

UTAH NATIONAL CERTIFIED PIPE WELDING BUREAU
CONTRACTOR WITNESS CHECKLIST



DURING THE TEST - WELDING & BRAZING

- Verify the identity of the welder/brazer using a picture I.D. and other documentation the welder/brazer has been provided by the UA for taking the test.
- Verify that the welder/brazer has a copy of the Welding/Brazing Procedures Specification (WPS)/(BPS) that the welder/brazer will follow during the welding/brazing of the test coupon.
- Verify that the test coupon is identified with the welder's/brazer's name or stamp and that the top of the coupon is marked to identify same when welding/brazing is done in a position that does not allow for the rotation of the coupon.
- Ensure that the test coupon is not moved from its present position.
- Verify that the electrode or filler metal type to be used for the root and fill passes are correct and are used in proper sequence.
- Verify that the welding/brazing progression/position is in the correct direction (uphill or downhill/flat, horizontal or vertical).
- Verify that the amperage is within ranges specified by the WPS.
- Verify approximate thickness of the weld metal deposited with each process or electrode type when more than one process or electrode type is used.
- Verify the joint design and fit up for welds and the overlap for brazed joints.
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- Verify proper backing gas and flow if required.
- Verify that the correct filler metal and, when required, the correct flux is used.

AFTER THE TEST - WELDING

After the welder has finished welding the test coupon, the contractor and the UA Authorized Testing Representative (ATR) shall visually examine the test coupon for the following:

- Cracks (*None permitted*)
- Porosity (*None permitted*)
- Reinforcement (*minimum flush to 1/8 maximum*)
- Incomplete penetration of the root, or evidence of grinding of the root side of the weld when the weld has been made from one side without backing. (*None permitted*)
- Incomplete Fusion (*None permitted*)
- Undercut (*Not to exceed 1/32*)
- Slag (*None permitted*)

AFTER THE TEST - BRAZING

After the brazer has finished brazing the test coupon, the contractor and the UA Authorized Testing Representative (ATR) shall visually examine the test coupon for the following:

- Presence of filler metal all around the joint at the interface between the socket and the pipe (*incomplete fill is not permitted*).
- The inside surface shall be free of oxidation (*none permitted - this applies to MedGas qualifications only*).

TEST COUPONS THAT PASS THE VISUAL INSPECTION SHOULD BE INITIALED AND DATED BY THE CONTRACTOR AND THE ATR. THE CONTRACTOR AND ATR SHOULD ALSO SIGN THE TEST RECORD.