



Br. C.A.T INTERANTIONAL CO. LIMITED

**QATIF SITE WELDERS CONTINUITY MEMO FOR THE MONTH OF
(July - 2019)**

ASME SEC-IX

S.NO	WELDER SYMBOL	PROCESS	UPDATED ON	DUE DATE	NO.OF DAYS LEFT
1	966	GMAW	22-Jan-19	23-Jul-19	✓ 55
2	966	SMAW	22-Jan-19	23-Jul-19	✓ 55
3	1391	GMAW	23-Jan-19	24-Jul-19	✓ 56
4	1520	SMAW	20-Jan-19	21-Jul-19	✓ 53
5	1366	GMAW	10-Jan-19	11-Jul-19	✓ 43
6	1366	SMAW	10-Jan-19	11-Jul-19	✓ 43

Vetco Saudi Arabia Co. Ltd.

WELDER/WELDING OPERATOR QUALIFICATION TEST RECORD

Test No. WQT-2280/17/P
Date: 28-Sep-17

Name: SHOKAT KHAN JAHAN ALI Identification No.: 966
 Iqama / Passport No.: 2248751675 Joint Type: Single V Groove
 Identification of WPS Followed: CAT-WPS-211-1, Rev-0 Weld Type: Bull Weld
 Specification of Base Metal(s) API 5L Gr. X60 Mat'l Size: ø8" NPS X 10.31mm WT.



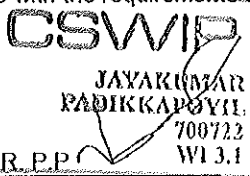
Testing Variables and Qualification Limits

Welding Variables	Actual Values	Range Qualified
Welding Process(es)	GMAW-STT / SMAW	GMAW-STT / SMAW
Type (ie: Manual, Semi-Auto, Automatic)	SEMI-AUTO / MANUAL	SEMI-AUTO / MANUAL
Backing (with / without)	GMAW-STT: Without	GMAW-STT: With/Without
Backing (with / without)	SMAW: With	SMAW: With Only
Test Specimen (Plate / Pipe)	PIPE / 8" DIA	2 1/2" OD & Over
Base Metal (P Number to P Number)	P1 Grp.2 to P1 Grp.2	P1-P15F, P34 & P41-P49
Filler Metal or Electrode Specification (SFA)	A5.18 / A5.1	-
Filler Metal or Electrode AWS Classification	ER 70S-3 / E 7018	-
Filler Metal F Number (s)	F6 / F4	ALL F6 / F1 to F4
Electrode / Filler Dia / Brand Name <u>GMAW-STT</u>	<u>ø1.1mm - SUPER ARC L-50</u>	-
Electrode / Filler Dia / Brand Name <u>SMAW</u>	<u>ø3.2mm - SUPERCITO E7018</u>	-
Deposit Thickness of <u>GMAW-STT</u> Process	3.0 mm	GMAW-STT: 3.3mm Maximum
Deposit Thickness of <u>SMAW</u> Process	7.31 mm	SMAW: 14.62mm Maximum
Position	6G	ALL
Welding Progression	DOWNHILL / UPHILL	DOWNHILL / UPHILL
Inert Gas backing (GTAW / PAW / GMAW)	N/A	N/A
Current / Polarity (AC / DCEP / DCEN)	DCEP / DCEP	DCEP / DCEP
Transfer Mode (Spray / Globular or Pulse or Short Circuit - GMAW)	N/A	N/A
Filler Metal (if not covered by AWS)	N/A	N/A

Test Conducted	Test Details (type, report no. etc)	Results
Visual Inspection (X)	Site Record: <u>WQT-2280/17/P</u>	Satisfactory
Radiography ()	N/A	-
Bend ()	N/A	-
Fillet Fracture ()	N/A	-
Macro Examination ()	N/A	-
Other Tests (UT) (X)	UT 011017-006	Accepted

We, the undersigned certify that the statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with the requirements of ASME IX 2015 Edition.

For Vetco Saudi Arabia Co.Ltd

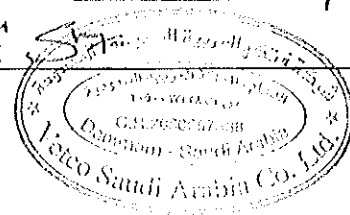


Test Witnessed /
Welding Inspector JAYAKUMAR, P.P

Contractor Br. C.A.T. Int'l Co.Ltd.

Contractor's Rep
Name & Sign KEITH BALDAM

Vendor Inspection Manager's Name & Signature THOMAS VARGHESE



Vetco Saudi Arabia Co. Ltd.

WELDER/WELDING OPERATOR QUALIFICATION TEST RECORD

Test No. WQT-2280/17/P
Date: 28-Sep-17

Name: SHOKAT KHAN JAHAN ALI Identification No.: 966
Iqama / Passport No.: 2248751675 Joint Type: Single V Groove
Identification of WPS Followed: CAT-WPS-211-1, Rev-0 Weld Type: Butt Weld
Specification of Base Metal(s) API 5L Gr. X60 Mat'l Size: ø8" NPS X 10.31mm WT.



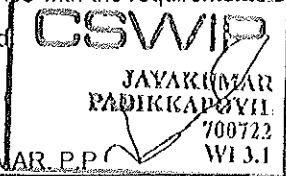
Testing Variables and Qualification Limits

Welding Variables	Actual Values	Range Qualified
Welding Process(es)	GMAW-STT / SMAW	GMAW-STT / SMAW
Type (ie: Manual, Semi-Auto, Automatic)	SEMI-AUTO / MANUAL	SEMI-AUTO / MANUAL
Backing (with / without)	GMAW-STT: Without	GMAW-STT: With/Without
Backing (with / without)	SMAW: With	SMAW: With Only
Test Specimen (Plate / Pipe)	PIPE/ 8" DIA	2 1/2" OD & Over
Base Metal (P Number to P Number)	P1 Grp.2 to P1 Grp.2	P1-P15F, P34 & P41-P49
Filler Metal or Electrode Specification (SFA)	A5.18 / A5.1	-
Filler Metal or Electrode AWS Classification	ER 70S-3 / E 7018	-
Filler Metal F Number (s)	F6 / F4	ALL F6 / F1 to F4
Electrode / Filler Dia / Brand Name <u>GMAW-STT</u>	ø1.1mm - SUPER ARC L-50	-
Electrode / Filler Dia / Brand Name <u>SMAW</u>	ø3.2mm - SUPERCITO E7018	-
Deposit Thickness of <u>GMAW-STT</u> Process	3.0 mm	GMAW-STT: 3.3mm Maximum
Deposit Thickness of <u>SMAW</u> Process	7.31 mm	SMAW: 14.62mm Maximum
Position	6G	ALL
Welding Progression	DOWNHILL / UPHILL	DOWNHILL / UPHILL
Inert Gas backing (GTAW / PAW / GMAW)	N/A	N/A
Current / Polarity (AC / DCEP / DCEN)	DCEP / DCEP	DCEP / DCEP
Transfer Mode (Spray / Globular or Pulse or Short Circuit - GMAW)	N/A	N/A
Filler Metal (if not covered by AWS)	N/A	N/A

Test Conducted	Test Details (type, report no. etc)	Results
Visual Inspection (X)	Site Record: <u>WQT-2280/17/P</u>	Satisfactory
Radiography ()	N/A	-
Bend ()	N/A	-
Fillet Fracture ()	N/A	-
Macro Examination ()	N/A	-
Other Tests (UT) (X)	UT 011017-006	Accepted

We, the undersigned certify that the statements in this record are correct and that the test coupons were prepared, welded and tested in accordance with the requirements of ASME IX 2015 Edition.

For Vetco Saudi Arabia Co.Ltd

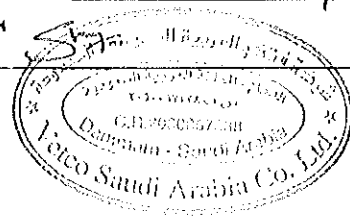


Test Witnessed /
Welding Inspector JAYAKUMAR P.P

Contractor Br. C.A.T. Int'l Co.Ltd.

Contractor's Rep
Name & Sign KEITH BALDAM

Vendor Inspection Manager's Name & Signature THOMAS VARGHESE



WELDER PERFORMANCE QUALIFICATION TEST RECORD

Welder's Name : MUHAMMAD REHMAN Identification No. : 1391
 WPS No : WPS -121 Rev. 2 Test Coupon : 8" Pipe
 Material specification : API 5L X60 Thickness : 12.70mm
 Date of Inspection : 28-MAR-2017



Variables	Actual values	Range.Qualified
Welding Process & Type	GMAW (S.T.T)- Semi Auto & SMAW - Manual	GMAW (S.T.T)- Semi Auto & SMAW Manual
Backing (with /without)	GMAW : Without Backing SMAW : With Backing	GMAW : With/Without Backing SMAW : With Backing
Type of Weld	Single 'V' Groove	Groove & Fillet
Product Type (Plate or Pipe)	Pipe	Pipe and Plate
Diameter	8 inch	2-7/8"OD & Over
Base Metal P Number	P. No. 1	P. No.1 through P. No.15F, P.No34 and P.No.41 through P.No.49
Filler Metal or Electrode specification	GMAW : A 5.18 SMAW : A 5.5	---
Filler Metal or Electrode Classification	GMAW : ER 70S-3 SMAW : E 7010-P1	---
Filler Metal F- Number	GMAW :F. No.6 (Without Backing) SMAW :F. No.3 (With Backing)	All F. No.6 F.No. 3,2&1(With Backing)
Consumable Insert(GTAW or PAW)	N/A	N/A
Filler Metal Product Form	Solid	Solid
Deposited Thickness for each process	GMAW: 2.50 mm(Root) SMAW: 10.20 mm(H,F & C)	GMAW: 2.75 mm (Max) SMAW: 20.40 mm (Max)
Welding Position and Progression	5G Down	F, V(DN) & OH
Type of Fuel gas (OFW)	N/A	N/A
Inert Gas Backing	N/A	N/A
Current type /Polarity	GMAW & SMAW - DCEP	GMAW & SMAW - DCEP
Transfer Mode (GMAW)	S.T.T	S.T.T

Type of Qualification Tests	Performed and Accepted	Not Tested	Test No: CAT-1057-17-084 REPORT NO: i) 29191 ii) A5845
Visual Examination	Acceptable		
Radiographic Examination	Acceptable		
UT Examination		✓	
Bend Test (Root / Face /Side)	Acceptable	✓	
Fracture Test		✓	
Macroscopic Examination		✓	
Other Test		✓	

We certify that the statements in this record are correct and that the test coupons were prepared welded and tested in accordance with the requirements of section IX of the ASME Boiler and pressure vessel code 2015 Edition.

Witnessing Inspector: **VISHAL K. JAISWAL**
 TCR Arabia Co Ltd
 Print Name & Signature

Contractor: **SUNIL ANTONY J.**
 Br. C.A.T International Co. Ltd.
 Print Name & Signature

The Results related to the sample tested and shall not be reproduced except in full without the written approval of laboratory
 QCP/TCR/WPO/1.0.REV.1

Page 1 of 2

82961

WELDER / WELDING OPERATOR QUALIFICATION TEST RECORD



FSL Job. No. 18-72-748
 Welder Name: Muhammad Shahid Imran Muhammad Sharif Date: 10 January 2019
 Stamp No. (Symbol): 1366 Passport No.: N/A
 Using WPS No.: CAT-WPS-211-1 Rev.0 Type: Semi-Auto + Manual Iqama No.: 2391691231
 Welding Process: GMAW + SMAW Backing: None Nationality: Pakistani
 Base Material: API 5L Gr. X60 Thickness: 0.625" Client/Contractor Br. C.A.T. International Co Ltd.

VARIABLES	RECORD ACTUAL VALUES	Range Qualified
	Used in Qualification	
Welding Process:	<u>GMAW + SMAW</u>	<u>GMAW + SMAW</u>
Base Metal:		
Specification	<u>API 5L Gr. X60 to API 5L Gr. X60</u>	<u>P1 thru P15F, P34 & P41 thru P49 to Same</u>
Classification Number	<u>P1 to P1</u>	<u>P1 thru P15F, P34 & P41 thru P49 to Same</u>
Joint:		
Type of Joint (Butt, lap etc.)	<u>Butt</u>	<u>All</u>
Type of Weld (Groove, Fillet)	<u>Single "V" Groove</u>	<u>Groove & Fillet</u>
Pipe or Plate	<u>Pipe</u>	<u>Pipe & Plate</u>
Consumable Inserts	<u>None</u>	<u>None</u>
Backing	<u>None</u>	<u>With or Without backing</u>
Pipe Diameter	<u>10" Ø</u>	<u>2 7/8" O.D. & Over</u>
Filler Metal:		
Specification	<u>SFA 5.18 & SFA 5.1</u>	<u>SFA 5.18 & SFA 5.1</u>
Classification	<u>ER70S-3 & E7018</u>	<u>All F6 & F4 Classification</u>
F-number	<u>F6 & F4</u>	<u>F6, F1 thru F4 with backing</u>
Deposited Weld Thickness	<u>GMAW - 0.118"</u>	<u>Up to 0.130" thickness</u>
Deposited Weld Thickness	<u>SMAW - 0.507"</u>	<u>Maximum to be welded</u>
Welding Parameters:		
Position	<u>6G</u>	<u>All</u>
Welding Progression:	<u>Root (Downhill); Hot, Fill & Cap (Uphill)</u>	<u>Root (Downhill); Hot, Fill & Cap (Uphill)</u>
Gas Backing	<u>N/A</u>	<u>N/A</u>
Current / Polarity (Root)	<u>DCEP</u>	<u>DCEP</u>
Current / Polarity (Hot/Fill/Cap)	<u>DCEP</u>	<u>DCEP</u>

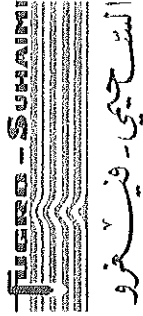
Tests Conducted	Describe (Number, Type, etc.)	Results
Visual Inspection <input checked="" type="checkbox"/>	<u>_____</u>	<u>Satisfactory</u>
Tensile & Bend Test <input type="checkbox"/>	<u>_____</u>	<u>_____</u>
Hardness Test <input type="checkbox"/>	<u>_____</u>	<u>_____</u>
Charpy Impact <input type="checkbox"/>	<u>_____</u>	<u>_____</u>
Ultrasonic inspection <input checked="" type="checkbox"/>	<u>FSL - UT - 023 - 2019</u>	<u>Satisfactory</u>
Other <input type="checkbox"/>	<u>_____</u>	<u>_____</u>

"We certify that the information in this record is correct and that the test coupons were prepared, welded, and Tested in accordance with the requirements of ASME BPVC.IX-2017"

Date: 14 January 2019
 Signed: [Signature]
 FSL Welding Inspector
 Print Name: Carlito Bayron
NOT WI FORM 03 (98) Rev. 04

Date: 14/Jan/2019
 Signed: [Signature]
 Contractor
 Print Name: Muhammad Sharif

ULTRASONIC INSPECTION REPORT



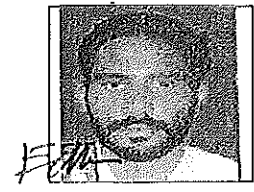
Location: Dammam
 NDT: UT Report No. FSL-JT-023-2019
 Lab. Page 1 of 1
 Field Dwg. No. SA18-72-748 Purchase Order 13 January 2019 Date

Contract		Br. CAT International Co.		Project		Division		Drawing		Assy / Subassy		Reference	
Item		Material Type		Thickness		Description:		Procedure No.		ASME Sec. IX 2017 Ed.			
Manufacturer of Equip.		Carbon Steel		10" Dia. X 0.625"				FSL/QC/NDT/UT Issue 2 Rev. 0					
Manufacturer of Equip.		Krautkramer		Serial No.		00HDYC		Manufacturer of Probe		GB		Size	
Calibration Standard		USN-52R		Couplant		ULTRAGEL		Joint Type		Butt Joint <input checked="" type="checkbox"/>		T Joint <input type="checkbox"/>	
Weld I.D. No.		Defect No.		DEFECT		Type		DIVISION		Accept		Reject	
WPS No. CAT-WPS-211-1 Rev. 0				Length		Depth		% Reference Level + or					
GMAW + SMAW								80% FSH DAC@ 2.4 mm SDH					
(Downhill / Uphill) 6G								STRAIGHT BEAM @ 55dB &					
WS: 1366								Angle beam @ 56dB					
XXXXXX								REFERENCE LEVEL				No Relevant Indication	
								+ 6 dBSCANNING LEVEL				No Relevant Indication	
								RANGE:					
								0°-0-50mm					
								60°, 70° = 0 -100mm					

FSL Inspector Jonathan E. Reyes
 ASNT Level II
FUGRO-SUHAIMI LTD.

82961

WELDER / WELDING OPERATOR QUALIFICATION TEST RECORD



FSL Job No. 18-72-748
 Welder Name: Muhammad Shahid Imran Muhammad Sharif Date: 10 January 2019
 Stamp No. (Symbol): 1366 Passport No.: N/A
 Using WPS No.: CAT-WPS-211-1 Rev.0 Type: Semi-Auto + Manual Iqama No.: 2391691231
 Welding Process: GMAW + SMAW Backing: None Nationality: Pakistani
 Base Material: API 5L Gr. X60 Thickness: 0.625" Client/Contractor Br. C.A.T. International Co Ltd.

VARIABLES	RECORD ACTUAL VALUES	Range Qualified
	Used in Qualification	
Welding Process:	<u>GMAW + SMAW</u>	<u>GMAW + SMAW</u>
Base Metal:		
Specification	<u>API 5L Gr. X60 to API 5L Gr. X60</u>	<u>P1 thru P15F, P34 & P41 thru P49 to Same</u>
Classification Number	<u>P1 to P1</u>	<u>P1 thru P15F, P34 & P41 thru P49 to Same</u>
Joint:		
Type of Joint (Butt, lap etc.)	<u>Butt</u>	<u>All</u>
Type of Weld (Groove, Fillet)	<u>Single "V" Groove</u>	<u>Groove & Fillet</u>
Pipe or Plate	<u>Pipe</u>	<u>Pipe & Plate</u>
Consumable Inserts	<u>None</u>	<u>None</u>
Backing	<u>None</u>	<u>With or Without backing</u>
Pipe Diameter	<u>10" Ø</u>	<u>2 7/8" O.D. & Over</u>
Filler Metal:		
Specification	<u>SFA 5.18 & SFA 5.1</u>	<u>SFA 5.18 & SFA 5.1</u>
Classification	<u>ER70S-3 & E7018</u>	<u>All F6 & F4 Classification</u>
F-number	<u>F6 & F4</u>	<u>F6, F1 thru F4 with backing</u>
Deposited Weld Thickness	<u>GMAW - 0.118"</u>	<u>Up to 0.130" thickness</u>
Deposited Weld Thickness	<u>SMAW - 0.507"</u>	<u>Maximum to be welded</u>
Welding Parameters:		
Position	<u>6G</u>	<u>All</u>
Welding Progression:	<u>Root (Downhill); Hot, Fill & Cap (Uphill)</u>	<u>Root (Downhill); Hot, Fill & Cap (Uphill)</u>
Gas Backing	<u>N/A</u>	<u>N/A</u>
Current / Polarity (Root)	<u>DCEP</u>	<u>DCEP</u>
Current / Polarity (Hot/Fill/Cap)	<u>DCEP</u>	<u>DCEP</u>

Tests Conducted	Describe (Number, Type, etc.)	Results
Visual Inspection	<input checked="" type="checkbox"/> _____	<u>Satisfactory</u>
Tensile & Bend Test	<input type="checkbox"/> _____	_____
Hardness Test	<input type="checkbox"/> _____	_____
Charpy Impact	<input type="checkbox"/> _____	_____
Ultrasonic Inspection	<input checked="" type="checkbox"/> <u>FSL - UT - 023 - 2019</u>	<u>Satisfactory</u>
Other	<input type="checkbox"/> _____	_____

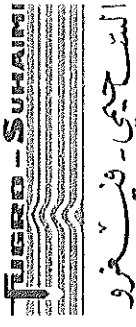
"We certify that the information in this record is correct and that the test coupons were prepared, welded, and Tested in accordance with the requirements of ASME BPVC.IX-2017"

Date 14 January 2019
 Signed: [Signature]
 Print Name: Carlito Bayron
NDT WI FORM 03 (98) Rev. 04

Date 14 Jan 2019
 Signed: [Signature]
 Print Name: Contractor

ULTRASONIC INSPECTION REPORT

Location: Dammam
 NDT: UT
 Report No.: FSL-JT-023-2019
 Page: 1 of 1
 Job No.: SA18-72-748
 Purchases Order: _____
 Date: 13 January 2019
 Dwg. No.: _____
 Lab.
 Field



Contract	Br. CAT International Co.	Project	Division	Drawing	Assy / Subassy	Reference ASME Sec. IX 2017 Ed.
Item	Material Type Carbon Steel	Thickness 10" Dia. X 0.625"	Description:	Procedure No. FSL/QC/NDT/UT Issue 2 Rev. 0		
Manufacturer of Equip.	Model Krautkramer	Serial No. USN-52R	Manufacturer of Probe GB	Size 10 mmφ / 8 x 9 mm	Angle 0°, 60°, 70°	MHz 5 / 4 MHz
Calibration Standard	Couplant ULTRAGEL	Joint Type		Butt Joint <input checked="" type="checkbox"/>	T Joint <input type="checkbox"/>	Corner Joint <input type="checkbox"/>
Weld I.D. No.	Defect No.	DEFECT		REMARKS		
WPS No. CAT-WPS-211-1 Rev. 0		Length	Depth	Type	% Reference Level + or	Accept
GMAW + SMAW					80% FSH DAC@ 2.4 mm SDH	Reject
(Downhill / Uphill) 6G					STRAIGHT BEAM @ 56dB &	
WS: 1366					Angle beam @ 56dB	✓
XXXXXX					REFERENCE LEVEL	✓
					+ 6 dBSCANNING LEVEL	No Relevant Indication
					RANGE:	No Relevant Indication
					0°=0-50mm	
					60°, 70° = 0 -100mm	

FSL Inspector: Jonathan E. Reyes
 ASNT Level: II
FUGRO-SUHAIMI LTD.
 INSPECTION DEPT.

81304

WELDER / WELDING OPERATOR QUALIFICATION TEST RECORD



FSL Job. No. 18-72-748
 Welder Name: Nguyen Hoang Hiep Date: 21 July 2018
 Stamp No. (Symbol): 1520 Passport No.: B9312210
 Using WPS No.: CAT-WPS-108-IT Rev. 1 Type: Manual Iqama No.: N/A
 Welding Process: GTAW + SMAW Backing: None Nationality: Vietnamese
 Base Material: API 5L Gr. X60 Thickness: 0.625" Client/Contractor Br. C.A.T. International Co Ltd.

VARIABLES	RECORD ACTUAL VALUES		Range Qualified
	Used in Qualification		
Welding Process:	GTAW + SMAW		GTAW + SMAW
Base Metal:			
Specification	API 5L Gr. X60 to API 5L Gr. X60		P1 thru P15F, P34 & P41 thru P49 to Same
Classification Number	P1 to P1		P1 thru P15F, P34 & P41 thru P49 to Same
Joint:			
Type of Joint (Butt, lap etc.)	Butt		All
Type of Weld (Groove, Fillet)	Single "V" Groove		Groove & Fillet
Pipe or Plate	Pipe		Pipe & Plate
Consumable Inserts	None		None
Backing	None		With or Without backing
Pipe Diameter	10" Ø		2 7/8" O.D. & Over
Filler Metal:			
Specification	SFA 5.18 & SFA 5.1		SFA 5.18 & SFA 5.1
Classification	ER70S-2 & E7018		All F6 & F4 Classification
F-number	F6 & F4		F6, F1 thru F4 with backing
Deposited Weld Thickness	GTAW - 0.118"		Up to 0.236" thickness
Deposited Weld Thickness	SMAW - 0.507"		Maximum to be welded
Welding Parameters:			
Position	6G		All
Welding Progression:	Uphill		Uphill
Gas Backing	N/A		N/A
Current / Polarity (Root/Hot)	DCEN		DCEN
Current / Polarity (Fill/Cap)	DCEP		DCEP

Tests Conducted	Describe (Number, Type, etc.)	Results
Visual Inspection	[X]	Satisfactory
Tensile & Bend Test	[]	
Hardness Test	[]	
Charpy Impact	[]	
Radiography	[X] FSL - RT - 2918 - 2018	Satisfactory
Other	[]	

"We certify that the information in this record is correct and that the test coupons were prepared, welded, and Tested in accordance with the requirements of ASME BPVC.IX-2017 "

Date 23 July 2018
 Signed: NDT/WSS
 FSL Welding Inspector
Carlito Bayron
 NDT WI FORM 03 (98) Rev. 04

Date 30 July 2018
 Signed: [Signature]
 Contractor
G. N. S. Mustafa