

RESUME

Post Applied For	:	**TIG & ARC WELDER**
Name	:	**M.SIVAKUMAR**
Father's Name	:	Mr. E.Munusamy
Sex	:	Male
Date of Birth	:	02.06.1990
Nationality	:	INDIAN
Religion	:	Hindu
Marital Status	:	Married
Address	:	No.8/40, Sadras, Kalpakkam Chengalpattu Dist, Tamil nadu – 603 102
Contact No.	:	+91 **8220655496**
Languages Known	:	Tamil, English & Hindi
Educational Qualification	:	**S.S.L.C**

PASSPORT DETAILS

Passport No.	:	**M5890460**
Place of Issue	:	Chennai
Date of Issue	:	28.01.2015
Date of Expiry	:	27.01.2025

Experience Details :

S. No.	Name of Company	Position	Period	
			From	To
1.	Hundai, Saudhi, Marjan Project Contractors	TIG & ARC Welder	19.05.2022	05.11.2022
2.	Tata Pvt Ltd	TIG & ARC Welder	20.06.2020	20.04.2022
3.	Descon Engineering QATAR	TIG & ARC Welder	01.01.2020	14.03.2020
4.	LARSEN & TOUBRO Ltd	TIG & ARC Welder	15.04.2019	20.11.2019
5.	Heisco, Kuwait	TIG & ARC Welder	12.09.2016	01.01.2019
6.	Rambal Hi-Tech, Kalpakkam	TIG & ARC Welder	27.05.2016	06.09.2016
7.	Gulf Spic KNPC, Kuwait	TIG & ARC Welder	09.09.2015	14.05.2016
8.	Kharafi National, Kuwait	TIG & ARC Welder	12.07.2012	10.06.2015
9.	Kharafi National, Abu Dhabi	TIG & ARC Welder	22.11.2010	12.07.2012

Declaration

I hereby declare that all the above given information are true to my knowledge.

Date: Yours Faithfully

Place: Sadras **(M.SIVAKUMAR)**

DEBOTTLENECKING OF GC-17 IN WEST KUWAIT

HEISCO



WELDER PERFORMANCE QUALIFICATION (WPQ)

(As per ASME Section IX)

Certificate No. : 068

Welder's name: SIVA KUMAR Identification No.: HW-535

Test Description

Identification of WPS followed: *WPS-010* [■] Test Coupon [ ] Production Weld

Specification and type/grade or UNS No. of base metal(s): ASTM B444 UNS NO6625 Thickness: *2.77 MM*

Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es):	GTAW	GTAW
Type (ie, manual, semi-auto) used:	MANUAL	MANUAL
Backing (With / Without):	WITHOUT	WITH (or) WITHOUT
[ ] Plate [■] Pipe (enter diameter if pipe or tube):	1/2"	1/2" to UNLIMITED
Base metal P-Number to P-Number	P43 to P43	P1 to P15F, P34 or P41 to P49
Filler metal or electrode specification(s) (SFA) (info. only):	SFA 5.11	-
Filler metal or electrode classification(s) (info. only):	ER NiCrMO-3	-
Filler metal F-Number(s):	F43	F41 to F46 & F34
Consumable insert (GTAW or PAW):	NIL	NIL
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW):	SOLID	SOLID
Deposit thickness for each process:		
Process - 1: GTAW 3 layers minimum [ ] Yes [■] No	2.77 MM	5.54 MM
Process - 2: ____ 3 layers minimum [ ] Yes [ ] No		
Position qualified (2G, 6G,3F etc.) :	6G	ALL
Vertical progression (uphill or downhill):	UPHILL	UPHILL
Type of fuel gas (OFW):	NA	
Inert gas backing (GTAW, PAW, GMAW):	ARGON	ARGON
Transfer mode (spray/globular or pulse to short circuit-GMAW):	NA	NA
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	DCEN

RESULTS

Visual Examiantion of Completed Weld (QW-302.4) *ACCEPTED*

[ ] Transverse face & 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): **ACCEPTED - (RT-053)** 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/convexity (in.) : ____

Other tests: ____

Film or specimens evaluated by: *ARUN.M* Company: *HEISCO*

Mechanical tests conducted by: ____ Laboratory test report no.: ____

Welding supervised by: *ARUN.M*

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.

Certified By : M. Reey (ARUN. M)

Date: 05-06-2017 Organization: HEISCO

	WELDER QUALIFICATION CARD QChem II TA 2020	QChem
Welder Name	SIVAKUMAR MUNUSWAMY	Position 6G
Welder I .D #	D102057	
Wps #	DES-QC-6509-A-08	
Test date	12-Jan-2020	
Process	GTAW	
Applicable Code	ASME IX	
QA/QC Sign		
DESCON		QChem

QUALIFICATION DATA	
Base Metal	P No: 1 to 15F & 34, 41 TO 49
GROOVE	GTAW - 11.08 mm MAX
	SMAW - N/A
DIAMETER	MIN 25 MM OD TO UNLIMITED
FILLET	ALL
POSITION	ALL
FILLER METALS	
ROOT/HOT	ER-2209
FILL/CAP	ER-2209
F No	F6

	WELDER QUALIFICATION CARD QChem II TA 2020	QChem
Welder Name	SIVAKUMAR MUNUSWAMY	Position 6G
Welder I .D #	D102057	
Wps #	DES-QC-6509-A-01	
Test date	12-Jan-2020	
Process	GTAW	
Applicable Code	ASME IX	
QA/QC Sign		
DESCON		QChem

QUALIFICATION DATA	
Base Metal	P No: 1 to 15F & 34, 41 TO 49
GROOVE	GTAW - 11.08 mm MAX
	SMAW - N/A
DIAMETER	MIN 25mm OD TO UNLIMITED
FILLET	ALL
POSITION	ALL
FILLER METALS	
ROOT/HOT	ER-70S-6
FILL/CAP	ER-70S-6
F No	F6

DESCON ENGINEERING QATAR L.L.C.

2nd Floor Bulding# 08 Umm-Ghawalina
P.O Box 23364 Doha Qatar
Fax # +974-44054778

PP&A/FRM-29
Rev: 00
9/30/2009

SERVICE CERTIFICATE

Sr. No. 448293 / 102057

Certified that Mr. SIVAKUMAR MUNUSWAMY Emp. No. 102057 / 40047578 N.I.C #. _____ Passport No. M5890460

Son of Mr. MUNUSWAMY PARTHASARATHY Resident of INDIAN

Nationality INDIAN Has served the company as WELDER MULTI CS

at Q-CHEM TA-II 2020 From 1-Jan-2020 To 17-Mar-2020 (Sporadically / Intermittently)

☐ He left the job on his own accord.

☑ His services were terminated due to COMPLETION OF WORK

☐ His services were no more required.

☐ He was releived of the job on the completion of contract /job assignment/ project.

ASME A S U U2 9P R

INCHARGE ADMINISTRATION

DEBOTTLENECKING OF GC-17 IN WEST KUWAIT

HEISCO



WELDER PERFORMANCE QUALIFICATION (WPQ)

(As per ASME Section IX)

Certificate No. : 067

Welder's name: SIVA KUMAR Identification No.: HW-535

Test Description

Identification of WPS followed: *WPS-002* [■] Test Coupon [ ] Production Weld

Specification and type/grade or UNS No. of base metal(s): P8 (ASTM 312 Type 316L) Thickness: *4.78 MM*

Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es):	GTAW	GTAW
Type (ie, manual, semi-auto) used:	MANUAL	MANUAL
Backing (With / Without):	WITHOUT	WITH (or) WITHOUT
[ ] Plate [■] Pipe (enter diameter if pipe or tube):	1/2"	1/2" to UNLIMITED
Base metal P-Number to P-Number	P8 to P8	P1 to P15F, P34 or P41 to P49
Filler metal or electrode specification(s) (SFA) (info. only):	SFA 5.9	-
Filler metal or electrode classification(s) (info. only):	ER 316L	-
Filler metal F-Number(s):	F6	F6
Consumable insert (GTAW or PAW):	NIL	NIL
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW):	SOLID	SOLID
Deposit thickness for each process:		
Process - 1: GTAW 3 layers minimum [■] Yes [ ] No	4.78 MM	9.56 MM
Process - 2: ____ 3 layers minimum [ ] Yes [ ] No		
Position qualified (2G, 6G,3F etc.) :	6G	ALL
Vertical progression (uphill or downhill):	UPHILL	UPHILL
Type of fuel gas (OFW):	NA	NA
Inert gas backing (GTAW, PAW, GMAW):	ARGON	ARGON
Transfer mode (spray/globular or pulse to short circuit-GMAW):	NA	NA
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	DCEN

RESULTS

Visual Examiantion of Completed Weld (QW-302.4) *ACCEPTED*

[ ] Transverse face & 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): ACCEPTED - (RT-052) 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/convexity (in.) : ____

Other tests: ____

Film or specimens evaluated by: *ARUN.M* Company: *HEISCO*

Mechanical tests conducted by: ____ Laboratory test report no.: ____

Welding supervised by: *ARUN.M*

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.

Certified By : M. Arun (Arun.M)

Date: 05-06-2017 Organization: HEISCO

DEBOTTLENECKING OF GC-17 IN WEST KUWAIT

HEISCO



WELDER PERFORMANCE QUALIFICATION (WPQ)

(As per ASME Section IX)

Certificate No. : 069

Welder's name: **SIVA KUMAR** Identification No.: **HW-535**

Test Description

Identification of WPS followed: *WPS-006* [■] Test Coupon [ ] Production Weld

Specification and type/grade or UNS No. of base metal(s):) P1 (API 5L GR.B) Thickness: *10.97MM*

Testing Variables and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es):	GTAW + SMAW	GTAW + SMAW
Type (ie. manual, semi-auto) used:	MANUAL	MANUAL
Backing (With / Without):	GTAW - WITHOUT SMAW - WITH	GTAW - WITH (or) WITHOUT SMAW - WITH
[ ] Plate [■] Pipe (enter diameter if pipe or tube):	6"	2 ⅜" to UNLIMITED
Base metal P-Number to P-Number	P1 to P1	P1 to P15F, P34 or P41 to P49
Filler metal or electrode specification(s) (SFA) (info. only):	SFA 5.18 + 5.1	-
Filler metal or electrode classification(s) (info. only):	ER70S-2 + E7018 H4R	-
Filler metal F-Number(s):	F6 & F4	F1 to F4 & F6
Consumable insert (GTAW or PAW):	NIL	NIL
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW):	SOLID	SOLID
Deposit thickness for each process:		
Process - 1: GTAW 3 layers minimum [ ] Yes [■] No	4 MM	8 MM
Process - 2: SMAW 3 layers minimum [■] Yes [ ] No	6.97MM	13.94MM
Position qualified (2G, 6G,3F etc.) :	6G	ALL
Vertical progression (uphill or downhill):	UPHILL	UPHILL
Type of fuel gas (OFW):	NA	NA
Inert gas backing (GTAW, PAW, GMAW):	NA	NA
Transfer mode (spray/globular or pulse to short circuit-GMAW):	NA	NA
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	DCEN

RESULTS

Visual Examiantion of Completed Weld (QW-302.4) *ACCEPTED*

[ ] Transverse face & 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): **ACCEPTED - (RT-058)** 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/convexity (in.) : _____

Other tests: _____

Film or specimens evaluated by: *ARUN.M* Company: *HEISCO*

Mechanical tests conducted by: _____ Laboratory test report no.: _____

Welding supervised by: *ARUN.M*

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.

Certified By : M. Arun (ARUN.M)

Date: 04-07-2017 Organization: HEISCO

TOTAL

Laggan–Tormore

Petrofac

Engineering, Construction,
Operations & Maintenance

Petrofac House, Al-Khan Road
PO Box 23467, Sharjah, UAE
Tel +971 6574 0999
Fax +971 6574 0099
www.petrofac.com

Service Certificate

This is to certify that Mr. Siva Kumar have been working with Petrofac International Ltd as a Tig and Arc Welder for Laggan Tormore Project (Shetland Gas Plant, UK. Total E & P UK Contract No. 4300002482). He was assigned to ABJ fabrication yard Kuwait where Petrofac have carried out modular construction of Shetland Gas Plant.

During his tenure with us we found him hard working, sincere and accomplishing assigned tasks effectively.

Siva Kumar have worked for Laggan Tormore project from July 2012 to Aug 2013

Suresh V. M.
Site Representative, Laggan Tormore Project
Petrofac International Ltd

31, Aug 2013

Petrofac International (UAE) LLC
Company No. 569307
Incorporated in UAE
Registered Office:
Petrofac House, Al-Khan Road, PO Box 23467,
Sharjah, UAE

LARSEN & TOUBRO LIMITED Heavy Civil Infra IC

CONSTRUCTION OF VARIOUS BUILDINGS OF WASTE MANAGEMENT PLANT FRFCF AT KALPAKKAM.

WELDER PERFORMANCE QUALIFICATION TEST REPORT

Welder Name : Mr.M.Siva Kumar

Welder No : PW - 43

W P S No. : L&T/HCIC/FRFCF/CV-1E/WPS-02

Specification of Base Matl.: SA312 TP 304L (50NB Sch 40)

Thickness: 3.91mm

Welder Certificate No: 52

Date: 15.07.2019

Welding Process: GTAW

Type: Manual/~~Semiautomatic/ Automatic~~ (QW - 350)

Qualification test on: Test coupon / ~~Production Joint~~

Joint Type : Groove



(SHIVAM SUNDARAM)

Welding varibles	Actual Values	Range Qualified
Backing (metal, weld metal, welded from both side,etc) (QW - 402)	Without Backing	With & Without Backing
Welding Process(es)	GTAW	GTAW
Base metals P.No.	P8	P1 th P15F
Plate / ROD thickness	NA	NA
Pipe Dia & Thickness	Ø60.3 mm & Thick ness 3.91 mm	Min Dia 25 mm to Unlimited
Metal or Electrode Specification(s) (SFA)	SFA 5.9	SFA 5.9
Filler Metal or Electrode Classification(s) (QW - 404)	ER-308L	ER-308L
Filler Metal F - Number(s)	F6	F6
Filler Metal product form	Solid	Solid
Consumables insert	NIL	NIL
Weld deposit thickness	3.91mm	7.82mm(Max)
Welding Position qualified (2G,6G,3F,etc) (QW - 405)	6G	ALL (Grove & Fillet for Plate & Pipe)
Progress (Uphill / Downhill)	UPHILL	UPHILL
Backing gas for GTAW / GMAW (QW - 408)	ARGON	ARGON
Welding Current Type Polarity	DCSP	DCSP
Visual Examination Result (QW - 302.4)	Satisfactory	

GUIDE BEND TEST RESULT

Type of Root,Bend & Tensile test	NA
	NA

Radiographic Test Result (QW - 191): Acceptable — Report No.: L&T/RIR/53

Ultra Sonic Examination (QW - 191.2): NA — Report No.: NA

Fillet Weld - fracture test result (QW - 180) : NA — Length and percentage of defects: NA

Macro examination NA — Fillet size (in) — in concavity/convexity NA

Film or specimens evaluated by: Mr.M.Jai Ganesh — Company: NA

Welding supervisied by: Mr.M.Jai Ganesh

Welding witnessed by : Mr.S.Venkatachalam QA-FRFCF

We certify that the statement 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..

Company Name: LARSEN & TOUBRO LIMITED Heavy Civil Infra IC

Date : 15-07-2019

15/07/19

M.Jai Ganesh

L&T - QA/QC

15/07/19

Approved by

QA - FRFCF

(SHIVAM SUNDARAM)

LARSEN & TOUBRO LIMITED Heavy Civil Infra IC

CONSTRUCTION OF VARIOUS BUILDINGS OF WASTE MANAGEMENT PLANT FRFCF AT KALPAKKAM.

WELDER PERFORMANCE QUALIFICATION TEST REPORT



Welder Name : Mr.M.Siva Kumar	Welder Certificate No: 48
Welder No : W-43	Date: 10.04.2019
W P S No : L&T/HCIC/FRFCF/CV-1E/WPS-01	Welding Process: SMAW
Specification of Base Matl.: IS 2062 E 250 BR	Type: Manual/~~Semiautomatic/~~ ~~Automatic~~ (QW - 350)
Thickness: 12mm	Qualification test on: Test coupon /~~Production Joint~~
	Joint Type : Groove

Welding Variables	Actual Values	Range Qualified
Backing (metal, weld metal, welded from both side,etc) (QW - 402)	Without Backing	With & Without Backing
Welding Process(es)	SWAW	SMAW
ASME P.No. To P.No. (QW - 403)	P1 to P1	P1 th P15F
Plate / ROD thickness	12mm	24mm & All Fillet Weld Size
Pipe Dia & Thickness	NA	NA
Filler Metal or Electrode Specification(s) (SFA)	SFA 5.1	SFA 5.1
Filler Metal or Electrode Classification(s) (QW - 404)	E - 7018	E - 7018
Filler Metal F - Number(s).	F4	F1 to F3 (With Backing) , F4 (With & Without Backing)
Consumables insert (GTAW+ PAW)	NA	NA
Weld deposit thickness for each welding process	12 mm	24mm
Welding Position qualified (2G,6G,3F,etc) (QW - 405)	3G	1G & 3G for Plates 1G for Pipes > 610mm OD 1F & 2F for Pipes & 1F,2F & 3F Plates
Progress (Uphill / Downhill)	UPHILL	UPHILL
Backing gas for GTAW / GMAW (QW - 408)	NA	NA
GMAW Transfer mode (QW - 409)	NA	NA
Welding Current Type Polarity	DCEP	DCEP
Visual Examination Result (QW - 302.4)	-	Satisfactory

GUIDE BEND TEST RESULT

Bend Test	NA.
Result	N.A.

X-Ray radiographic Test Result (QW - 191): Acceptable Report No.: L&T/RIR/No/39

Ultra Sonic Examination (QW - 191.2): NA Report No.: NA

Fillet Weld - fracture test result (QW - 180) : NA Length and percentage of defects: NA

Macro examination NA Fillet size (in) _____ in concavity/convexity NA

Film or specimens evaluated by: Mr.M.Jai Ganesh Company: NA

Welding supervised by: Mr.M.Jai Ganesh

Welding witnessed by : Mr.D.Suresh QA-FRFCF

We certify that the statement 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..

Company Name: LARSEN & TOUBRO LIMITED Heavy Civil Infra IC

Date : 10.04.2019

10/4/19

M.Jai Ganesh

L&T - QA/QC

15/04/2019

Approved by

QA - FRFCF

RAMBAL HI-TECH ENGINEERS

6/256, MAPS Main Road, Sadras, Kalpakkam 603 102
PFRB-SITE KALPKKAM

WELDER PERFORMANCE QUALIFICATION RECORD (WPQ) (QW - 483)



Welder Name : **M.SIVA KUMAR**
Welder No : **PW-08**
Date of Test : 13.07.2021
WPS No : RBH/WIP/ELECTRODE/WPS-01 REV.0
PQR No : RBH/WIP/ELECTRODE/PQR-01 REV.0

Specification of Base Metal: ASTM B167 SEAMLESS PIPE 8NB Sch.40 (OD13.72x2.24mm Thk.) [UNS NO 6600] (Inc 600 to Inc 600)

TESTING CONDITIONS AND QUALIFICATION LIMITS

	Actual Values	Range Qualified
Welding Process	GTAW	GTAW
Type	Manual	Manual
Backing (with/ without)	without	with/without backing
Pipe (if pipe Enter diameter)	OD13.72mm (8NB Pipe)	OD13.72 to Unlimited
Base Metal P to P Number	P No-43 to 43 ~~G.No-~~	P No-43 ~~G.No to~~ P No-43
Filler Metal or Electrode Specification (SFA)	5.14	5.14
Filler Metal or Electrode classification (AWS No.)	ERNiCrFe-7	ERNiCrFe-7
Filler Metal (F No.)	43	43
Filler or Electrode Product Form	Solid	Solid
Weld Deposit Thickness	2.24mm	1.5 to 4.48mm
Position Qualified	6G	6G
Vertical progression	Up Hill	Up Hill
Inert Gas Backing	Argon 99.997%	Argon 99.997%
Current type / Polarity	DCEN/ SP	DCEN/ SP
Results		
Visual examination of completed weld (QW-302.4)—Satisfactory.		
Bend Test: --.		

Alternative radiographic testing examination results (QW-191): **RBH/WIP/RIR-17, Dt: 19-07-2021** ✓

Film & Specimen Evaluated : QAS/ KNRPC/ NRB
Test conducted by : RBH, KALPAKKAM
Test witness by : **Mr.M.Bharathiraja**

We certify that the statements in this record are correct and that the test coupons were prepared and tested in accordance with the requirements of Section IX of the ASME BPV Code.

19/7/21
Signature
(RBH)
(S.VEERAMANI)

28/07/2021
Signature
QAS/ KNRPC/ NRB

RAMBAL HI-TECH ENGINEERS

6/256, MAPS Main Road, Sadras, Kalpakkam 603 102
PFRB-SITE KALPKKAM

WELDER PERFORMANCE QUALIFICATION RECORD (WPQ) (OW – 483)



Welder Name : **M.SIVA KUMAR**
Welder No : **PW-08**
Date of Test : 06.07.2021
WPS No : RBH/WIP/ELECTRODE/WPS-01 REV.0
PQR No : RBH/WIP/ELECTRODE/PQR-01 REV.0

Specification of Base Metal: **ASTM B167 SEAMLESS PIPE 40NB Sch.80 (OD48.26x 5.08mm Thk.)**
[UNS N06690] {Inc-690 to Inc-690}

TESTING CONDITIONS AND QUALIFICATION LIMITS

	Actual Values	Range Qualified
Welding Process	GTAW	GTAW
Type	Manual	Manual
Backing with/ without	Without backing	with/without backing
Pipe (if pipe Enter diameter)	OD 48.26mm	OD25 to Unlimited
Base Metal P to P Number	P No-43 to 43 G.No--	P No-43 G.No--
Filler Metal or Electrode Specification (SFA)	5.14	5.14
Filler Metal or Electrode classification (AWS No.)	ERNiCrFe-7	ERNiCrFe-7
Filler Metal (F No.)	43	43
Filler or Electrode Product Form	Solid	Solid
Weld Deposit Thickness	5.08mm	1.5 to 10.16mm
Position Qualified	6G	6G
Vertical progression	Up Hill	Up Hill
Inert Gas Backing	Argon 99.997%	Argon 99.997%
Current type / Polarity	DCEN/ SP	DCEN/ SP

Results

Visual examination of completed weld (QW-302.4)—Satisfactory.
Bend Test: --.

Alternative radiographic testing examination results (QW-191): **RBH/WIP/RIR-19 Dt:26-07-2021**

Film & Specimen Evaluated : QAS/ KNRPC/ NRB
Test conducted by : RBH, KALPAKKAM
Test witness by : **Mr.M.Bharathiraja**

We certify that the statements in this record are correct and that the test coupons were prepared and tested in accordance with the requirements of Section IX of the ASME BPV Code.

26/7/21

Signature
(RBH)

28/07/2021

Signature
QAS/ KNRPC/ NRB

HINDUSTAN CONSTRUCTION CORPORATION

QW-484A WELDER PERFORMANCE QUALIFICATIONS (WPQ)

(See QW-301, Section IX, ASME Boiler & Pressure Vessel Code)



Welder's Name: SIVAKUMAR K

Identification Number: G-8

Identification of WPS followed: HCC/FRFCF/GTAW/WPS/01

[X] Test Coupon [ ] Production weld

Specification of base metal(s) ASTM A 312 TP. 304L toASTM A 312 TP. 304L Thickness 2.77mm

Testing Conditions and Qualification Limits

Welding Variables (QW-350)

	Actual Values	Range Qualified
Welding Process(es)	GTAW	GTAW
Type (ie. manual, semi-auto) used	Manual	Manual
Backing (Metal, weld metal, double welded, etc)	Without	With & without
Base metal P- or S- Number To P- or S- Number	P-8 to P-8	P1 through P15F
[ ] Plate [X] Pipe (If pipe or tube, enter the diameter)	15NB SCH 40S	15NB & above
Filler Metal or electrode specification(s) (SFA) (Info. Only)	SFA 5.9	SFA 5.9
Filler Metal or electrode classification(s) (AWS) (Info. Only)	ER 308L	ER 308L
Filler Metal F Number(s)	6	6
Consumable Insert (GTAW or PAW)	NA	NA
Filler type (solid/metal or flux cored/powder) (GTAW or PAW)	Solid	Solid
Deposit thickness for each process		
Process 1 GTAW 3 layers minimum [X] Yes [ ] No	2.77 mm	upto 5.54 mm
Process 2 ..... 3 layers minimum [ ] Yes [ ] No	NA	NA
Position qualified (2G, 6G, 3F, etc)	6G	All
Vertical progression (uphill or downhill)	Uphill	Uphill
Type of fuel gas (OFW)	NA	NA
Inert gas backing (GTAW,PAW,GMAW)	Argon (99.997 %)	Argon (99.997 %)
Transfer mode (spray/globular or pulse to short circuit-GMAW)	NA	NA
GTAW welding current type / polarity (AC, DCEP,DCEN)	DCEN	DCEN

Results

Visual Examination of completed weld (QW-302.4) ... Satisfactory

[x] Bend Test ; [ ]Transverse root & face(QW-462.3(a)) ; [ ]Longitudinal root & face(QW-462.3(b)) ; [ ] side(QW-462.2);
[ ]Pipe bend specimen, corrosion-resistant overlay(QW-462.5(c)) ; [ ]Plate bend specimen, corrosion-resistant overlay(QW-462.5(d))
[ ] Macro test for fusion (QW-462.5(b)) ; [ ] Macro test for fusion(QW-462.5(e))

TYPE	RESULT
Radiography	Satisfactory
Other tests: VT	Satisfactory

Alternative radiographic examination Results (QW-191) ... HCC-FRFCF-RIR-016 dtd 28-12-22 ...
Fillet Weld - Fracture test (QW-180) ... NA
Macro examination (QW-184) ..... Fillet size ..... mm X ..... mm Concavity / Convexity ..... mm
Other tests VT & IGC PrC
Film or specimens evaluated by: Mr Sriram Sundaram (QA,FRFCF)
Test conducted By: M/s IIT Engineers Kalpakkam
Laboratory Test Rep. No. NA
Welding Witnessed by: Mr Gokul V S (HCC-QA) and Mr. S Venkatachalam, (QA,FRFCF)
Testing Witnessed by: NA
We certified that the statement 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 B & PV Code.

For,

(HCC, QA)

For,

28/12/2022

(FRFCF, QA)

SRIRAM SUNDARAM
QA-FRFCF

TATA

QW-484A FORMAT FOR WELDER PERFORMANCE QUALIFICATION (WPQ)
(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)



Welders name: Mr.SIVAKUMAR K Welder Identification No: TPL/FRFCF/W 25

Test Description

Identification of WPS followed: TPL/FRFCF/WPS-04 Dt.10-07-17 ■ Test coupon ☐ Production weld

Specification and Type/Grade or UNS Number of base metal(s): ASTM A 312 TP 316L Thickness: 3.9 mm

Testing Variables and Qualification Limits (Welding Variables (QW-256))	Actual Values	Range Qualified
Welding Process(es)	GTAW	GTAW
Type (i.e., manual, semi-automatic) used	MANUAL	MANUAL
Backing (Metal, weld metal, double-welded, etc.)	WELD METAL	WELD METAL
☐ Plate ☐ Pipe (enter diameter if pipe or tube)	Over 2"	Over 2" and Above
Base metal P - Number to P - Number	P-8	P-8
Filler metal or electrode specification(s) (SFA) (info. Only)	A5.9	A5.9
Filler metal or electrode classification(s) (info. Only)	ER308L	All classification of P-no-8
Filler metal F-Number(s)	F6	F6
Consumable insert (GTAW or PAW)	NA	NA
Filler Metal Product Form (solid/metal or flux cored/powder) (GTAW or PAW)		
Deposit thickness for each process		
Process 1 ____ 3 layers minimum ☐ Yes ■ No	NA	NA
Process 2 ____ 3 layers minimum ☐ Yes ■ No	NA	NA
Position qualified (2G, 6G, 3F, etc.)	6G	ALL
Vertical progression (uphill or downhill)	UPHILL	UPHILL
Type of Fuel Gas (OFW)	NA	NA
Inert gas backing (GTAW, PAW, GMAW)	Argon 99.99%	Argon 99%.97
Transfer mode (spray/globular or pulse as short circuit—GMAW)	NA	NA
Current type/polarity (AC, DCEP, DCEN)	DCEN	DCEN

RESULTS

Visual examination of completed weld (QW-302.4): Found satisfactory

☐ Transverse face and root bends (QW-462.3(a)) Satisfactory ☐ 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 Radiographic examination results (QW-191): TPL/FRFCF/RT/PP-21 Dt.01/08/2020

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.): ____ x ____ Concavity/convexity (in.): ____

Other tests: ____

Film or specimens evaluated by: ____ Company: ____

Mechanical tests conducted by: ____ Laboratory test no.: ____

Welding supervised by: Mr. DINESH S (TATA Projects Ltd) Mr. SP MANIVANNAN (FRFCF)

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.

Manufacturer or Contractor: TATA Projects Ltd

Date: 02-June-2020 Certified by: FRFCF 03/06/2020

SHIVAM SUNDARAM
QA-FRFCF

Form No. FQ / 068 Rev.2

KHARAFI NATIONAL - KUWAIT

WELDER PERFORMANCE QUALIFICATION RECORD (WPQ)

ACCORDING TO ASME SEC. IX)

PROJECT: NEW BOOSTER STATION- BS-171 AT WEST KUWAIT		KN PROJECT NO: 1664 Certificate No: 1664/714
COMPANY: KUWAIT OIL COMPANY	CONTRACTOR : SAIPEM	KOC Contract No: 45283
SUB CONTRACTOR : KHARAFI NATIONAL		KOC Project No : EF/ 1718



Test Description

WELDER'S NAME : SIVA KUMAR MUNUSWAMY	Identification No. 103171	STAMP No. AJ 1607
WPS No: 1664/001 Rev.No.1	Test Number: 0390/WQT/100	Test date: 22-03-2014
■ Test Coupun	☐ Production Weld	
Specification of base metal(s) SA 106 Gr.B		Thickness: 18.25MM

Testing Conditions and Qualification Limits

Welding Variables(QW-350)	Actual Values	Range Qualified
Welding Process	GTAW+SMAW	GTAW+SMAW
Type(i.e. Manual or Semi -Auto)	Manual	Manual
Backing (Metal, Weld Metal, Double-Welded)	GTAW without and SMAW with backing	GTAW with or without and SMAW with backing
☐ Plate ■ Pipe	DN 150 (NPS 6)	73 mm (2-7/8") OD &above , Fillet All
Base metal P to P	P No 1	P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49
Filler metal or electrode Specification(s) SFA	SFA 5.18(GTAW)+ SFA 5.1(SMAW)	Applicable F number
Filler metal or electrode Classification(s) SFA	ER70S2+ E7018	Applicable F number
Filler metal F- Number(s)	F No 6 without and F No 4 with backing	All F No 6 with or without & F No 1,2,3 & 4 with Backing
Consumable insert (GTAW or PAW)	None	Not Allowed
Addition or Deletion of Filler Metal(GTAW, PAW)	With	With
Filler type	Solid wire For GTAW	Solid wire For GTAW
Deposited Metal Thickness	GTAW-4mm , SMAW-14.25mm	GTAW-8mm (Max.), SMAW-Unlimited, Fillet- All
Position Qualified	6G	ALL
Vertical Progression(Uphill or Down hill)	UPHILL	UPHILL
Type of fuel gas(OFW)	N/A	N/A
Inert gas Backing(GTAW,PAW,GMAW)	Without	With or With out
Transfer mode(Sparay/globular or pulse to short circuit-GMAW)	N/A	N/A
GTAW current type/polarity(AC,DCEP,DCEN)	DCEN	DCEN

RESULTS

Visual Examination of Completed Weld(QW-302.4) **Accepted**

Guided Bend Test (QW-462.3 a & b)

Type	Result	Type	Result
NA	NA	NA	NA
NA	NA	NA	NA

Alternate Radiographic examination results(QW_191) **Accepted in RT Report No: 9165/1664/RT/318 (Date: 22-03-2014)**

Fillet weld-Fracture test(QW-180) **NA** Length and percent of defects NA

Macro examination(QW-184) **NA** Fillet size **NA** Concavity /Convexity

Film or Specimens evaluated by : **N.Mohammed Nazeer** Company: **Kharafi National**

Mechanical tests Conducted by **NA** Laboratory test no. NA

Welding Supervised by : **N.Mohammed Nazeer**

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

	KN	SAIPEM	KOC
NAME		QUALITY DEPARTMENT	CSWIP
DESIGNATION			J H GRAHAM
SIGNATURE			525318
DATE	23/03/14	24 MAR 2014 Sign Saipem S.p.A BS-171 Project	24/3/14. SWI 3.2.2

KUWAIT OIL COMPANY (KOC)
INSPECTION & CORROSION TEAM
CONTRACTOR'S WELDER CERTIFICATE

Name: SIVA KUMAR

Welder No. : HW-535

Employer: M/S. HEISCO

Contract No. : 15052358

Approved By: _____



QUALIFICATION RANGE

Pipe Size: OD ½" to Unlimited	Position: 6G (All)
Thickness: Upto 5.54 mm	Base Material: P43
Process (Root/Other): GTAW	Code: ASME SEC. IX
Electrode Root: F43 (ER NiCrMo-3)	Others: F43 (ER NiCrMo-3)
Direction Root: Uphill	Others: Uphill
Valid Until: 19.06.2018	Welder No. : HW-535

Remarks: Base mat. ASTM B444 UNS NO 6625 Welder test-AWA/MD

Record No. : 626

KUWAIT OIL COMPANY (KOC)
INSPECTION & CORROSION TEAM
CONTRACTOR'S WELDER CERTIFICATE

Name: SIVA KUMAR

Welder No. : HW-535

Employer: M/S. HEISCO

Contract No. : 15052358

Approved By: _____



QUALIFICATION RANGE

Pipe Size: OD 2⅞" to Unlimited	Position: 6G (All)
Thickness: Upto 22.0 mm	Base Material: P1 (API 5L Gr.B)
Process (Root/Other): GTAW+SMAW	Code: ASME SEC. IX
Electrode Root: F6 (ER 70S-2)	Others: F4 (E 7016H4R)
Direction Root: Uphill	Others: Uphill
Valid Until: 24.07.2018	Welder No. : HW-535

Remarks: Welder test BSH/MD

Record No. : 878

ABJ
Engineering & Contracting Co. KSC (Closed)

QW - 484A WELDER PERFORMANCE QUALIFICATION RECORD (WPQ)

Certificate No. 0395/P/139/582

(See QW301, Section IX, ASME Boiler and Pressure Vessel Code.)



Company Name: ABJ	Test Date: 28/03/2013	Test No:	165
Welder's name: SIVA KUMAR MUNI SWAMY (ID 10317)		Stamp no:	AJ 1607
Identification of WPS followed 0395/07 Rev.C	■ Test coupon	☐	Production weld
Specification of Base metal(s) welded SA 312 TP316L		Thickness	5.54 mm

Testing Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(es)	GTAW	GTAW
Type (Manual, Semi Auto) used	Manual	Manual
Backing (Metal, Weld metal, Double Welded etc)	without backing	with or without backing
☐ Plate ■ Pipe (enter diameter, if pipe or tube)	DN 50 (NPS 2)	25 mm (1") OD &above , Fillet All
Base Metal P or S Number to P or S Number	P No 8	** P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49
Filler metal or electrode specification(SFA)	SFA 5.9	Applicable 'F' Number
Filler metal or electrode classification	ER316L	Applicable 'F' Number
Filler metal F Numbers	F No 6 without Backing	All F No 6 with or without Backing
Consumable insert for GTAW or PAW	None	Not Allowed
Addition or Delition of Filler Metal(GTAW or PAW)	With	With
Filler Type (Solid/ Metal or Flux cored/ Powder)(GTAW or PAW)	Solid wire	Solid wire
Deposit thickness for each process		
Processes 1: GTAW 3 layers minimum ■ Yes ☐ No	5.54 mm	11.08 mm Max. Fillet All
Processes 2: _____ 3 layers minimum ☐ Yes ☐ No	N/A	N/A
Position Qualified	6G	ALL
Vertical Progression (uphill / downhill)	UPHILL	UPHILL
Type of fuel gas (OFW)	N/A	N/A
Inert gas backing (GTAW, PAW, GMAW)	With	With
Transfer mode(Spray,/Globular or pulse to Short circuit-GMAW)	N/A	N/A
GTAW current type / polarity (AC, DCEP, DCEN)	DCEN	DCEN

TEST RESULTS

Visual examination results (QW 302 4) **Acceptable**

■ Bend test : ■ Transverse root & face[QW 462.3a] ☐ Longitudinal root & face[QW 462 2b] ☐ Side[QW-462.2]
☐ Pipe bend specimen, corrosion-resistant overlay[QW-462.5c] ☐ Plate bend specimen, corrosion-resistant overlay[QW-462.5d]
☐ Macro test for fusion[QW-462.5b] ☐ Macro test for fusion[QW-462.5e]

Test Type	Specimen No:	Result
Face Bend	2189-1 FB1	Satisfactory
Face Bend	2189-1 FB2	Satisfactory
Root Bend	2189-1 RB1	Satisfactory
Root Bend	2189-1 RB2	Satisfactory

Alternative Radiographic examination results(QW-304 and QW-305) **Accepted Vide RT Report No.9165/0395/RT/591, Dt: 31-03-2013**

Fillet Weld - Fracture test(QW-180) N/A Length and percent of defects

Macro Examination(QW-184) N/A Fillet leg size ____ mm X ____mm Concavity / Convexity_____mm

Other tests N/A

Film or specimen evaluated by N.Mohammed Nazeer Company: KN/ABJ

Mechanical tests conducted by International Inspection Centre W.L.L

Laboratory test no IIC/PHY/310/13 Pg-1-1, Dated: 07/04/2013

Welding supervised by N.Mohammed Nazeer

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 Code. Edition: 2010 Addenda 2011

Remarks: **For Laggan Tormore Project, this Welder qualified to weld only " P8 to P8 and P8 to P1" Base metal.

ABJ CSWIP

Name:

Date: 25/04/2013

Test witnessed by AI / CLIENT

Name:

Date: 25/4/2013

KHARAFI NATIONAL - KUWAIT

WELDER PERFORMANCE QUALIFICATION RECORD (WPQ)

ACCORDING TO ASME SEC. IX)



PROJECT: NEW BOOSTER STATION- BS-171 AT WEST KUWAIT		KN PROJECT NO:1664 Certificate No: 1664/455
COMPANY: KUWAIT OIL COMPANY	CONTRACTOR : SAIPEM	KOC Contract No: 45283
SUB CONTRACTOR : KHARAFI NATIONAL		KOC Project No : EF/ 1718

Test Description

WELDER'S NAME : SIVA KUMAR MUNUSWAMY	Identification No. 103171	STAMP No. AJ 1607
WPS No: 1664/009 Rev.No.0	Test Number: 0390/WQT/065	Test date: 08-09-2013

■ Test Coupon ☐ Production Weld

Specification of base metal(s) SA 106 Gr.B Thickness: 5.54 mm

Testing Conditions and Qualification Limits

Welding Variables(QW-350)	Actual Values	Range Qualified
Welding Process	GTAW	GTAW
Type(i.e. Manual or Semi -Auto)	Manual	Manual
Backing (Metal, Weld Metal, Double-Welded)	Without backing	With or without backing
☐ Plate ■ Pipe	DN 50(NPS 2)	25 mm (1") OD &above , Fillet All
Base metal P to P	P No 1	P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49
Filler metal or electrode Specification(s) SFA	SFA 5.14	Applicable F number
Filler metal or electrode Classification(s) SFA	ERNiCrMo-3	Applicable F number
Filler metal F- Number(s)	F No 43 without Backing	F No. 34 and all F No. 41through F No. 46 with or without Backing
Consumable insert (GTAW or PAW)	None	Not Allowed
Addition or Deletion of Filler Metal(GTAW, PAW)	With	With
Filler type	Solid wire	Solid wire
Deposited Metal Thickness	5.54 mm	11.08mm (Max.), Fillet All
Position Qualified	6G	ALL
Vertical Progression(Uphill or Down hill)	UPHILL	UPHILL
Type of fuel gas(OFW)	N/A	N/A
Inert gas Backing(GTAW,PAW,GMAW)	With	With
Transfer mode(Sparay/globular or pulse to short circuit-GMAW)	N/A	N/A
GTAW current type/polarity(AC,DCEP,DCEN)	DCEN	DCEN

RESULTS

Visual Examination of Completed Weld(QW-302.4) Accepted

Guided Bend Test (QW-462.3 a & b)

Type	Result	Type	Result
NA	NA	NA	NA
NA	NA	NA	NA

Alternate Radiographic examination results(QW_191) Accepted in RT Report No: 9165/1664/RT/207 (Date: 08-09-2013)

Fillet weld-Fracture test(QW-180) NA Length and percent of defects: NA

Macro examination(QW-184) NA Fillet size NA Concavity /Convexity

Film or Specimens evaluated by : N.Mohammed Nazeer Company: Kharafi National

Mechanical tests Conducted by NA Laboratory test no NA

Welding Supervised by : N.Mohammed Nazeer

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

	KN	SAIPEM	KOC
NAME			CSWIP J H GRAHAM
DESIGNATION			325318
SIGNATURE			10/9/2013 SWI 3.2.2
DATE	09/09/13		

KUWAIT OIL COMPANY (KOC)
INSPECTION & CORROSION TEAM
CONTRACTOR'S WELDER CERTIFICATE

Name: SIVA KUMAR

Welder No. : HW-535

Employer: M/S. HEISCO

Contract No. : 15052358

Approved By: _____



QUALIFICATION RANGE

Pipe Size: OD ½" to Unlimited	Position: 6G (All)
Thickness: Upto 9.56 mm	Base Material: P8 (SA312TP316
Process (Root/Other): GTAW	Code: ASME SEC. IX
Electrode Root: F6 (ER 316L)	Others: F6 (ER 316L)
Direction Root: Uphill	Others: Uphill
Valid Until: 19.06.2018	Welder No. : HW-535

Remarks: Welder test AWA/MD

Record No. : 825

KUWAIT OIL COMPANY (KOC)
INSPECTION & CORROSION TEAM
CONTRACTOR'S WELDER CERTIFICATE

Name: SIVA KUMAR

Welder No. : HW-535

Employer: M/S. HEISCO

Contract No. : 15052358

Approved By: _____



QUALIFICATION RANGE

Pipe Size: OD ½" to Unlimited	Position: 6G (All)
Thickness: Upto 9.56 mm	Base Material: P8
Process (Root/Other): GTAW	Code: ASME Sec. IX
Electrode Root: F6 (ER316 L)	Others: F6 (ER316 L)
Direction Root: Uphill	Others: Uphill
Valid Until: 08.07.2019	Welder No. : HW-535

Remarks: Base Mat. ASTM 312 Type 316L, Renewal-SAK/MD

Record No. : 2537

KUWAIT OIL COMPANY (KOC)
INSPECTION & CORROSION TEAM
CONTRACTOR'S WELDER CERTIFICATE

Name: SIVA KUMAR

Welder No. : HW-535

Employer: M/S. HEISCO

Contract No. : 15052358

Approved By: _____



QUALIFICATION RANGE

Pipe Size: OD ½" to Unlimited	Position: 6G (All)
Thickness: Upto 5.54 mm	Base Material: P43
Process (Root/Other): GTAW	Code: ASME Sec. IX
Electrode Root: F43 (ER NiCrMo-3)	Others: F43 (ER NiCrMo-3)
Direction Root: Uphill	Others: Uphill
Valid Until: 08.07.2019	Welder No. : HW-535

Remarks: Base mat. ASTM B444 UNS NO6625, Renewal-SAK/MD

Record No. : 2536

WELDER ID CARD

KHARAFI NATIONAL Co. (L.L.C.)

HABSHAN 5 PROCESS PLANT

NAME	SIVA KUMAR MUNUSWAMY
BADGE NO	103171
WELDER ID NO	AB-093
CERTIFICATE NO	9125/64/421
ISSUED BY (KN QC)	



APROVED BY TCM

NAME	PRAVEEN.V	
SIGNATURE		
DATE	21/03/11	25.3.11

QUALIFIED

WPS NO	2031/01A
PROCESS	GTAW
POSITION	All Position
MATERIAL	
BASE (P - No.)	P No 1 through P No 15F, PNo 34 & PNo 41through P No 49
FILLER (F - No.)	All F No 6 with or without backing
RANGE: DIA	GTAW-25mm OD & above THK GTAW- 17.48mm
CODE : ASME IX ☑	API-1104 ☐ AWS D 1.1 ☐

VALID UNTIL SATISFACTORY PERFORMANCES IN THE PROJECT

WELDER ID CARD

KHARAFI NATIONAL Co. (L.L.C.)

HABSHAN 5 PROCESS PLANT

NAME	SIVAKUMAR MUNUSWAMY
BADGE NO.	103171
WELDER ID NO.	AB-093
CERTIFICATE NO	9125/169/1124
ISSUED BY (KN QC)	



APROVED BY TCM

NAME	SHIVAKUMAR A	
SIGNATURE		
DATE	08/12/2011	13-12-11

QUALIFIED

WPS NO	2031/01
PROCESS	GTAW
POSITION	ALL POSITION
MATERIAL	
BASE (P - No.)	P No 1 through P No 15F, PNo 34 & PNo 41through P No 49
FILLER (F - No.)	All F No 6 with or without backing
RANGE: DIA	1/2" OD & above THK 7.46mm
CODE: ASME IX ☑	API-1104 ☐ AWS D 1.1 ☐

VALID UNTIL SATISFACTORY PERFORMANCES IN THE PROJECT

DYNAMIC ENGINEERS

WELDER PERFORMANCE QUALIFICATION (WPQ)



Qualification Code : ASME Section IX	Certificate No.: MW 12
Welder Name : **M. SIVA KUMAR**	Date of Test : 12.02.2008

Identification of WPS followed by Welder during Welding of Test Coupon : MW -7

Base material (s) Welded : A 106 Gr.B -2" Dia sch. 40 Thickness : 5.54mm

Welding Variables (QW- 350)	Actual Values	Range Qualified
Welding Process (es)	SMAW & GTAW	SMAW & GTAW
Type (i.e. Manual or semi. Auto) used	Manual	Manual
Backing (metal, weld metal, double, welded, Flux etc.)(QW-402)		
☐ Plate ☐ Pipe (Enter dia if pipe)	Plate	Plate
Filler metal or specification (SFA) & Filler Metal F-No.	SFA 5.1/F3 for Root, F4 for fill & cap	SFA 5.1/F3 for Root, F4 for fill & cap
AWS Classification No.	ER 70S2, E 7018	ER 70S2, E 7018
Consumable insert (GTAW or PAW)	N/A	N/A
Filler Type (Solid / Metal or flux cored / powder) (GTAW or PAW)	N/A	N/A
Weld deposit thickness for each welding process	7.1mm	Range of 10mm
Process 1: SMAW 3 layers minimum ☐ Yes ☐ No	N/A	N/A
Process 2: 3 layers minimum ☐ Yes ☐ No	N/A	N/A
Welding Position (2G,6G,3F , etc) (QW-405)	6G	3G
Vertical Progression (Up hill / Down hill)	Uphill	Uphill
Type of fuel gas (OFW)	N/A	N/A
Inert gas backing (GTAW, PAW, GMAW)	N/A	N/A
Transfer Mode (Spray / Globular or pulse to short circuit - GMAW)	N/A	N/A
GTAW Current type / polarity (AC,DCEP,DCEN)	N/A	N/A

RESULTS

Visual Examination of Completed Weld (QW-302.4) : **SATISFACTORY**

GUIDED BEND TEST RESULTS

Type and Figure as per ASME Sec IX	Result
N/A	N/A

Radiographic test Results (QW- 304 & QW -305) - ACCEPTABLE – Radiography report No.0021

(For Alternative qualification of Groove welds by Radiography) : _____

Fillet weld – Fracture test : N/A Length and percent of defects : N/A -inch

Macro Test Fusion : NA Fillet size (in) : N/A Concavity/ convexity -inch

Others tests : Radiography only

Welding Test conduct by : Mr. R. PARTHIBHAN

Film or specimens evaluated by : Mr.RAJESH K.NAIR Company : M/S PIH

Mechanical Tests conducted by : N/A Laboratory Test No. : N/A

Welding Supervised By : Mr. V.K. KANDAN Mr. R. PARTHIBHAN

(We certify that the statements in this record are correct and that test welds were prepared, welded and tested in accordance with the requirements of section IX of the ASME Boiler and Pressure Vessel Code)

FOR DYNAMIC ENGINEERS

Date	Organization	Organization : M/s.DYNAMIC ENGINEERS
Legend : N/A – Not Applicable	By	By PROPRIETOR

DYNAMIC ENGINEERS

FABRICATION ERECTION ENGINEERS, CONTRACTORS

3/144, MAPS MAIN ROAD,
SADRAS,
KALPAKKAM-603102,
Kancheepuram Dist.

Phone: 01114-27...

Ref:

Date 18.08.2008

TO WHOMSOEVER IT MAY CONCERN

This is to certify that Mr. M. SIVAKUMAR S/o. Mr. Munusamy was work in our M/s. DYNAMIC ENGINERERS, WIP SITE, KALPAKKAM as a TIG & ARC WELDER (3G) for the period 10.02.2008 to 18.08.2008.

His conduct, Character and proficiency of work is satisfactory.

I wish him all success in his future carrier.

FOR DYNAMIC ENGINEERS

M. Munusamy

PROPRIETOR

BLUE STAR

BLUE STAR LIMITED

Garuda Prestige
46 Cathedral Road Chennai 600 086
Telephone 28124000 Fax 91 44 28124100
www.bluestarindia.com

Date : 04.08.2009

TO WHOMSOEVER IT MAY CONCERN

This is to certify that **Mr. M. SIVA KUMAR S/o. MUNUSAMY** was working in our **M/s.BLUE STAR LIMITED, IGCAR SITE, KALPAKKAM as a TIG & ARC WELDER (6G)** for the period from **27.10.2008 to 04.08.2009.**

His conduct, Character and proficiency of work is satisfactory.

I wish him all success in his future carrier.

BLUE STAR LIMITED CHENNAI

KHARAFI NATIONAL



WELDER OR WELDING OPERATOR PERFORMANCE QUALIFICATION TEST CERTIFICATE (WPQ)

See QW301, Section IX, ASME Boiler and Pressure Vessel Code.

Company Name: ABJ INDUSTRIES Test Date 20-12-2010 Certificate No. 9125/33/187

Welder's name SIVA KUMAR MUNUSWAMY (ID NO103171.) Stamp no: AB-093

Welding process(es) GTAW+SMAW Type Manual

Identification of WPS followed by welder during welding of test coupon 2031/02A

Base material(s) welded SA 106 Gr.B Thickness 18.26

Manual or Semiautomatic Variables for Each Process (QW-350)	Actual Values	Range Qualified
Backing(metal,weld metal,welded from both sides,flux,etc.)(QW-402)	Without	Without for GTAW & with For SMAW
ASME P-No 1 to ASME P-No (QW-423)	P No. 1	P-No.1 Through P-No.15E, P-No.34, & P-No.41 through P-No.49.
( ) Plate (√) Pipe (enter diameter, if pipe) (QW 452)	DN 150 (NPS 6"OD)	73mm (2 7/8"OD) & above
Filler metal specification(SFA) Classification(QW-404)	5.18&5.1(ER70S-2&E7018)	
Filler metal F-No.	6 & 4	All F No 6 with or without&1,2,3 &4 with backing
Consumable insert(QW-404)	None	None
Consumable type(QW-404)	Solid	Solid
Weld deposit thickness for each welding process (QW 452)	GTAW - 4mm & SMAW - 14.26mm	GTAW - 8mm & SMAW - Unlimited.
Welding position (QW-405)	6G	All position
Progression (uphill / downhill)	Uphill	Uphill
Backing gas (QW-408)	Without	With or without
GMAW transfer mode(QW-409)	NA	NA
Welding Current type / polarity	GTAW-EN, SMAW - EP	GTAW-EN, SMAW - EP

Machine Welding Variables for the Process Used(QW-360)	Actual Values	Range Qualified
Direct / remote visual control		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position		
Consumable insert		
Backing (metal, weld metal, welded from both sides, flux, etc.)		

Guided Bend Test Results

Guide Bend Test Type	Specimen No:	Result
NA	NA	NA

Visual examination results (QW-302.4) : Accepted

Radiographic test results(QW-304 and QW-305) Accepted, RT report No.2031-RT-A WQT-21, Dated: 20 Dec.2010

(For alternative qualification of groove welds by radiography)

Fillet Weld - Fracture test NA Length and percent of defects NA

Macro test fusion NA Fillet leg size NA mm X mm

Welding test conducted by Welding Service Unit-UAE

Mechanical test conducted by: NA

Laboratory test no. NA

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 Code.

KHARAFI NATIONAL

CSWIP

Name PRAVEEN VENGARA 603748

Date WI 3.1

TECHNIMONT QA/QC Dept. Habshan-5 Process Plant

Test Witnessed by AI / CLIENT/ COMPANY

Name : K. Sathish

Date: 04/01/11

KUWAIT NATIONAL PETROLEUM COMPANY
QA / QC PROJECTS - PDI
WELDER IDENTIFICATION CARD



NAME : SIVA KUMAR
IDENTIFICATION NO. : GSW-340
CONTRACTOR : TECHNIMONT
PROJECT REF : CA/CSPD/0011
Approved / Witnessed by : Projects Dept. 1 Devendra Kumar

PRJ-QMS-91-97-5134-REV.4 (SIDE1)

WELDER CIVIL ID NO : H 9582291
WELDER QUALIFIED ON
PIPE : ☑ PLATE : ☐
POSITION : 6G UPHILL
SIZE : 2" THICKNESS: SCH 80 5.54mm
MATERIAL : ASTM A106 GR B P.No. : 1
FILLER MATERIAL : ER70S2 F. No. : 6
TECHNIQUE : GTAW
DATE OF TEST : 14/12/15 VALIDITY : 13/12/16
This Card may be revoked on the job, If in the opinion of The Inspection Engineer, weld quality is not satisfactory

for CS weld only PRJ-QMS-91-97-5134-REV.4 (SIDE:

KUWAIT NATIONAL PETROLEUM COMPANY
PROJECTS DEPARTMENTS - QA/QC PROJECTS
WELDER IDENTIFICATION CARD



NAME : SIVA KUMAR
IDENTIFICATION NO. : GSW-340
CONTRACTOR : TECHNIMONT
PROJECT REF : CA/CSPD/0011
Approved / Witnessed by : Projects Dept. 1 Devendra Kumar

PRJ-QMS-91-97-5134 REV.5 - SIDE 2 (Apr.15)

WELDER CIVIL ID NO : H 9582291
WELDER QUALIFIED ON
PIPE : ☑ PLATE : ☐
POSITION : 6G UPHILL
SIZE : 6" THICKNESS: SCH 80 - 10.97mm
MATERIAL : ASTM 106 GR B P. No. : 1
FILLER MATERIAL : ER70S2 + E7018-1 F. No. : 6 & 4
TECHNIQUE : GTAW + SMAW
DATE OF TEST : 3/12/15 VALIDITY : 2/12/16
(QUALIFIED TO WELD ON 1G ONLY)
This Card may be revoked on the job, If in the opinion of the Inspection Engineer, weld quality is not satisfactory

PRJ-QMS-91-97-5134 REV.5 - SIDE 2 (Apr.15)

BLUE STAR LIMITED

WELDER PERFORMANCE QUALIFICATIONS (WPQ)

(See QW – 301, Section IX ASME Boiler and Pressure Vessel Code)

Date : 28.10.2008

Company Name: BLUE STAR LIMITED
Name: M. SIVA KUMAR
Welder's ID No: PW 21 Test Place: IGCAR, Kalpakkam
Identification of WPS followed: BSL/(K)IGCAR/WPS – 007 Thickness: 5.54mm

Welder's Photo



Testing Conditions and Qualification Limits

Welding variables (QW-350)	Actual Values	Range Qualified
Welding Process (es)	GTAW + SMAW	GTAW + SMAW
Type (ie; manual, semi – Automatic etc)	Manual	Manual
Backing (metal, weld metal, double – welded etc)	Without Backing	With or without Backing
( ) plate ( ) Pipe (enter diameter, if pipe)	2" NB	2" OD and Above
Base metal P or S-S number to P or S-Number	P8 to P8	P8 Through P8
Filler metal or electrode specification(s) (SFA) (info only)	5.9	
Filler metal or electrode classification(s) (info only)	ER 70S2, E7018	
Filler metal F-Number(s) (SFA)(info only)	6	6
Consumable insert (GTAW)	N/A	N/A
Filler type (Solid/metal or flux cored powder)(GTAW/PAW)	Solid	Solid
Weld deposit thickness for each welding process	6.36 mm	11.08mm Max
Position qualified (6G)	6G	All
Vertical progression (uphill / downhill)	UP – HILL	UP-HILL
Inert gas backing (GTAW, PAW, GMAW)	Nil	With or without inert gas backing
Transfer mode (Spray/ globular or pulse to short circuit - GMAW	N / A	N/A
GTAW current type/polarity	DCSP	DCSP

RESULTS

Visual Examination of completed weld (QW-302.4) SATISFACTORY

Guided Bend Test Results

Type	Result	Type	Result

Alternative radiography examination results (QW-191) SATISFACTORY
Fillet Weld – Fracture test (QW-180) N/A Length and percent of defects : Nil
Macro examination (QW-184) N/A Fillet leg size N/A Concavity/convexity(in) : Convexity
Remarks :

We certify that the statements in this record are correct and that the test coupon were prepared, welded, and tested in accordance with the requirements of section IX of the ASME code.

BLUE STAR LIMITED CHENNAI

For BLUE STAR LIMITED

IGCAR - SITE QA QC KALPAKKAM - 603 102.

Test Witnessed by

BLUE STAR

WELDERS QUALIFICATION CARD

Name M. SIVA KUMAR
PW.NO 21
Position 6G
Date of Qualification
28.10.2008 CS



For BLUE STAR LTD Tested witnessed by

WELDING PROCESS GTAW & SMAW

W.P.S No	Material / Process	Range Qualified
007	Carbon Steel	2" and Above
Filler metal	ER 70S2 E 7018	

Section IX ASME and pressure Vessel Code

DYNAMIC ENGINEERING.
WELDERS QUALIFICATION CARD

Name : M. SIVA KUMAR
Welder No : W 12
WPS Qualification : WELDER 3G
Date of Test : 12.02.2008



FOR DYNAMIC ENGINEERS
PROPRIETOR
For DYNAMIC ENGG.,
Tested witnessed by

QUALIFICATION DETAILS

Process	Electrode	Range Thk	Position	Date Qual
GTAW & SMAW	ER 70s2 E 7018	10mm	3G	12.02.2008

" Thickness in mm" & "Diameter in inches"

TPS BUILDERS LTD

WELDERS QUALIFICATION CARD

Name M.SIVA KUMAR
PW.No
Position
Date of Qual 28.10.2008



For TPS BUILDERS Ltd.

W.P.S No 007
PROCESS GTAW, SMAW
POSITION 6G
MATERIAL 70S2, 7018

QUALIFIED RANGE

Thickness (t) 1.5 to 15mm
2" and above

IF YOU LOSE THIS CARD IMMEDIATELY NOTIFY YOUR ENGINEER. IF FOUND PLEASE RETURN

ABJ
Engineering & Contracting Co. KSC (Closed)

QUALIFIED WELDERS ID CARD

FRONT

ABJ - KUWAIT

WELDER/ WELDING OPERATOR ID CARD

NAME : **SIVA KUMAR MUNUSWAMY**

EMP ID No : **103171**

WELDER ID NO. : **AJ 1607** WPS NO : **0395/07 Rev.C**

CERTIFICATE NO : **0395/P/139/582**

DATE OF WELDING : **28/03/2013** VALIDITY: **Till Satisfactory TEP UK Laggan Formore Performance**

ISSUED BY : Welding Insp.

APPROVED BY : ☐ WITNESS ☑ ACCEPTED ☑ REVIEW ☐ NOT AC

BACK

QUALIFIED FOR



PROCESS : **GTAW**

POSITION : **ALL**

TECHNIQUE : **UPHILL**

BASE METAL : **** P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49**

BASE METAL THK : **All**

FILLER METAL : **All F No 6 with or without Backing**

WELD METAL THK : **11.04 mm Max. Fillet All**

PIPE DIA : **25 mm (1") OD &above , Fillet All**

REMARKS: **** For Laggan Tormore Project, this Welder qualified to weld only " P8 to P8 and P8 to P1" Base metal.**

CODE : ASME IX ■ AWS D1.1 ☐

ABJ
Engineering & Contracting Co. KSC (Closed)

QUALIFIED WELDERS ID CARD

FRONT

ABJ - KUWAIT

WELDER/ WELDING OPERATOR ID CARD

NAME : SIVA KUMAR MUNUSWAMY
EMP ID No:. 103171
WELDER ID NO. : AJ 1607 WPS NO.: 0395/05 Rev.B
CERTIFICATE NO. : 0395/P/363/093
DATE OF WELDING : 23/06/2012 VALIDITY: Till Satisfactory Performance
ISSUED BY : (SIVA KUMAR)
APPROVED BY : LEONARDO S

BACK

QUALIFIED FOR



PROCESS : GTAW+SMAW
POSITION : ALL
TECHNIQUE : UPHILL
BASE METAL : ** P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49
BASE METAL THK : All
FILLER METAL : All F No.6 with & without, F No. 1,2,3 & 4 with backing
WELD METAL THK: GTAW-8mm Max, SMAW-Unlimited, For Fillet all thk.
PIPE DIA : Dia. 73mm(2 7/8")OD & Above, Fillet - All
REMARKS: ** For Laggan Tormore Project, this Welder qualified to weld only P No.1 Base metal. ☐ WITNESS ☑ ACCEPTED
CODE : ASME IX ■ AWS D1.1 ☐ ☑ REVIEW ☐ NOT ACCEPTED

TEP UK Laggan Tormore
Welding Insp
8/7/12

Leonardo S
7/7/12

WELDER ID CARD

KHARAFI NATIONAL Co. (L.L.C.)

HABSHAN 5 PROCESS PLANT



NAME :	SIVA KUMAR MUNUSWAMY
BADGE NO.:	ID NO10317 I
WELDER ID NO:	AB-093
CERTIFICATE NO:	9125/33/187
ISSUED BY (KN QC)	APROVED BY TCM

NAME	PRAVHENV	[illegible]	[illegible]
SIGNATURE	[illegible]	QA/QC Dept.	AE - 0057
DATE	21/12/10	3.1.11	04/01/11

QUALIFIED

WPS NO :	2031/02A
PROCESS	GTAW+SMAW
POSITION	All Position
MATERIAL	
BASE (P - No.)	P No 1 through P No 15F, PNo 34 & PNo 41through P No 49
FILLER (F - No.)	All F No 6 with or without & 1,2,3,4 with backing
RANGE: DIA.:	GTAW-73mm OD & above; SMAW - 73mm OD & above
THK	GTAW- 6mm; SMAW - Unlimited
CODE : ASME IX ☑	API-1104 ☐ AWS D 1.1 ☐

VALID UNTIL SATISFACTORY PERFORMANCES IN THE PROJECT

QUALIFIED FOR



PROCESS : GTAW+SMAW

POSITION : ALL

TECHNIQUE : UPHILL

BASE METAL : ** P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49

BASE METAL THK : All

FILLER METAL : All F No.6 with & without, F No. 1,2,3 & 4 with backing

WELD METAL THK: GTAW-8mm Max, SMAW-Unlimited, For Fillet all thk.

PIPE DIA : Dia. 73mm(2 7/8")OD & Above, Fillet - All

REMARKS: ** For Laggan Tormore Project, this Welder qualified to weld only P No.1 Base metal.

For UK Laggan Tormore Welding Insp

☐ WITNESS ☑ ACCEPTED

CODE : ASME IX ■ AWS D1.1 ☐ ☑ REVIEW ☐ NOT ACCEPTED

ABJ - KUWAIT

WELDER/ WELDING OPERATOR ID CARD

NAME : SIVA KUMAR MUNUSWAMY

EMP ID No.: 103171

WELDER ID NO. : AJ 1607 WPS NO.: 0395/05 Rev.B

CERTIFICATE NO. : 0395/P/363/093

DATE OF WELDING : 23/06/2012 VALIDITY: Till Satisfactory Performance

ISSUED BY : (SIVE KUMAR)

APPROVED BY : LEONARDO S

QUALIFIED WELDER ID CARD

FRONT SIDE OF CARD

KHARAFI NATIONAL

WELDER/WELDING OPERATOR ID CARD

KOC Contr.No:45283	KOC Project No: EF/ 1718

Name : SIVA KUMAR MUNUSWAMY (ID 103171) Test Date : 22-03-2014

Stamp No.: AJ 1607 Validity : Till Satisfactory Performance

KN Q/C : [illegible] Sign : [signature]

SAIPEM: K.V.S.Reddy Sign : [signature]

KOC: JOHN GRAHAM Sign : [signature]

BACK SIDE OF CARD

Qualification Details



WPS No.: 1664/001

Process : GTAW+SMAW

Position : All

Cert. No. : 1664/714

Code : ■ ASME IX ☐ API 1104 ☐ AWS D1.1

MATERIAL

Base : P No. 1 thru P No. 15F, P No. 34 & P No. 41 thru 49

Filler : All F No. 6 with or without, F No. 1,2,3 & 4 with backing.

Range : Dia. 73mm(2 7/8")OD & Above, Fillet- All

Thk; GTAW-8mm (Max.), SMAW-Unlimited,, For Fillet -All thk.

QUALIFIED WELDER ID CARD

FRONT SIDE OF CARD

KHARAFI NATIONAL

WELDER/WELDING OPERATOR ID CARD

KOC Contr.No:45283	KOC Project No: EF/ 1718

Name : SIVA KUMAR MUNUSWAMY (ID 103171)

Test Date : 08-09-2013

Stamp No : AJ 1607

Validity : Till Satisfactory Performance

KN Q/C : [illegible] Sign :

SAIPEM: SADIK BASHA Sign :

KOC: JOHN GRAHAM Sign : J Graham

BACK SIDE OF CARD

Qualification Details



WPS No.: 1664/009

Process : GTAW

Position : All

Cert. No. : 1664/455

Code : ■ ASME IX ☐ API 1104 ☐ AWS D1.1

MATERIAL

Base : P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49

Filler : F No. 34 and all F No. 41through F No. 46 with or without Backing

Range : Dia. 25mm(1")OD & Above, Fillet - All

Thk.- 11.08mm (Max), For Fillet all thk.

KHARAFI NATIONAL



WELDER OR WELDING OPERATOR PERFORMANCE QUALIFICATION TEST CERTIFICATE (WPQ)
See QW301, Section IX, ASME Boiler and Pressure Vessel Code.

Company Name: ABJ INDUSTRIES Test Date 20-03-2011 Certificate No. 9125/64/421

Welder's name SIVA KUMAR MUNUSWAMY (ID-103171) Stamp no: AB-093

Welding process(es) GTAW Type Manual

Identification of WPS followed by welder during welding of test coupon 2031/01A

Base material(s) welded SA 106 Gr.B Thickness 8.74

Manual or Semiautomatic Variables for Each Process (QW-350)	Actual Values	Range Qualified
Backing(metal,weld metal,welded from both sides,flux,etc.)(QW-402)	Without	With or Without
ASME P-No 1 to ASME P-No (QW-423)	P No. 1	P-No.1 Through P-No.15F, P-No.3 & P-No.41 through P-No.49.
( ) Plate (√) Pipe (enter diameter, if pipe) (QW 452)	DN 50 (NPS 2"OD)	25mm (1"OD) & above
Filler metal specification(SFA) Classification(QW-404)	5.18 (ER 70S2)	
Filler metal F-No.	6	All F No 6 with or without backing
Consumable insert(QW-404)	None	None
Consumable type(QW-404)	Solid	Solid
Weld deposit thickness for each welding process (QW 452)	8.74mm	17.48mm
Welding position (QW-405)	6G	All position
Progression (uphill / downhill)	Uphill	Uphill
Backing gas (QW-408)	With out Backing	With and without Backing
GMAW transfer mode(QW-409)	NA	NA
Welding Current type / polarity	DCEN	DCEN

Machine Welding Variables for the Process Used(QW-360)	Actual Values	Range Qualified
Direct / remote visual control		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position		Acu
Consumable insert		
Backing (metal, weld metal, welded from both sides, flux, etc.)		

Guided Bend Test Results

Guide Bend Test Type	Specimen No:	Result
NA	NA	NA

Visual examination results (QW-302.4) : **Accepted**

Radiographic test results(QW-304 and QW-305) **Accepted, RT report No. 2031-RT-A-WQT-85,Dated:20/03/2011**

(For alternative qualification of groove welds by radiography)

Fillet Weld - Fracture test NA Length and percent of defects NA

Macro test fusion NA Fillet leg size NA mm X _____ mm

Welding test conducted by **Welding Service Unit-UAE**

Mechanical test conducted by: NA

Laboratory test no. NA

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 Code.

KHARAFI NATIONAL **Test Witnessed by AI / CLIENT/ COMPANY** TPI

CSWIP
PRAVEEN VENGARA
603748
WI 3.1

Name _____

Date 21/03/11

QA/QC Dept.

Name : RAJESH BABU

Date: 27.03.2011

3539-LZ-PF-TX002 Att.3 Rev 0 04 Mar 2010

ABJ
Engineering & Contracting Co. KSC (Closed)

QW - 484A WELDER PERFORMANCE QUALIFICATION RECORD (WPQ) Certificate No. 0395/P/363/093
(See QW301, Section IX, ASME Boiler and Pressure Vessel Code.)



Company Name: ABJ Test Date: 23/06/2012 Test No.: 020
Welder's name SIVA KUMAR MUNUSWAMY (ID 103171) Stamp no: AJ 1607
Identification of WPS followed 0395/05 Rev.B ■ Test coupon ☐ Production weld
Specification of Base metal(s) welded SA333 GR.6 Thickness 18.25 mm

Testing Conditions and Qualification Limits

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding Process(es)	GTAW+SMAW	GTAW+SMAW
Type (Manual, Semi Auto) used	Manual	Manual
Backing (Metal, Weld metal, Double Welded etc.)	GTAW-without backing, SMAW-with backing	GTAW-with & without, SMAW-with backing
☐ Plate ■ Pipe (enter diameter, if pipe or tube)	DN 150(NPS 6)	73mm(2-7/8")OD & above
Base Metal P or S Number to P or S Number	P No 1	** P No 1 Thru P No 15F, P No 34 & P No 41 Thru 49
Filler metal or electrode specification(SFA)	SFA 5.18, SFA 5.1	Applicable 'F' Number
Filler metal or electrode classification	ER 70S-2 & E7018-1	Applicable 'F' Number
Filler metal F-Numbers	F No.6 without backing, F No. 4 with backing	All F No.6 with & without, F No. 1,2,3 & 4 with backing
Consumable insert for GTAW or PAW	None	N/A
Addition or Delition of Filler Metal(GTAW or PAW)	With	With
Filler Type (Solid/ Metal or Flux cored/ Powder)(GTAW or PAW)	Solid wire For GTAW	Solid wire For GTAW
Deposit thickness for each process		
Processes 1: GTAW - 3 layers minimum ☐ Yes ■ No	4 mm	8mm Max , Fillet- All
Processes 2: SMAW - 3 layers minimum ■ Yes ☐ No	14.25 mm	Unlimited , Fillet- All
Position Qualified	6G	ALL
Vertical Progression (uphill / downhill)	UPHILL	UPHILL
Type of fuel gas (OFW)	N/A	N/A
Inert gas backing (GTAW, PAW, GMAW)	Without	With or With out
Transfer mode(Spray,/Globular or pulse to Short circuit-GMAW)	N/A	N/A
GTAW current type / polarity (AC, DCEP, DCEN)	DCEN	DCEN

TEST RESULTS

Visual examination results (QW-302.4) Acceptable

■ Bend test ; ☐ Transverse root & face[QW-462.3a] ; ☐ Longitudinal root & face[QW-462.2b] ■ Side[QW-462.2]
☐ Pipe bend specimen, corrosion-resistant overlay[QW-462.5c] ; ☐ Plate bend specimen, corrosion-resistant overlay[QW-462.5d] ;
☐ Macro test for fusion[QW-462.5b] ☐ Macro test for fusion[QW-462.5e]

Test Type	Specimen No:	Result
Side Bend	1512-3 SB1	Satisfactory
Side Bend	1512-3 SB2	Satisfactory
Side Bend	1512-3 SB3	Satisfactory
Side Bend	1512-3 SB4	Satisfactory

Alternative Radiographic examination results(QW-304 and QW-305): Accepted Vide RT Report No.9165/0395/RT/191 , Dt: 24-06-2012
Fillet Weld - Fracture test(QW-180) N/A Length and percent of defects
Macro Examination(QW-184) N/A leg size ____ mm X ____ mm Concavity / Conve... ____ mm
Other tests N/A
Film or specimen evaluated by: N.Mohammed Nazeer Company: KN/ABJ
Mechanical tests conducted by: International Inspection Centre W.L.L
Laboratory test no. IIC/PHY/903/12 Pg-1-1, Dated: 02/07/2012
Welding supervised by N.Mohammed Nazeer
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 Code. Edition: 2010

TEP UK Laggan Tormore
Welding Insp
☐ WITNESS ☐ ACCEPTED
☐ REVIEW ☐ NOT ACCEPTED

Remarks: For Laggan Tormore Project, this Welder qualified to weld only P No.1 Base metal**

ABJ
Name: P.VELOUMMY
Date: 03/07/2012

LEONARDO S
7/7/12

Test witnessed by ALL CLIENT
Name:
Date: 04/07/2012

Lloyd's Register

9125/TWI851 Att.3A Rev.1 18 Jun. 2011

12376

भारत गणराज्य REPUBLIC OF INDIA



प्रकार / Type: P
राष्ट्र कोड / Country Code: IND
पासपोर्ट सं. / Passport No.: M5890460

उपनाम / Surname: MUNUSWAMY

दिया गया नाम / Given Name(s): SIVAKUMAR

राष्ट्रीयता / Nationality: INDIAN
लिंग / Sex: M
जन्म तिथि / Date of Birth: 02/06/1990

जन्म स्थान / Place of Birth: SADHURANGAPATTINAM, TAMIL NADU

जारी करने का स्थान / Place of Issue: CHENNAI

जारी करने की तिथि / Date of Issue: 28/01/2015
समाप्ति तिथि / Date of Expiry: 27/01/2025

P<INDMUNUSWAMY<<SIVAKUMAR<<<<<<<<<<<<<<<<<<<<
M5890460<6IND9006027M2501279<<<<<<<<<<<<<<<0

टिप्पणी / OBSERVATIONS

विविध सेवा / MISCELLANEOUS SERVICE

EMIGRATION CHECK REQUIRED



पिता / वास्तविक अभिभावक का नाम / Name of Father / Legal Guardian
MUNUSWAMY PARTHASARATHY

माता का नाम / Name of Mother
SHANTHI MUNUSWAMY

पति या पत्नी का नाम / Name of Spouse

पता / Address
NO.8/40,SADHURANGAPATTINAM

THIRUKAZHUKUNDRAM,KANCHIPURAM

PIN:603102,TAMIL NADU,INDIA

पुराने पासपोर्ट का नं. और उसके जारी होने की तिथि एवं स्थान / Old Passport No. with Date and Place of Issue
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