

**FORM QW-484B SUGGESTED FORMAT B FOR WELDING OPERATOR PERFORMANCE QUALIFICATIONS (WOPO)**  
**(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)**

Welding operator's name \_\_\_\_\_ Identification no. \_\_\_\_\_

**Test Description (Information Only)**

Identification of WPS followed \_\_\_\_\_  Test coupon  Production weld Date welded \_\_\_\_\_  
 Specification and type/grade or UNS Number of base metal(s) \_\_\_\_\_ Thickness \_\_\_\_\_  
 Base metal P-Number \_\_\_\_\_ to P-Number \_\_\_\_\_ Position(s) \_\_\_\_\_  
 Plate  Pipe (enter diameter, if pipe or tube) \_\_\_\_\_  
 Filler metal (SFA) specification \_\_\_\_\_ Filler metal or electrode classification \_\_\_\_\_

**Testing Variables and Qualification Limits When Using Automatic Welding Equipment**

Welding Variables (QW-361.1)	Actual Values	Range Qualified
Type of welding (automatic)	_____	_____
Welding process	_____	_____
Filler metal used (Yes or No) (EBW or LBW)	_____	_____
Type of laser for LBW (CO <sub>2</sub> to YAG, etc.)	_____	_____
Continuous drive or inertia welding (FW)	_____	_____
Vacuum or out of vacuum (EBW)	_____	_____

**Testing Variables and Qualification Limits When Using Machine Welding Equipment**

Welding Variables (QW-361.2)	Actual Values	Range Qualified
Type of welding (Machine)	_____	_____
Welding process	_____	_____
Direct or remote visual control	_____	_____
Automatic arc voltage control (GTAW)	_____	_____
Automatic joint tracking	_____	_____
Position(s)	_____	_____
Consumable inserts (GTAW or PAW)	_____	_____
Backing (with or without)	_____	_____
Single or multiple passes per side	_____	_____

**RESULTS**

Visual examination of completed weld (QW-302.4) \_\_\_\_\_  
 Transverse face and root bends [QW-462.3(a)]  Longitudinal bends [QW-462.3(b)]  Side bends (QW-462.2)  
 Pipe bend specimen, corrosion-resistant weld metal overlay [QW-462.5(c)]  
 Plate bend specimen, corrosion-resistant weld metal overlay [QW-462.5(d)]  
 Pipe specimen, macro test for fusion [QW-462.5(b)]  Plate specimen, macro test for fusion [QW-462.5(e)]

Type	Result	Type	Result	Type	Result

Alternative Volumetric Examination Results (QW-191): \_\_\_\_\_ RT  or UT  (check one)

Fillet weld — fracture test (QW-181.2) \_\_\_\_\_ Length and percent of defects \_\_\_\_\_  
 Fillet welds in plate [QW-462.4(b)]  Fillet welds in pipe [QW-462.4(c)]

Macro examination (QW-184) \_\_\_\_\_ Fillet size (in.) \_\_\_\_\_ × \_\_\_\_\_ Concavity or convexity (in.) \_\_\_\_\_

Other tests \_\_\_\_\_  
 Film or specimens evaluated by \_\_\_\_\_ Company \_\_\_\_\_  
 Mechanical tests conducted by \_\_\_\_\_ Laboratory test no. \_\_\_\_\_  
 Welding supervised by \_\_\_\_\_

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.

Organization \_\_\_\_\_

Date \_\_\_\_\_

Certified by \_\_\_\_\_