

**CERTIFICATIONS >> WELDER TEST PACKAGES**

**Take Note**

July 20, 2021: Added Fusion Operator Tests MD-1-MD-6

Test Qualification Ranges  
UA Weld Tests - Supporting Documents

 **Links**

[UA-NCPWB Joint  
Welder Testing  
Program Documents](#)

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Certification Tests						
All tests are in the 6G position unless indicated otherwise in the Special Notes column.						
Weld Test	Process	Pipe Coupon Size	Wall Thickness	Filler Metals	Special Notes	NCPWB-JPQT
MD-1	Plastic Fusion	2"	SDR 11	none		
MD-2	Plastic Fusion	3"	SDR 11	none		
MD-3	Plastic Fusion	2"	SDR 11	none		
MD-4	Plastic Fusion	4"	SDR 11	none		
MD-5	Plastic Fusion	6"	SDR 11	none		
MD-6	Plastic Fusion	2"	SDR 11	none		
PE-1	Plastic Fusion	2"	SDR 11	none		
PE-2	Plastic Fusion	4"	SDR 11	none		
PE-3	Plastic Fusion	6"	SDR 11	none		
PE-4	Plastic Fusion	8"	SDR 11	none		
PE-5	Plastic Fusion	12"	SDR 11	none		
PE-9	Plastic Fusion	6"	SDR 11	none	Section IX Fusion Test	
B-1	Plastic Bonding	4"	SDR 40	none		
B-2	Plastic Bonding	4"	SDR 80	none		
B-3	Plastic Bonding	4"	SDR 80	none		
SS-1	Solder	1 1/2" Tube		ASTM B32 Solder	Solder Test	
UA-1	SMAW	6" Sch. 40	.280"	E6010	Downhill Welding	JPQT 01
UA-2	SMAW	6" Sch. 40	.280"	E6010 / E7018	—	JPQT 02
UA-3A	GTAW & SMAW	6" XXS	.864"	ER80S-B6 / E8018-B6	5% Chrome Test	JPQT 3A
UA-5	GTAW & SMAW	6" Sch. 40	.280"	ER70S-2 / E7018	—	JPQT 05
UA-6	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018 / E309	—	JPQT 06
UA-8	SMAW	2" Sch. 80	.218"	E6010 / E7018	—	JPQT 08
UA-9T	GTAW & SMAW	6" XXS	.864"	ER70S-2 / E7018	—	JPQT 9T
UA-10	GTAW & SMAW	2" Sch. 80	.218"	ER70S-2 / E7018	—	JPQT 10
UA-11	GTAW & SMAW	6" Sch. 80	.432"	ER70S-2 / E7018	—	JPQT 11
UA-12	GMAW-S	6" XXS	.864"	ER70S-6	—	JPQT 12
UA-12W	GMAW-S	6" Sch. 80	.432"	ER70S-3 or 6	—	JPQT 12W

UA-13	GTAW	.500" O.D.	.065"	none	Manual Fusion	JPQT 13
UA-14	GTAW	2" Sch. 10	.109"	none	Manual Fusion	JPQT 14
UA-15	GTAW	2" Sch. 80	.218"	ER70S-2	—	JPQT 15
UA-16	GTAW	1/2" Sch. 80	.147"	ER70S-2	Very small diameter	JPQT 16
UA-17	GMAW & FCAW	6" XXS	.864"	ER70S-6 / E71-T1	—	JPQT 17
UA-17W	GMAW & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	—	JPQT 17W
UA-18	SMAW	2" Sch. 160	.344"	E7018	—	
UA-18A	GTAW	0.750" O.D.	.065"	none	Automatic Orbital Welding	JPQT 18A
UA-19	SMAW	2" Sch. 160	.344"	E6010 / E7018	—	JPQT 19
UA-19A	GTAW	0.750" O.D.	.065"	none	Automatic Orbital Welding	
UA-20	FCAW	6" Sch. 80	.432"	E71-T1	Using Backing Ring	
UA-21	SMAW	2" XXS	.436"	E6010 / E7018	—	JPQT 21
UA-22	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018	—	JPQT 22
UA-23	SMAW	6" XXS	.864"	E6010 / E7018	—	JPQT 23
UA-24	SMAW	6" Sch. 120	.562"	E6010 / E7018	—	JPQT 24
UA-25	GTAW	2" XXS	.436"	ER70S-2	—	JPQT 25
UA-26	GTAW & SMAW	2" Sch. 160	.344"	ER70S-2 or 3 / E7018	—	
UA-27	GMAW	6" Sch. 80	.432"	ER70S-6	Root-down / Balance-up	JPQT 27
UA-28	SMAW	6" Sch. 80	.432"	E6010 / E7018	—	JPQT 28
UA-29	SMAW	6" Sch. 80	.432"	E6010 / E7018	Restricted Access Test	
UA-30	GMAW & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	IG Rolled Test	JPQT 30
UA-31B	GTAW	6" Sch. 40	.280"	ER5356	Aluminum Test - chill ring	JPQT 31B
UA-31J	GTAW	6" Sch. 40	.280"	ER5356	Aluminum Test - J Bevel	JPQT 31J
UA-32	SMAW	6" Sch. 80	.432"	E6010	—	
UA-33	GTAW	2" Sch. 40	.154"	ER NiCrMo-10	Nickel Alloy Test	JPQT 33
UA-34	GTAW	2" Sch. 10	.109"	ER NiCrMo-10	Nickel Alloy Test	
UA-35	GTAW	2" Sch. 80	.218"	ER NiCrMo-10	Nickel Alloy Test	JPQT 35
UA-36	GMAW & FCAW	2 3/4" O.D.	.625"	ER70S-6 / E71-T1		JPQT 36
UA-37	GTAW	6" Sch. 120	.562"	ER70S-6	Machine Welding	JPQT 37
UA-38	GTAW	2" Sch. 5	.065"	none	Manual Fusion	JPQT 38
UA-39	GMAW	6" Sch. 80	.432"	ER308Si	IG Rolled Test	JPQT 39
UA-41	GTAW	2" Sch. 80	.218"	ER309	Stainless Test	JPQT 41
UA-42	GTAW & SMAW	2" XXS	.436"	ER309 / E309-16	Stainless Test	JPQT 42
UA-43	GTAW & SMAW	6" XXS	.864"	ER309 / E309-16	Stainless Test	JPQT 43
UA-44	GTAW	10" Sch. 100	.719"	ER309	Narrow Groove Test	
UA-45	GTAW	2" Sch. 10	.109"	ER308	Stainless Test	JPQT 45
UA-46	SMAW	2" Sch. 160	.344"	E309-17 or 16	Stainless Test	JPQT 46
UA-47	GTAW	6" Sch. 80	.432"	ER70S-6	Machine Welding	JPQT 47
UA-48	GTAW	10" Sch. 100	.719"	ER309	Remote Video control	
UA-49	GTAW	6" Sch. 80	.432"	ER70S-2 & ER70S-6	Manual & Machine Welding	
UA-50	Brazing	3/4" Tube	.045"	BCuP 2 thru 7	Manual Torch Brazing	JPQT 50
UA-51	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Manual Torch Brazing	JPQT 51
UA-52	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Brazer Qual Renewal Test	JPQT 52
UA-60	SMAW	2 3/4" O.D.	.625"	E6010 / E7018		JPQT 60
UA-61	GTAW & SMAW	2 3/4" O.D.	.625"	ER309 / E309-16	Stainless Test	JPQT 61
UA-62	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E309-16		JPQT 62

<a href="#">UA-63</a>	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E7018		JPQT 63
<a href="#">UA-64</a>	SMAW	2 3/4" O.D.	.625"	E7018		
<a href="#">UA-66</a>	GTAW	2 3/4" O.D.	.625"	ER NiCr-3	Nickel Alloy Test	JPQT 66
<a href="#">UA-67</a>	GTAW	2 3/4" O.D.	.625"	ER70S-2		JPQT 67
<a href="#">UA-68</a>	SMAW	2 3/4" O.D.	.625"	E6010 / E7018	Root-down / Balance-up	
<a href="#">UA-69</a>	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E7018		JPQT 69
<a href="#">UA-70</a>	SMAW	2" pipe & 3/16" plate	.154"	E7018	Structural Steel Fillet Weld Test	JPQT 70
<a href="#">UA-71</a>	GMAW	6" Sch. 80	.432"	ER70S-3 or 6	Short Arc Root / Spray or Pulse Fill	JPQT 71
<a href="#">UA-72</a>	GMAW	6" Sch. 80	.432"	ER70S-2 or 3	IG Rolled Test	JPQT 72
<a href="#">UA-73</a>	SMAW	6" Sch. 80	.432"	E6010 / E7018	Flip Flop Test (2G & 5G)	JPQT 73
<a href="#">UA-74</a>	GTAW	6" Sch. 10	.134"	ER308L or ER316L	Stainless Orbital Machine Welding	
<a href="#">UA-75</a>	GTAW	6" Sch. 10	.134"	ER308L or ER316L	Stainless Orbital Machine Welding	
<a href="#">UA-76</a>	SMAW	2" XXS	.436"	E6010 / E7018	Two Coupons (2G & 5G)	JPQT 76
<a href="#">UA-77</a>	GTAW & SMAW	10" Sch. 160	1.125"	ER70S-2 / E7018	Local responsible for coupon costs	
<a href="#">UA-78</a>	GTAW & SMAW	2 3/4" O.D.	.625"	ERNiCr-3 / ENiCr-3	Nickel Alloy Test	JPQT 78
<a href="#">UA-79</a>	GMAW	6" Sch. 80	.432"	ER70S-3 or 6	90% Argon / 10% CO2	JPQT 79
<a href="#">UA-80</a>	GTAW	6" Sch. 80	.432"	ER70S-6 or ER309	"Tip-Tig" Hot Wire Process	JPQT 80
<a href="#">UA-81</a>	SMAW	2" XXS	.436"	E7010-A1 / E7018-A1	—	JPQT 81
<a href="#">UA-85</a>	GMAW	2 3/4" O.D.	.625"	ER70S-6	90% Argon / 10% CO2	
<a href="#">UA-86</a>	GTAW & FCAW	6" Sch. 80	.432"	ER70S-2 or E71T-1	IG Rolled Test	JPQT 86
<a href="#">UA-87</a>	SMAW	6" Sch. 40	.280"	E6010 / E7018	Two Coupons (2G & 5G)	
<a href="#">UA-91</a>	GTAW & SMAW	2" XXS	.436"	ER90S-B9 / E9018-B9	9% Chrome Test	JPQT 91
<a href="#">UA-92</a>	GTAW	2" Sch. 40	.154"	ERTi-2	Local responsible for coupon costs	JPQT 92
<a href="#">UA-93</a>	GTAW	4" Sch. 5	.083"	none	Manual Fusion	JPQT 93
<a href="#">UA-94</a>	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E7018	Restricted Access Test	JPQT 94
<a href="#">UA-95</a>	GTAW & SMAW	2 3/4" O.D.	.625"	ER90S-B9 / E9018-B9	9% Chrome Test	
<a href="#">UA-99</a>	SMAW	6" Sch. 80	.432"	E6010 / E7018	Two Coupons (2G & 5G)	JPQT 99
<a href="#">UA-100</a>	SMAW	4" Sch. 80	.337"	E6010 / E7018	2G Only Test	JPQT 100
<a href="#">UA-101</a>	GMAW & FCAW	6" XXS	.864"	ER70S-6 / E71T-1	Flip-Flop Test (2G & 5G)	JPQT 101
<a href="#">UA-102</a>	GMAW & FCAW	8" Sch. 40	.322"	ER308LSi / E308LT1	Flip-Flop Test (2G & 5G)	JPQT 102
<a href="#">UA-103</a>	GMAW & FCAW	6" Sch. 80	.432"	ER70S-6 / E71T-1	Two Coupons (2G & 5G)	

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