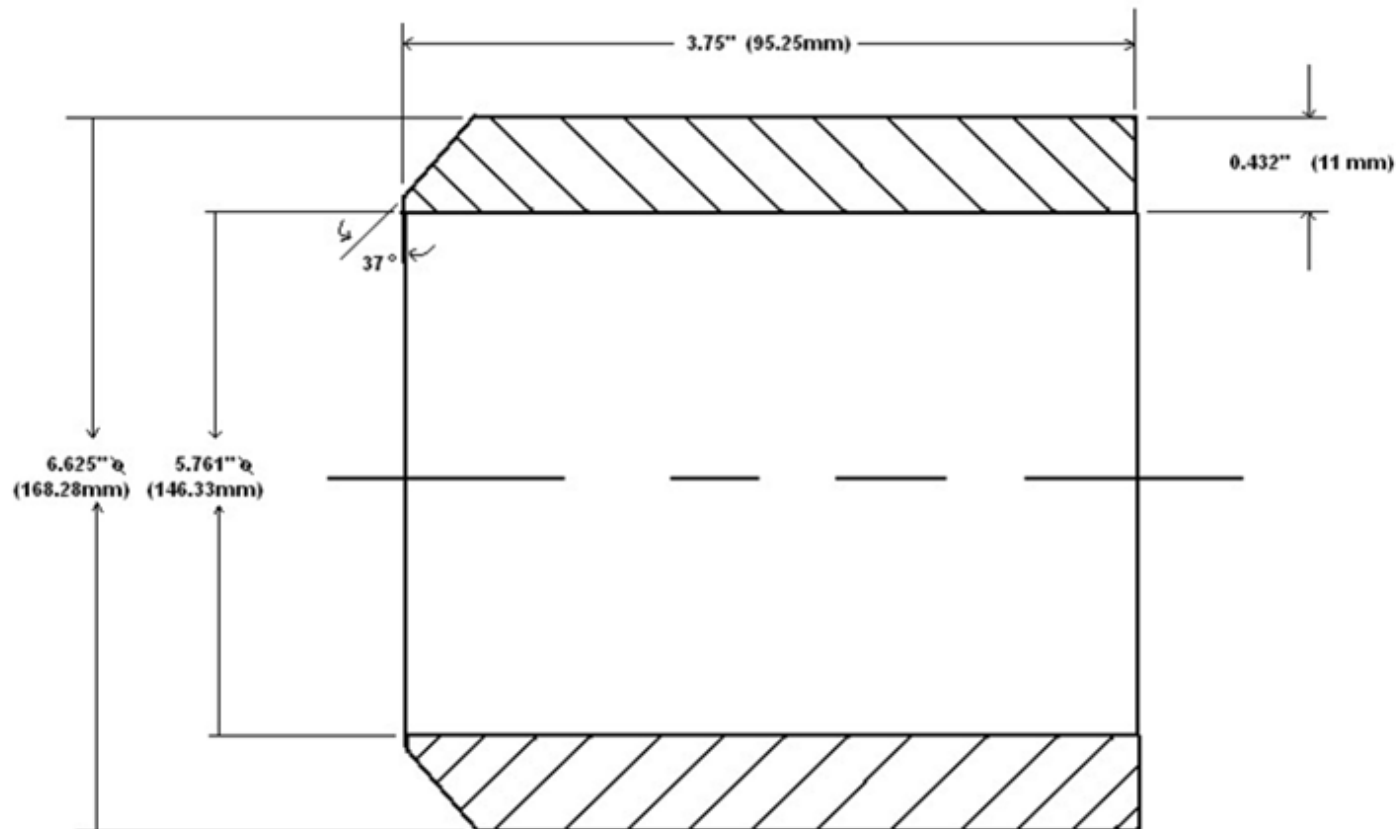


NOTES:

1. If you are bringing your own test coupon, please be sure to have a copy of the Material/Mill Test Report/Record (MTR) available for review by the inspector for material verification and traceability. (SA 106 Gr. B is recommended)
2. Instructions for tacking your coupon and stamping with the proper markings for the test will be given by the inspector at the weld test centre. See also IP-2008-04-002; Information paper on 'Initial Pressure Welder's Qualification Test'
3. The test will be SMAW process, F3 (6010 electrode) open root, F4 (7018 electrode) fill and cap, performed in the 2G (1/3 of pipe circumference) & 5G (2/3 pipe circumference) positions.
4. If you do not pass the initial qualification test on your first attempt, you must wait 30 days before testing again.
5. Acceptance of the test will be in accordance with ASME Sec. IX and test samples pieces will be selected by the inspector and will be destructively tested by the inspector using the bending jig.

DWG NO: NPS6-WC



Material (as per ASME B36.10M)

NPS-6 SCHD 80(XS) SA-106-B Pipe
(P1 Material)

Special Process/ HT Treat

None



**Technical
Safety Authority
of Saskatchewan**

Title: 6" Pipe (NPS-6)
Weld Coupon Specifications

DWN: J.WRIGHT	DATE: May 26, 2020
CHKD: T. Deaussy	DATE: December 16, 2020
APPD: R. Campbell	DATE: December 16, 2020
PAGE: 1 OF 1	REV: 2
PART No:	NPS-6 COUPON