Root Bend	Acceptable	-	-	-	-

For alternative qualification of groove welds by volumetric examination to QW-191:

RT RESULTS: NA

UT RESULTS: NA

Fillet Weld-Fracture Test (QW-182)(Describe location, nature and size of any crack or tearing of specimen):

NA

Length and Percent of Defects: NA

Inches: NA

Macro Test - Fusion (QW-184):

NA

Appearance - Fillet Size (leg): NA X NA Inch.

Convexity: NA Inch. or Concavity: NA Inch.

Other Tests:

NA

RECORD INFORMATION

Film or Specimen Evaluated By: Aravind Ajith Menon

Company: Canada Weld Test and Training Inc.

Mechanical Tests Conducted By: Aravind Ajith Menon

Laboratory test No: 5216

Welding Supervised By: Aravind Ajith Menon

We Certify that the statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code .

Accredited organization: CANADA WELD TESTING & TRAINING INC.

AOQP # 7318

Expiry Date:

September 6, 2022

Certified by: Aravind Ajith Menon

Examiner File No: E-00721

Date:

June 10, 2022

P.Q Card No. (When Issued): 5216

Performance Test Reference No.: 5216

Test Coupon I.D.No.: 5216

Date Coupon is to be retained to:

June 10, 2022

Test Witnessed by:

Fourstar Resources Inc.

*Certified by Fourstar Resources Inc
Victor Sengul*

**WELDER PQ CARD**

Card No: 5216

Michael Opdendries W-23699

P1 to P15F,

Process(es)	GMAW (Short Circuit)	SMAW	Material (P-No.)	P34 & P4X
Filler Metal Group (F-No.)	F6	F4	Min. Outside Pipe Diameter	25 mm
Max. Deposited Weld Metal	3.3 mm	11.4 mm	Position(s) Qualified	SP (30 degree) & F for Root; F for fill & cap
Backing	With/Without	With	Backing gas	With/Without
Progression	Downhill	N.A.		
June 9, 2024				E-00721
P.Q. Expiry Date			Welding Examiner Signature	Examiner File No

 **CANADA**
WELD TEST &
TRAINING INC.

PH: (780) 232-9394
www.CanadaWeld.ca

7318

A.O.Q.P No.

WELDER PERFORMANCE QUALIFICATION CARD

NAME: Michael Opdendries

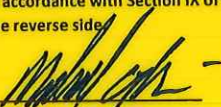
ABSA File No: W-23699

This card is issued in pursuant to the Alberta Safety Codes Act and Pressure Welders Regulation. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test June 10, 2022

Aravind Ajith Menon

Welding Examiner Name


Welder Signature

Card No: 5216