

WELDER QUALIFICATION TEST RECORD

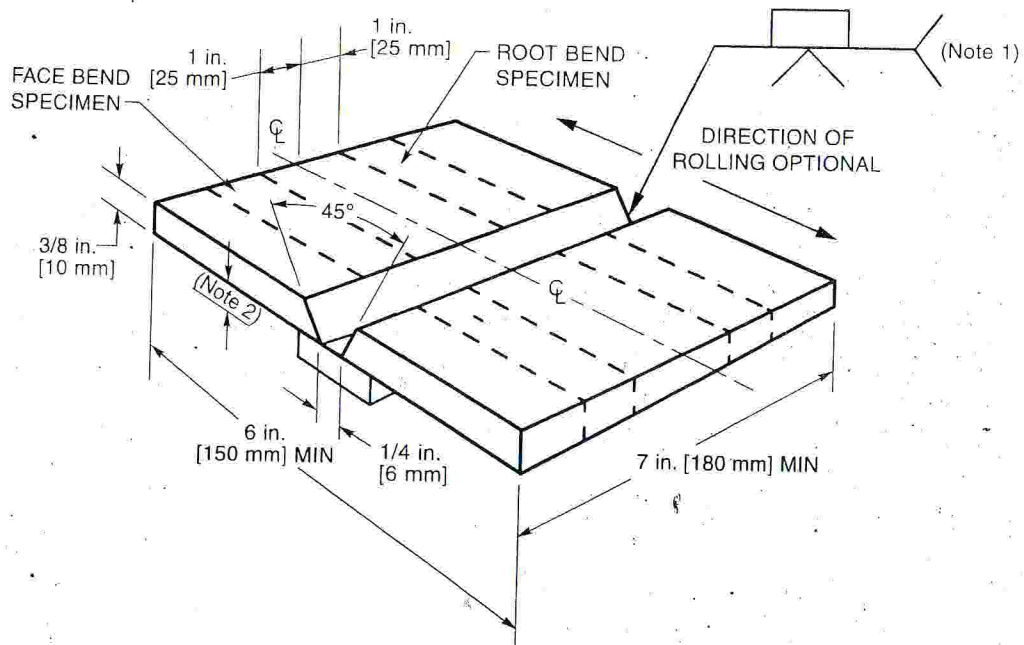
Date February 8, 2008
 Job No. T0806525
 Permit No. na
 Client Pacific Stair Corp.
 Welder Name Scott Clem
 Manufactures Welding Procedure Specification No. _____
 Witnessed by M. Carter
 Manufacturer or Contractor Pacific Stair Corp.
 Project na
 Social Security No. [REDACTED]
 CTIGMAW Revision 0
 Organization CTI
 Authorized By Todd
 Certification # C-2578
 Date 2/12/1996
 Date 2/5/2008
 Date 2/5/2008

Variables	Record actual values Used in Qualification		Qualification Range
Process/Type	<u>GMAW</u>		<u>GMAW</u>
Electrode (single or multiple)	<u>Single</u>		
Current/Polarity	<u>DCEP</u>		
Position	<u>1G</u>		<u>1G</u>
Weld Progression	<u>na</u>		<u>na</u>
Backing (YES or NO)	<u>Yes</u>		<u>Yes</u>
Material/Spec.			
Base Metal	<u>A-36</u>	To <u>A-36</u>	
Thickness: (Plate)			
Groove	<u>3/8"</u>		<u>1/8" to 3/4"</u>
Fillet	<u>na</u>		<u>1/8" to unlimited</u>
Thickness: (Pipe/tube)			
Groove	<u>na</u>		<u>na</u>
Fillet	<u>na</u>		<u>na</u>
Diameter: (Pipe)			
Groove	<u>na</u>		<u>na</u>
Fillet	<u>na</u>		<u>na</u>
Filler Metal			
Spec. No.	<u>A 5.18</u>		
Class	<u>ER70S-6</u>		<u>ER7XS-XX</u>
F-No.	<u>F-6</u>		
Gas/Flux Type	<u>Argon / CO2</u>		
Other	<u>90% / 10%</u>		

VISUAL INSPECTION							
GUIDED BEND TEST RESULTS				Acceptable YES or NO			
Type	Root	Result	Pass	Type	Face	Result	Pass
Fillet Test Results				Fillet size			
Appearance				Macroetch			
Fracture Test Root Penetration							
Inspected by	<u>M. Carter</u>	Company	<u>CTI</u>	Date	<u>2/7/2008</u>	Test Number	<u>M3095</u>
RADIOGRAPHIC TEST RESULTS							
Film				Film			
Identification				Identification			
Number	Results	Remarks	Number	Results	Remarks	Number	Results
Inspected by		Company		Date		Test 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 the requirements of Section 4, Part C of ANSI/AWS D1.1, (2006) Structural Welding Code.

CTI Authorized Representative [Signature] Date 2/13/08



Notes:

1. When RT is used, no tack welds shall be in test area.
2. The backing thickness shall be 1/4 in. [6 mm] min to 3/8 in. [10 mm] max; backing width shall be 3 in. [75 mm] min when not removed for RT, otherwise 1 in. [25 mm] min.

**Figure 4.30—Test Plate for Limited Thickness—All Positions—
Welder Qualification (see 4.23.1)**

Welder Certification program

Pacific Stair Corporation welders are tested and certified by an Independent third party (Carlson Testing, Inc.) and conform with the following conditions:

AWS D1.1-06

Process: GMAW

Position: 1G

Weld Description: VEE GROOVE

Material A-36

Filler: ER70s-6

Thickness: 1/8"-3/4"

Per AWS D1.1 the third party will inspect the plates using the guided bend test. If the plates are found to be acceptable per AWS D1.1 then the welder becomes certified as noted above.

WELDER CERTIFICATION

Cert. No: C-2578
Welder: SPOTT CLEM
SS#: [REDACTED]
City of Portland Expiration Date: 02/08/2009
Welder Signature: [Signature] Date: _____
CTI Authorized Signature: [Signature] 02/13/2008

Carlson Testing, Inc.
Tigard, Oregon (503) 684-3460
See Reverse Side for Qualification Data

Qual. Spec: AWS D1.1-06
Process: GMAW Position: 1G
Weld Desc: VEE GROOVE
Material: A-36
Filler: ER70S-6 Thickness: 1/8" TO 3/4"
Remarks: BACKING REQUIRED