

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 # WPS4 (Rev.0)				W.P.Reg. 2617.2	
Base material(s) welded: A513 Gr.1026		Wall Thickness: 16 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: _____

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

Process/Electrode 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): _____

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)

ACTUAL VALUES		RANGE QUALIFIED	
SMAW	SMAW	SMAW	SMAW
MANUAL	MANUAL	MANUAL	MANUAL
P1 to P1		P1 thru P15F, P34 & P4X	
2.5" O.D.		25 mm OD Min	
Without	Weld Metal	With/Without	With
SFA 5.1	SFA 5.1		
E6010	E7018-1		
F3	F4	F3	F4
N.A.	N.A.	N.A.	N.A.
N.A.	N.A.	N.A.	N.A.
3 mm	13 mm	6 mm	Maximum to be welded

		3 layers minimum ☒ Yes ☐ No	
6G	6G	ALL	ALL
Uphill	Uphill	Uphill	Uphill
N.A.	N.A.	N.A.	N.A.
N.A.	N.A.	N.A.	N.A.
N.A.	N.A.	N.A.	N.A.

RESULTS

Tack Welds: OK (Length: OK Number: 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 - Side Bend	Acceptable	Coupon 3 - Side Bend	Acceptable	-	-
Coupon 2 - Side Bend	Acceptable	Coupon 4 - Side Bend	Acceptable	-	-

For alternative qualification of groove welds by volumetric examianition 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: 5607

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 TEST & TRAINING INC. AOQP # 7318 Expiry Date: September 6, 2025

Certified by: Aravind Ajith Menon Examiner File No: E-00721 Date: November 27, 2022

P.Q Card No. (When Issued): 5607 Performance Test Reference No.: 5607

Test Coupon I.D.No.: 5607 Date Coupon is to be retained to: November 27, 2022

Test witnessed by: Victor Shyngster

Certify by Fourstar Resources Inc

Victor Shyngster



PH: (780) 232-9394

7318

www.CanadaWeld.ca

A.O.Q.P. No.

WELDER PERFORMANCE QUALIFICATION CARDNAME: Michael OpdendriesABSA 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 November 29, 2022Aravind Ajith Menon

Welding Examiner Name


Welder Signature

Card No: 5607

CANADA WELD TEST & TRAINING INC.		WELDER PQ CARD		Card No: 5607
Michael Opendries		W-23699	P1 to P15F, P34 & P4X	
Process(es)	SMAW	SMAW	Material (P-No.)	
Filler Metal Group (F-No.)	F3	F4	Min. Outside Pipe Diameter	25 mm
Max. Deposited Weld Metal	6 mm	Maximum to be welded	Position(s) Qualified	All
Backing	With/Without	With	Backing gas	N.A.
Progression	Uphill	Uphill		
November 28, 2024				E-00721
P.Q. Expiry Date	Welding Examiner Signature			Examiner File No