

WELD QUALITY ASSURANCE CENTER A.S.M.E. / A.W.S. QUALIFICATION RANGE CHART

	W.P.Q. #	DIAMETER OF PIPE	GROOVE THICKNESS	MATERIAL TYPE	PROCESS	POSITION	PROGRESSION	FILLER METAL (F-NO)	DEPOSIT THICKNESS
A S M E	GT-01-01	1.0" and Over	Up To .436" Max	P1-P8 W/Gas, P8-P8 W/Gas, P1-P1 W/O gas	G.T.A.W.	All Positions	Upward	F-6	Same As Groove
	GT-01-01C	.840" and Over	Up To .294" Max	P1-P8 W/Gas, P8-P8 W/Gas, P1-P1 W/O gas	G.T.A.W.	All Positions	Upward	F-6	Same As Groove
	GT-08-08b	2.875" and Over	Up To 1.0" Max	P8-P8 W/Gas	G.T.A.W.	All Positions	Upward	F-6	Same As Groove
	GTSM-08-08	2.875" and Over	Up To 1.0" Max	P8-P8 W/Gas	G.T.A.W. and S.M.A.W.	All Positions	Upward	F-6 F-5	Up To .250" Max Up To .750" Max
	GTSM-01-01	2.875" and Over	Up To .864" Max	P1-P1 WO/Gas	G.T.A.W. and S.M.A.W.	All Positions	Upward	F-4 F-6	Up To .614" Max Up To .250" Max
	GT-617-617	2.875" and Over	Up To 1.75" Max	Inc.617-Inc.617 W/Gas	G.T.A.W.	All Positions	Upward	F-43	Same As Groove
	GT-800HTc	1.0" and Over	Up To .834" Max	Inc.P45-Inc.P45 W/Gas	G.T.A.W.	All Positions	Upward	F-43	Same As Groove
	SM-01-01	2.875" and Over	Up To .864" Max	P1-P1	S.M.A.W.	All Positions	Upward	F-3 F-4	Up To .250" Max Up To .614" Max
	SM-01-01B	1" and Over	Up To .436" Max	P1-P1	S.M.A.W.	All Positions	Upward	F-3 F-4	Up To .188" Max Up To .248" Max
	TB-88-88	Overlap Length Up To 1.125"	.025" To .10"	B88-B88	Torch Braze	All Positions	Face Feed	F-102	N/A
STAY-SILV-15	Overlap Length Up To 1.125"	.025" To .10"	B88-B88	Torch Braze	All Positions	Face Feed	F-103	N/A	
A W S	GE001	Over 24" W/Backing or Backgouging	.125" To Unlimited	Group #1	S.M.A.W.	All Positions	Upward	F-4	Same As Groove
	GE002 & GE005	Over 24" W/Backing or Backgouging	.125" To .75" (Groove) .125" To Unlimited (Fillet)	Group #1	F.C.A.W.	All Positions	Upward	N/A	Same As Groove
	GE003 & GE004	Over 24" W/Backing or Backgouging	.125" To .75" (Groove) .125" To Unlimited (Fillet)	Group #1	G.M.A.W.	All Positions	Upward Downward	N/A	Same As Groove
	GT-23-23	Over 24"W/Backing	.125" To .5" (Groove) Unlimited (Fillet)	M23-M23	G.T.A.W.	Flat Horizontal Vertical	Upward	F-22	Same As Groove

P1=Carbon P8=Stainless Steel Inc.=Inconel B88=Copper M23=Aluminum