

Sample Welder Qualification Blank Form (Single-Process)
WELDER, WELDING OPERATOR, OR TACK WELDER
PERFORMANCE QUALIFICATION TEST RECORD

Name		Test Date		Rev.
ID Number		Record No.		
Stamp No.		Std. Test No.	W-67	
Company		WPS No.	WPS-D1.1-GMAW-1	
Division		Qualified To	Standard D1.1	

BASE METALS	Specification	Type or Grade	Standard Group No.	Size (NPS)	Schedule	Thickness	Diameter
Base Material	Standard A36		1			1/2"	
Welded To	Standard A36		1			1/2"	

VARIABLES	Actual Values	RANGE QUALIFIED
Type of Weld Joint	Plate-Groove Weld (Fig. 6.20) Groove Weld with Backing	Groove, Fillet, Plug and Slot Welds
Base Metal	Group I to Group I	Any Standard D1.1 Qualified Base Metal

	Groove	Fillet	Groove	Fillet
Plate Thickness	1/2"		1/8" - 1"	1/8" Minimum
Pipe/Tube Thickness			1/8" - 1"	Unlimited
Pipe Diameter			24" Minimum	Unlimited

Welding Process	GMAW	GMAW
Type (<i>Manual, Semiautomatic, Mechanized, Automatic</i>)	SemiAutomatic	SemiAutomatic, Mechanized, Automatic
Backing	With Backing	With Backing Only
Filler Metal (Standard Spec.)	A5.18	A5.XX
Standard Classification	ER70S-6	All
F-Number		
Position	3G	Flat, Horizontal & Vertical
Groove – Plate & Pipe > 24 in		All
Groove – Pipe < 24 in		
Fillet – Plate & Pipe < 24 in		All
Fillet – Pipe < 24 in		All
Progression	Vertical Up	Vertical Up
GMAW Transfer Mode	Globular	Spray, Pulsed, Globular
Single or Multiple Electrodes	Single	Single
Gas/Flux Type	45.32 SG-C	AS-XX Approved

TEST RESULTS

Type of Test	Acceptance Criteria	Results	Remarks
Visual Examination per 6.10.1	6.10.1	Acceptable	
3G: 2X Side Bend per 6.10.3.1 and Fig. 6.8	6.10.3.3	Acceptable	

CERTIFICATION

Test Conducted by	
Laboratory	
Test Number	
File Number	

We the undersigned certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with applicable requirements of Clause X of Standard D1.1/ 1M (2026) *Structural Welding Code—Steel*.

Manufacturer or Contractor _____ Authorized by _____

Date _____

*Accredited
Welding
Inspector
Stamp*

Inspector's Name
CWI 12345678
QC1 EXP. 5/26/2031