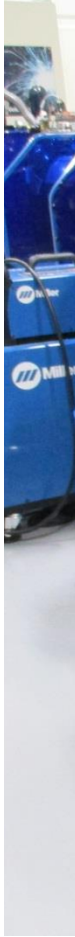


PIT Instruction & Training, LLC



Volume 1.5 - January 2021



Quality Assurance Manual



PIT Instruction & Training, LLC
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INTRODUCTION

Section 1.0

Individuals who wish to become Certified Welders through the American Welding Society (AWS) can schedule testing dates to achieve their AWS DX.X certification at PIT Instruction & Training, LLC. AWS welder testing is available for experienced welders and graduates of PIT’s Pit Weld U Powered by Miller Welders welding program. Pit Instruction & Training, LLC will meet all codes and specifications as spelled out by the AWS to ensure proper testing practices.

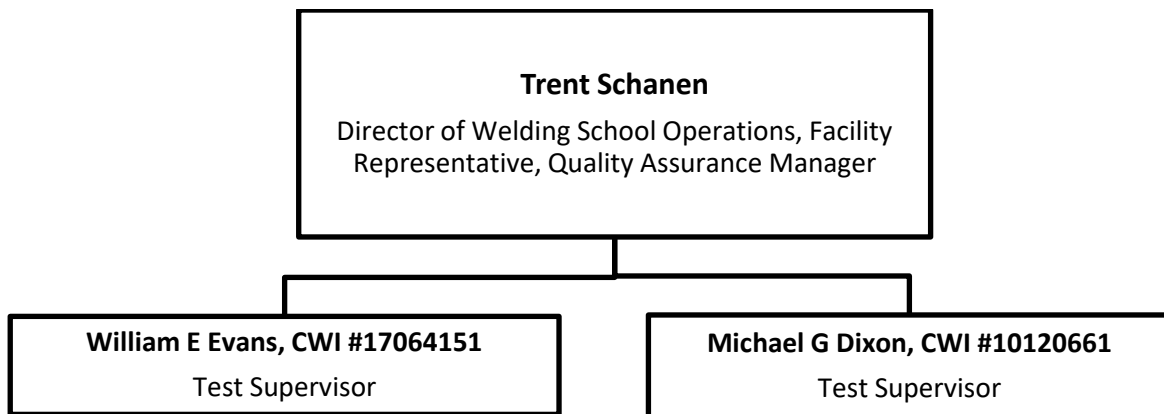
Quality Policy

1.1

Pit Instruction & Training will follow and support all standards set forth in the American Welding Society’s QC-4, QC-7 and B5.4-05 ATF Standard manuals for its Certified Welder Program to ensure performance of technical functions for which certification is sought. Management will review the QA program on an annual basis to ensure that proper procedures continue to be followed.

ORGANIZATIONAL CHART

Section 2.0



Faculty Roles

Section 3.0

Director of Welding School Operations

3.1

The Director of Welding School Operations serves as the Facility Representative and Quality Assurance Manager, and ensures that administrative items are completed including but not limited to certified welder applications, Quality Assurance Manual (QAM), etc. The Director must also maintain that welding instructors and test supervisors are following all guidelines that are laid out by the American Welding Society when testing to certify welders. The Director also serves as Quality Assurance Manager and must oversee that the Company Policy is complied with, and has direct access to Board Members.

Facility Representative

3.2

The Facility Representative is responsible for taking and documenting all Certified Welder Applications (EXHIBIT G), and record keeping of each individual’s tests, paperwork and fees paid. Facility Representative must also ensure proper welder calibration, scheduling of such and maintaining records and calibration logs for necessary welding equipment. Additionally, the Facility Representative must oversee proper control of materials needed for testing including but not limited to ordering testing materials, ensuring that test materials come with necessary reports, and proper storage of materials in accordance American Welding Society standards.

Quality Assurance Manager

3.3

The Quality Assurance Manager is responsible for ensuring that the facility follows all standards necessary in accordance with the AWS QC-4 to ensure compliance. The QA Manager ensures that policies set forth by Pit Instruction & Training per the AWS standards for the Certified Welder Program are followed by the Test Supervisor. The QA Manager is also responsible for reviewing and updating the Quality Assurance Manual as needed.



Test Supervisor

3.4

The Test Supervisor must be a Certified Welding Inspector currently qualified to the requirements of AWS QC-1 when conducting tests to certify welders including but not limited to preparing bend test specimens, overseeing testing, inspection of tests and filling out and submitting appropriate paperwork to the AWS. Said Test Supervisor must also strictly follow procedures laid out in the PIT Instruction & Training, LLC Quality Assurance Manual (QAM). As such, the Test Supervisor is not permitted to test students taking part in the Certified Welder program who have been in another training program including but not limited to a Pit Weld U Powered by Miller Welders welding course in which the Test Supervisor was also their instructor. Test Supervisor is solely responsible for maintaining current CWI status with the AWS including but not limited to necessary training, professional development hours and re-testing as required.

CERTIFIED WELDER PROGRAM OPERATIONS

Section 4.0

The program is under the observation of the Facility Representative, Quality Assurance Manager and Test Supervisor and complies with all guidelines set forth by the American Welding Society. Additional details are spelled out below in the following sections defining specific guidelines. Said individuals work together to ensure proper preparation and accuracy of all records kept at the testing facility.

Library

4.1

All paperwork and documentation including but not limited to Welder Qualification Forms, ASC-Z49 Safety in Welding & Cutting document, AWS Certified Welder Applications (EXHIBIT G), blank ATF WPQR forms (EXHIBIT F), Maintenance of Welder Certification (EXHIBIT H) forms, Visual Examination form (EXHIBIT I), safety records and documentation and company policies are kept in a library that's accessible to employees and test candidates. A full list of all documents and forms utilized may be found in the Appendix on page eight (8) of this document.

Copies of all necessary Welding Procedure Specifications used for the testing of welders, and WPS and PQR lists are kept on file in the Library at the testing facility. Blank copies of applicable WQTR and WPQR documents are also kept on file.

TESTING & QUALITY CONTROL PROCEDURES

Section 5.0

Certification

5.1

Test candidates must submit a Pit Instruction & Training, LLC Certified Welder Registration Form and AWS Certified Welder Application, found in "EXHIBIT G", to be considered eligible for certification. Test Candidates must also present a valid state or government issued photo identification upon arrival and will be informed of Testing Facility requirements, safety procedures and fit-up tolerances prior to testing. Sample applications are available upon request. Individuals are able to become certified in accordance to AWS qualification codes.

Equipment Maintenance & Calibration

5.2

Pit Instruction & Training's welding equipment is calibrated to meet standards and requirements per the National Institute of Standards and Technology by welding machine manufacturer or Airgas National Welders Performance Plus per ISO 9000 and ANSI Z540-1 requirements of quality standards. Units are calibrated on an annual basis to ensure that performance meets aforementioned standards. Welding equipment calibration certificates and maintenance records are available upon request. Calibrated welding equipment is clearly marked with calibration tags at each unit. Operating manuals for said units are available in the Library at the Testing Facility.

Employee Qualifications & Training

5.3

As laid out in QAM 3.0, only qualified employees are to partake in operations of the Certified Welder program including but not limited to testing, purchasing, record keeping and submission of paperwork to the American Welding Society.

Training procedures to familiarize new employees of PIT Instruction & Training, LLC's policies and procedures for the Certified Welder program are in place and under the responsibility of the Director of Welding School Operations.



Purchasing & Order Review

5.4

The Facility Representative is responsible for purchasing all materials necessary for testing. Purchase Orders – see “EXHIBIT E” for an example – must note that material test reports on base metals and certificates of conformance for filler metals are required to accept delivery. Sample Purchase Orders from vendors are available for review. Upon receiving testing materials, the Test Supervisor will confirm that they meet the standards as laid out in QAM 5.5.

Testing Materials & Quality Control Procedures

5.5

Testing materials meet minimum ASTM standards and filler metals meet standards as per AWS A5.X. Certificates and paperwork providing specific mill test reports for testing materials confirming said standards and conformance are available upon request – original copies are kept with the testing materials themselves, while additional copies are kept on file by the Test Supervisor. All testing materials are stored in a separate locked storage area at the testing facility to ensure proper material traceability and are to be checked in by either the Test Supervisor or Facility Representative. Refer to the checklist found in “EXHIBIT D” for controls ensuring necessary steps are followed. All testing materials are procured from approved vendors as defined in QAM 7.2 and “EXHIBIT E” by the Facility Representative.

A copy of the Pit Instruction & Training AWS DX.X tests and Welding Procedures (WPS) are available at each candidate’s station. Test Supervisor will verify safety equipment and ensure that each test meets ASTM Standards in addition to a visual inspection confirming that fit-up is verified and test plates have not been repositioned without approval. Measurements and fit-up will be verified in accordance with checklists hereby referred to as “EXHIBIT A” in this document. Following completion of testing, test coupons may be submitted to sub-contractor for examination as defined in QAM 7.0 and 7.1.

PREPARING & SUBMITTING TESTS

Section 6.0

Pit Instruction & Training’s Test Supervisor will ensure that testing materials meet all American Welding Society standards prior to scheduled test dates by ensuring all necessary paperwork has been received with testing materials and PIT Pre-Weld Checklist. Additional checklists are in place that the instructor must complete during and following testing to ensure compliance. See Appendix (Section 13.0) to reference documents. Testing materials are purchased from Triangle Engineering, Inc and Race City Steel. Each test contains welding instructions, positional drawing(s), mill test reports, welder qualification form, shipping form, plates, electrode, and backing. Test Supervisor will review tests and document results of all tests in accordance with WPS and PQR forms under AWS DX.X. All AWS Certified Welder Applications see “EXHIBIT G”, and corresponding documentation will be submitted to the American Welding Society Certification Business Unit within two weeks (14 days) by Pit Instruction & Training, LLC via mail for processing. Individuals can expect to receive a certificate with their Certified Welder status within six (6) to eight (8) weeks following their testing date. All necessary records and documentation are to be prepared by the Test Supervisor and submitted to the Facility Representative for retention.

Pass / Fail Standards

6.1

Tests will either be subjected to bend testing at PIT Instruction & Training, LLC or submitted to an independent testing facility for non-destructive testing (radiographic examination). The independent testing facility will submit the results of each test to Pit Instruction & Training, LLC within five business days following completion of radiographic examination, at which point individuals will be notified of their test’s status.

Bend Testing

6.2

PIT Instruction & Training, LLC shall be responsible for bend testing when applicable, with testing and examination performed solely by the Test Supervisor in accordance with AWS D1.X standards and documented following steps laid out in “EXHIBIT B”. Additionally, the welder’s identification code will be uniquely marked on their respective test specimen to ensure proper traceability. Upon completion of testing, results and accompanying paperwork including visual examination report (EXHIBIT I) will be stored in the welding candidate’s file.



Documentation

6.3

Each welder's files will contain a copy of all test results, initial and subsequent applications, WPQR, checklists found in "EXHIBIT A" and "EXHIBIT B", Visual Examination report when pertinent (EXHIBIT I) and receipt of payment for said test. Additionally, their welder identification code and test materials identification will be recorded and kept with test records along with the Performance Qualification Test Record. Should the welder need to re-take a test, copies of each attempt will also be kept in the file with results and further receipts of payment. Written records will be retained for a five (5) year period. Test specimens will be maintained until WPQR is completed, at which point they will be disposed of.

Identification

6.4

Each welder will be assigned an identification code that consists of the welder's initials (first letter of first, middle and last name) followed by the last four digits of the welder's Social Security Number. The code will be used to designate the welder, and will be recorded on the welder's test coupon and paper work. Ex: TWS-1234.

SUBCONTRACTED ACTIVITIES

Section 7.0

Subcontracted activities are to comply with the quality control procedures and requirements of Pit Instruction & Training, LLC as defined by the purchase order, a sample of which may be found in "EXHIBIT E".

Radiographic Examination

7.1

Baker Testing Services, Inc. is responsible for radiographic examination of welders' test specimens submitted by Pit Instruction & Training, LLC when required. The examiner must be at a minimum qualified to SNT-TC 1A NDT Level 2 standards. The welder's identification code will be uniquely marked on each coupon to ensure it's shown on x-ray film when used. Reports will be returned to Pit Instruction & Training, LLC along with the candidate's test coupons, at which point the Test Supervisor will fill out the necessary Welder Performance Qualification Records (WPQR), and keep a copy in each candidate's file. Baker Testing Services' procedures are qualified to meet the standards of the American Welding Society (AWS), American Society of Mechanical Engineers (ASME) and American National Standards Institute (ANSI). Contact Information:

Baker Testing Services, Inc.
136 Ostwalt Amity Road, Unit E
Troutman, NC 28166
704-528-5019
www.bakertesting.com

Testing Materials

7.2

Following submittal of an approved purchase order (EXHIBIT E) by the Facility Representative, Triangle Engineering, Inc. and Race City Steel are approved suppliers of testing materials. Triangle Engineering and Race City Steel provide test materials, mill test reports, conformance paperwork, and shipping forms for practice and testing that meet requirements in accordance with American Welding Society DX.X. Documentation/paperwork for each test specimen is kept on file for no less than five (5) years at PIT Instruction & Training following use of materials. Base metals are uniquely marked with assigned welder identification code. Supplier Contact Information:

Triangle Engineering, Inc.
6 Industrial Way
Hanover, MA 02339
781-878-1500
www.trieng.com

Race City Steel
4052 N. Hwy 16
Denver, NC 28037
704-489-2101
www.racecitysteel.com



SUPPLIES & PERSONAL PROTECTIVE EQUIPMENT NEEDED

Section 8.0

- Welding Jacket and/or fire retardant rated clothing
- Welding Helmet
- Welding Gloves
- Safety Glasses
- Ear Plugs
- Leather or Steel Toed Shoes or Boots
- Jeans or appropriate work pants (shorts and athletic apparel is not permitted)
- Sharpie and pencil
- Tape Measure

TEST RESULTS

Section 9.0

Pit Instruction and Training, LLC maintains a full record of all testing attempts for each individual. Only the individual's successfully completed test results will be mailed to the American Welding Society. However, all attempts will be reflected in the individual's file. Within two weeks (14 days) of successfully completing the test, Pit Instruction & Training, LLC will mail the test results to the American Welding Society to be processed. Individuals can expect to receive a certificate with their Certified Welder status from the American Welding Society within six (6) to eight (8) weeks following their testing date. Individuals are advised that they are solely responsible for maintaining the status of their certification per the American Welding Society standards and must submit a Maintenance of Welder Certification form – see "EXHIBIT H" – every six (6) months to do so.

EXCEPTIONAL CIRCUMSTANCES

Section 10.0

Non-Conformances

10.1

When a non-conformance in testing materials and/or equipment (welding equipment, coupons, backing plate, filler metals, base metals, etc.) is detected, the Test Supervisor is to immediately notify the Quality Assurance Manager of the issue. Following notification, a Non-Conformance Report is to be filled out, as found in "EXHIBIT C". Any materials that do not conform to standards as set forth as pertaining to AWS DX.X will be stored in a separate locked storage area until they can be returned to the supplier. All materials are checked upon receiving them as spelled out in QAM 6.0 and 7.2, and found in "EXHIBIT D".

Technical Complaints

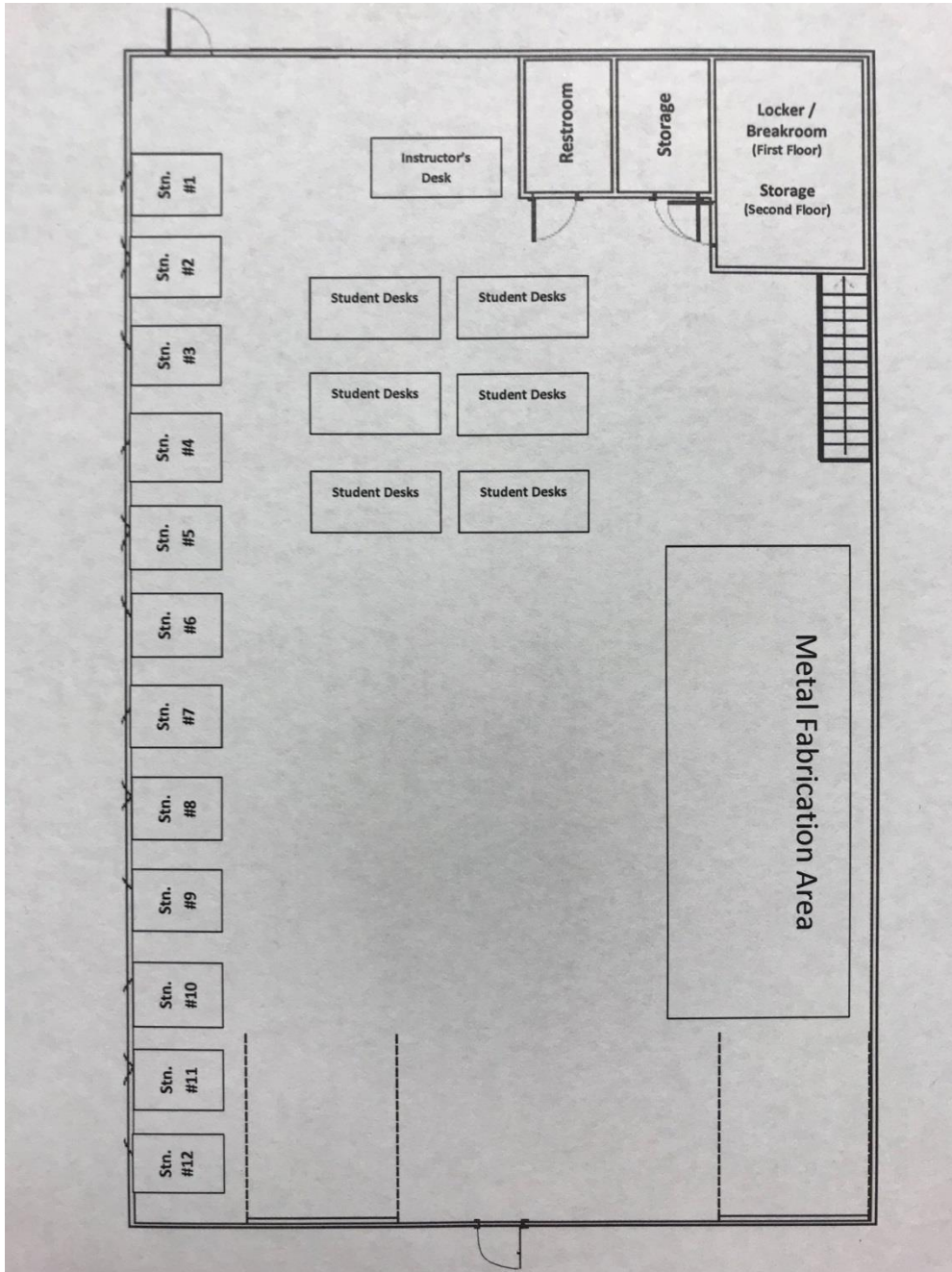
10.2

Those with concerns and/or suggestions related to equipment, testing procedures and/or non-conformances may express them by contacting the Director of Welding School Operations at Pit Instruction and Training, LLC. Concerns will be handled on a case-by-case basis and Pit Instruction and Training, LLC make an attempt, within reason, to rectify any such concerns should they arise to ensure proper customer satisfaction. When necessary, a Non-Conformance Report will be filled out as noted in QAM 11.2, and found in "EXHIBIT C".

Cancellations

10.3

Individuals will be notified of testing cancellation by 7:30am on the day of the scheduled test. Test dates shall be rescheduled within a 30 day window from the date of the originally scheduled test.



Welding Shop (above): Main entrance is the door on the bottom near the center of the image; rear entrance is located at the top left of the building. Twelve welding booths are located on the left side of the building, with storage room, restroom and desk/instructor space at the top. Fabrication and cutting equipment located at the right side of the image, with additional material storage in loft at top of stairs.



APPENDIX

Section 12.0

All documents utilized in accordance with the American Welding Society (AWS) that are referenced in the Quality Assurance manual, as well as part of the Certified Welder program are Pit Instruction & Training, LLC's standards and requirements are listed below.

Document	Title
ANSI Z49.1	Safety in Welding & Cutting
AWS B2.1/B2.1M	Performance Qualification Test Record (PQTR) – EXHIBIT F
AWS B2.1-1-004	SWPS for GMAW-S of Carbon Steel, 18 through 10 Gauge, in the As-Welded Condition, with or without Backing
AWS B5.4-05	Accredited Testing Facility Standards
AWS Certified Welder Application	EXHIBIT G
AWS D1.1/D1.1M	N-1 Welding Procedure Specification (WPS) Form
AWS D1.3/D1.3M	Structural Steel Welding Code – Sheet Steel
AWS Maintenance of Welder Certification Form	EXHIBIT H
AWS QC1	Standard for AWS Certification of Welding Inspectors
AWS QC4	Standard for Accreditation of Test Facilities for AWS Certified Welder Program
AWS QC7	Standard for AWS Certified Welders
PIT CW Testing Materials Checklist	Certified Welder Program Testing Materials Checklist for Quality Control Procedures – EXHIBIT D
PIT CWT Registration Form	PIT CWT Registration Form
PIT CWT Registration Form SAMPLE	PIT CWT Registration Form SAMPLE
PIT Bend Testing Checklist	EXHIBIT B
PIT Non-Conformance Report	EXHIBIT C
PIT Visual Examination Form	EXHIBIT I
PIT Welder Procedural Steps Checklist	EXHIBIT A
PIT Welder Calibration Records	PIT Instruction & Training Welder Calibration
Sample Purchase Order	EXHIBIT E
Quality Assurance Manual	PIT Quality Assurance Manual v1.5
QWS QC7 Supplement G	AWS Performance Qualification Test



FORMS

Section 13.0

EXHIBIT A

Welder Test Procedural Steps

Date: _____ Test Candidate: _____
 Welder ID Code: _____ Test Supervisor: _____
 Qualification Code: _____ WPS: _____
 Photo ID Verified: _____ Booth #: _____

<u>Test Supervisor</u>	<u>Candidate</u>		<u>Test Supervisor</u>	<u>Candidate</u>	
_____	_____	Filler Metal Specs	_____	_____	Verify & Mark Specimen to Ensure Fixed Position
_____	_____	Verify All Heat/Lot #s	_____	_____	Mark Tack Welds in Test Area
_____	_____	Base Metal Bevel Angle	_____	_____	Root Weld Inspection
_____	_____	Gas Cup Size	_____	_____	Inspect Cover Pass
_____	_____	Shielding Gas Composition	_____	_____	Test Specimen Marked w/Welder ID Code
_____	_____	Pre-Heat Temp	_____	_____	Remove Backing Plate
_____	_____	Verify Current Polarity	_____	_____	No Excessive Removal of Base Metal
_____	_____	Volt/Amp Range			
_____	_____	Verify Tack-up/Fit-Up			



EXHIBIT B

Bend Testing Checklist

Date: _____

Test Candidate: _____

Test Supervisor: _____

Welder ID Code: _____

Qualification Code: _____

WPS: _____

Side Bend: _____

Root/Face Bend: _____

Test Supervisor Initials

- _____ Test specimen uniquely marked with Welder ID Code
- _____ Test specimen bent through 180°
- _____ Bend axis coincident with weld axis
- _____ Root of weld is on the face of bend (if welded from one side only)
- _____ Complete Fusion
- _____ Acceptable weld profile
- _____ No porosity and/or slag
- _____ Weld Reinforcement (Filled Completely)
- _____ No visible cracks
- _____ Weld size equal to or greater than steel thickness
- _____ WPQR Completed
- _____ Test specimen disposed of



EXHIBIT C

Non-Conformance Report

Date: _____ Report Number: _____

Non-Conformance Reported By: _____

Type of Problem:

- Equipment
 - Welding Unit
 - Nozzle
 - Power Supply
- Materials
 - Test Specimens
 - Backing Plate
 - Wire
 - Gas
- Technical Complaint

Description of Non-Conformance: _____

Supporting Documentation/Pictures:

Attach to document or insert in space below (if any)

Circle One of the Options For Each Line Item Below:

Was Facility Representative Aware of Problem: Yes No

Time and Method of Notification: Phone Email Verbal Time: _____

Vendor Notified: Yes No If Yes, then Time: _____



EXHIBIT C (Continued)

Non-Conformance Report (Continued)

Corrective Action Required: _____

Additional Comments: _____

Corrective Actions Completed: Date: _____ Time: _____
Completed By: _____ Date: _____
Signature: _____

Corrective Actions Confirmed by Facility Representative: Yes No
Facility Representative Name: _____
Signature: _____ Date: _____



EXHIBIT D

Certified Welder Program Testing Materials Checklist

Date: _____

Employee: _____

Materials Received: _____

**Select all that apply*

- _____ P.O. Approved by Facility Rep.
- _____ Materials Match P.O.
- _____ Backing Plates Included
- _____ Test Coupons Included
- _____ Conformance Reports for Filler Metals
- _____ Test Reports for Base Metals
- _____ Reports kept with Materials
- _____ Material Reports kept on file
- _____ Stored in Designated Location
- _____ Designated Location Locked
- _____ Reviewed by Facility Rep.



EXHIBIT E

PURCHASE ORDER

PURCHASE FROM:
 Race City Steel
 4052 N Hwy 16
 Denver, NC 28037
 704-489-2101

SHIP TO:
Trent Schanen
 Pit Weld U
 133 Byers Creek Rd, Suite C
 Mooresville, NC 28117
 704-200-3257

P.O. NUMBER:
01162018
[The P.O. number must appear on all related correspondence, shipping papers, and invoices]

P.O DATE	REQUISITIONER	SHIPPED VIA	F.O.B. POINT	TERMS
1/16/2018				NET 30

QTY	UNIT	DESCRIPTION	UNIT PRICE	TOTAL
2	12' each	11ga x 4" flat bar cold rolled carbon steel	TBD	TBD
2	12' each	11ga x .75" flat bar cold rolled carbon steel	TBD	TBD

SUBTOTAL	
SALES TAX	6.75
SHIPPING AND HANDLING	
OTHER	
TOTAL	TBD

1. Please send two copies of material test reports including ASTM numbers, heat/lot numbers, classification, specifications, etc. per standards set forth in AWS A5.18. **REPORTS ARE REQUIRED TO ACCEPT DELIVERY OF MATERIALS.**
2. Please send two copies of your invoice.
3. Enter this order in accordance with the prices, terms, delivery method, and specifications listed above.
4. Please notify us immediately if you are unable to ship as specified.

Authorized by Facility Representative

1/16/2018



EXHIBIT F

	WELDER and WELDING OPERATOR PERFORMANCE QUALIFICATION RECORD
--	---

Welder's Name:	ATF No:	Test No.
Welder's SS No. XXX-XX-	Date:	Reference WPS No:

VARIABLE	QUALIFICATION TEST DETAIL	QUALIFICATION RANGE*
Code or Specification Used:		
Welding Process and Type:	<input type="checkbox"/> Manual <input type="checkbox"/> Semiautomatic <input type="checkbox"/> Mechanized <input type="checkbox"/> Automatic	<input type="checkbox"/> Manual <input type="checkbox"/> Semiautomatic <input type="checkbox"/> Mechanized <input type="checkbox"/> Automatic
Backing:	<input type="checkbox"/> Used <input type="checkbox"/> Not Used	<input type="checkbox"/> Required, <input type="checkbox"/> Not Required
Base Metal Spec/P or M-Number		
Plate/Pipe Thickness – Groove	Plate <input type="checkbox"/> Pipe <input type="checkbox"/> Thickness:	
Plate/Pipe Thickness – Fillet	Plate <input type="checkbox"/> Pipe <input type="checkbox"/> Thickness:	
Pipe/Tubular Outside Diameter – Groove		
Pipe/Tubular Outside Diameter – Fillet		
Filler Metal	Specification No	
	Classification No	
	F No	
	Diameter	
	Consumable Insert <input type="checkbox"/> Yes <input type="checkbox"/> No	
	Penetration Enhancing Flux <input type="checkbox"/> Yes <input type="checkbox"/> No	
Deposited Weld Metal Thickness		
Current/Polarity & Current Range	Type/Polarity: Volts: , Amps: , WFS:	
Metal Transfer Mode (GMAW or FCAW)		
Torch Shielding Gas	Type: Flow:	
Root Shielding Gas	<input type="checkbox"/> NA Type: Flow:	
Position(s)	Test Position(s) (1G, 2G, etc.):	Qualified Position(s) (F, H, V, O, or All):
Vertical Progression	<input type="checkbox"/> Uphill <input type="checkbox"/> Downhill	<input type="checkbox"/> Uphill <input type="checkbox"/> Downhill

* NOTE: Insert NA for Variables that are identified as Non-essential in the Code or Specification used for the Performance Qualification Test

MECHANICAL TEST RESULTS			
Type And Figure No.	Results	Type And Figure No.	Results

Guided Mechanical Testing Conducted By:	Date:
---	-------

NONDESTRUCTIVE EXAMINATION RESULTS

Radiographic Results:	Report No. -
-----------------------	----------------

Radiographic Testing Conducted By:	Visual Inspection: <input type="checkbox"/> Pass <input type="checkbox"/> Fail (reason)
------------------------------------	--

We certify that the statements in this record are correct and the test welds were prepared, welded and tested in accordance with the requirements of: AWS D1.1- , AWS B2.1-
 Other:

Date Qualified:	ATF Name and Number: Signed By:	CWI No.
-----------------	------------------------------------	---------



Performance Instruction & Training (PIT)
 156 Byers Creek Road
 Mooresville, NC 28117
 T (704) 799-3869 / F (704) 799-3871
 www.VisitPIT.com

EXHIBIT G



American Welding Society®
 8669 NW 36 St, # 130 Miami, FL 33166-6672
 (800) 443-9353 or (305) 443-9353, ext. 273

AWS Certified Welder Application
 \$50, Certification fee must accompany this form.
 (Prices are subject to change.)

Last Name										First Name										MI	
[Grid for name entry]																					

Welder card will be sent to the address indicated on this form. Make sure to indicate Apt./Suite # for the address indicated.

Check one: Home Address Business Address (indicate company name below)

[Grid for address type selection]																					
-----------------------------------	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--

Address

[Grid for address line 1]																					
---------------------------	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--

City and State / Province / Country

Zip Code

[Grid for city/state/zip]																					
---------------------------	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--

Home Telephone Number

Work Telephone Number

Mobile Telephone Number

[Home Phone Grid]						[Work Phone Grid]						[Mobile Phone Grid]					
-------------------	--	--	--	--	--	-------------------	--	--	--	--	--	---------------------	--	--	--	--	--

Email Address

U.S. Social Security Number (last 4 only)

[Email Address Grid]																[SSN Grid]			
----------------------	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	------------	--	--	--

Renewal notifications will be sent via email (3) months prior to the expiration of the welder certification. It is strongly recommended that a valid email address be indicated. (Note: If notification is not received, it remains the responsibility of the Certified Welder to renew on time.)

Upon obtaining my certification, I give AWS the right to reveal my certification status as it relates to its validity and the expiration date only. No other information related to my certification shall be revealed. Yes No. If Yes, please initial here _____

TEST INFORMATION (To be completed by Facility's Test Supervisor)

Accredited Test Facility: _____ Certificate#: _____

WPS: _____ Date Tested: ____ - ____ - ____

Indicate WPS as required by AWS B2.1. If Supplement G is used, indicate the WPS Number as assigned by the employer.

ex: mm/dd/yy

QUALIFICATIONS RANGE: Place the appropriate abbreviation in each category box

Supplement	Code	Process	Gas (optional)	Filler Metal	Base Metal	Position(s)	Thickness, Backing - or - Thickness, Pipe OD & Backing

REVIEWED: Facility Test Supervisor:

 Date Signature

Test Record must accompany this application. WPS will need to be submitted if it is the first time being used.

CWI Stamp (required)

Method of payment - Full payment must accompany this form. Checks and money orders made payable to AWS.

AWS USE ONLY

Check or money order # _____ VISA MC AMEX Discover CC#: _____ / _____ / _____ / _____ Exp: _____ / _____ CARD SECURITY CODE: _____ SIGNATURE: _____	Acct #: _____ Date: _____ Amt \$: _____
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American Welding Society®
 8669 NW 36 St, # 130 Miami, FL 33166-6672
 (800) 443-9353 or (305) 443-9353, ext. 273

EXHIBIT G (Continued) AWS CERTIFIED WELDER APPLICATION

INSTRUCTIONS FOR APPLICATION

There is a \$50 fee for **each** certification granted. For credit card information, fill out the box at the bottom of the application. Please fill out a separate application for each certification that the welder tested.

The welder is responsible for maintaining the certification. All certification materials will be sent to the welder's home address, unless specified to be sent to employer's address. **Remember to contact AWS if you change your address!**

Test Information (supplied by the Facility Test Supervisor): When using Supplement G, AWS must have a copy of the actual WPS on file. If you have previously submitted the WPS or are utilizing an AWS B2 SWPS, the AWS Certification Department has a record of this information. Any further tests using that same WPS can be referenced on the application. If this is the first time a WPS is being used, please submit a copy of that WPS and any supporting paperwork along with the application.

Under Qualifications, list the abbreviations that should appear on the welder certification card using the codes below. Note that some categories, such as Gas, may not apply in all situations (SMAW for example). Also, consider the "typical" essential variables of Welder Qualifications, such as position(s), up or down progression, thickness, outside diameter (OD, if pipe), and use or non-use of backing.

Authorization: If the welder wants the certification information to be released, for example, to people wishing to hire AWS Certified Welders, have the welder sign initials, where indicated on the application.

Review: After completing the application, the Facility Test Supervisor must sign the document, indicating his CWI certificate number and its expiration date. Signature by the ATF Supervisor attests to the completeness and accuracy of the record supplied.

GUIDE TO INTERPRETING ABBREVIATIONS ON AWS CERTIFIED WELDER CARD

Supplement	Code	Process	Gas (optional)	Filler Metal	Base Metal	Position(s)	Thickness, Backing - or - Thickness, Pipe OD & Backing
G	D1.1	GTAW FCAW	Ar 100% CO ₂	ER70S-2 E71T-1	A106B	4G 4G	L: 1/8-3/4": 4" OD: WB L: 1/8-3/4": 4" OD: WB

AWS SUPPLEMENTS

- C Sheet Metal Welding (AWS D9.1)
 - F Chemical Plant and Petroleum Piping (ASME B31.3 and Sec. IX)
 - G Generic Supplement (Company-furnished WPS and acceptance criteria) B2.1 SWPS
- CODES:** (For Supplement G only, reference appropriate acceptance criteria.)
- B2.1 AWS B2.1, Standard for Welding Procedure and Performance Qualification
 - D1.1 AWS D1.1, Structural Welding Code - Steel
 - D1.2 AWS D1.2, Structural Welding Code - Aluminum
 - D9.1 AWS D9.1, Sheet Metal Welding Code
 - ASME IX ASME Section IX, Qualification Standard for Welding and Brazing Procedures, Welders, Brazers, and Welding and Brazing Operators
 - D15.1 AWS D15.1, Railroad Welding Specification - Cars and Locomotives
 - API API 1104, Welding of Pipelines and Related Facilities
 - CUST Other customer may be used as indicated on the employer supplied WPS

*Other standards/codes may be used as indicated on the employer supplied – WPS

PROCESSES:

- SMAW Shielded Metal Arc Welding (SMAW)
- GMAW Gas Metal Arc Welding (GMAW)
- GMAW-S Gas Metal Arc Welding - Short Circuit
- FCAW Flux Cored Arc Welding (FCAW)
- GTAW Gas Tungsten Arc Welding (GTAW)
- SAW Submerged Arc Welding (SAW)
- BZ Brazing

GAS:

- AR Argon
- HE Helium
- Ar/CO₂Argon/CarbonDioxide
- CO₂ Carbon Dioxide
- Other - specify

FILLER METAL (AWS CLASSIFICATION NUMBER)

- ER309-L
- E7018-A1L
- ER70S-2

BASE METAL

- AXXX ASTM Designations (i.e., A36)
- M Material Numbers from B2
- SAXXX (SA106, SA105, SA304L, etc.)
- PX (P1, P8, P44, etc.)

POSITION

- 1G Groove Weld, Flat
- 2G Groove Weld, Horizontal
- 3G Groove Weld, Vertical
- 4G Groove Weld, Overhead
- 5G Groove Weld, (Pipe) Vertical
- 6G Groove Weld, (Pipe) 45° Vertical
- 6GR Groove Weld, (Pipe) 45 with Restriction Ring 1F
- Fillet Weld, Flat
- 2F Fillet Weld, Horizontal
- 3F Fillet Weld, Vertical
- 4F Fillet Weld, Overhead
- V Vertical Progression Up
- D Vertical Progression Down
- A All

THICKNESS

- U Unlimited (ex. 1/8" to Unlimited)
- L Limited (ex. 1/8-3/4")
- xx-xx Range in sheet gauges (ex. 11 - 18)
- x/x Thickness in fractions of an inch (ex. 3/8") SCH Schedule listing for pipe thickness (ex. Sch 40)
- WB With backing
- WOB Without backing
- OD Outside Diameter (pipe)



EXHIBIT I

Pit Instruction & Training, LLC Visual Examination Report

Report no.: VE-	Inspector:	Date:
Client:	Component / part no.:	Time:
Procedure no.:	Revision:	Page _____ of _____

Code/specification:	MATERIAL	SURFACE CONDITION	ITEM	
Light Source:	<input type="checkbox"/> Carbon Steel	<input type="checkbox"/> As Welded	<input type="checkbox"/> Pipe	<input type="checkbox"/> Weld
Light meter s/n:	<input type="checkbox"/> Stainless Steel	<input type="checkbox"/> As Cast	<input type="checkbox"/> Plate	<input type="checkbox"/> Root Pass
Light meter cal. Due date:	<input type="checkbox"/> Other	<input type="checkbox"/> Other	<input type="checkbox"/> Other	<input type="checkbox"/> Intermediate Pass No.
Light meter reading: _____ fc.				<input type="checkbox"/> Cover Pass

RESULTS			
Indication no.	Location / description	Accept	Reject
		<input type="checkbox"/>	<input type="checkbox"/>
		<input type="checkbox"/>	<input type="checkbox"/>
		<input type="checkbox"/>	<input type="checkbox"/>
		<input type="checkbox"/>	<input type="checkbox"/>
		<input type="checkbox"/>	<input type="checkbox"/>

Comments:

Insert Images / Sketch Here

Report no.:	Page _____ of _____
Technician Name/Signature	Reviewer, Level & Date



Performance Instruction & Training (PIT)
156 Byers Creek Road
 Mooresville, NC 28117
T (704) 799-3869 / F (704) 799-3871
www.VisitPIT.com

ACKNOWLEDGEMENT

SECTION 14.0

The information listed in this document is current and correct to the best of the company's (Pit Instruction & Training, LLC) efforts and knowledge. When changes requiring revisions to this document occur, revisions will be performed in a timely matter. As such, individuals taking part in welder qualification testing are bound by its contents upon completion and submission of their PIT Certified Welder Registration Form.