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INSPENET – INDUSTRIAL INSPECTION & CERTIFICATION

Technical Document – Welding Quality Control
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WELDER QUALIFICATION CHECKLIST

In accordance with ASME Section IX – Article III
(Qualification of Welders and Welding Operators)



SME IX COMPLIANCE – CERTIFIED INSPECTION

Open technical use document. Prepared by Inspenet AI for educational and quality-control purposes. Based on ASME Section IX – Article III: Welder Qualification.

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Guide for Equipment Inspectors and Technical Auditors

Assessment and traceability of certified welders in accordance with the requirements of the ASME Boiler & Pressure Vessel Code, Section IX.

WELDER QUALIFICATION CHECKLIST – ASME SECTION IX (ARTICLE III)

COMPANY:

PROJECT:

INSPECTOR:

DATE:

CODE / STANDARD: ASME SECTION IX **WELDING PROCESS:**
– ARTICLE III

1. Welder General Information

- ☐ Full name of welder
- ☐ ID or internal registration number
- ☐ Position or job category
- ☐ Qualification date
- ☐ Responsible company or contractor

2. Procedure Verification (WPS – Welding Procedure Specification)

- ☐ WPS used is supported by a valid PQR
- ☐ Welding process matches (SMAW, GTAW, etc.)
- ☐ WPS number and current revision confirmed
- ☐ Essential, non-essential and supplementary variables identified
- ☐ Base metal and filler metal match qualified ranges (P-Numbers)
- ☐ Base metal thickness and deposited weld thickness within qualified range
- ☐ Welding position matches WPS (1G, 2G, 5G, 6G, etc.)
- ☐ Preheat and PWHT documented properly
- ☐ Consumables and batch/lot number recorded



3. Practical Welding Execution

- ☐ Correct application of WPS during testing
- ☐ Stable body positioning and proper welding technique
- ☐ Proper fusion, penetration and uniform bead appearance
- ☐ Cleaning between passes and interpass temperature control
- ☐ No interruptions or visual defects
- ☐ Proper environmental conditions (no wind, excessive humidity)
- ☐ Correct PPE usage and compliance with safety standards

4. Visual Inspection of Test Coupon

- ☐ Coupon properly identified with traceability
- ☐ No cracks, undercut, porosity or lack of fusion
- ☐ Coupon dimensions within thickness and diameter range
- ☐ Surface finish complies with ASME QW-191 criteria
- ☐ Photographic record attached (optional)

5. Mechanical and Non-Destructive Testing

- ☐ Destructive tests conducted (bend, tensile, macro-etch)
- ☐ NDT performed per procedure (RT, UT, PT, MT)
- ☐ Results within acceptance criteria
- ☐ Reports signed by qualified lab or inspector
- ☐ Documentation archived with corresponding WPS and WPQ

6. Qualification Record Verification (WPQ – Welder Performance Qualification Record)

- ☐ Contains all welder information
- ☐ Signed by authorized inspector and company representative
- ☐ Essential variables clearly listed
- ☐ Test results documented



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- ☐ Qualification

scope (position, thickness, material type) properly defined

- ☐ Document archived and traceable in internal records

7. Validity & Re-Qualification

- ☐ Welding continuity without interruption > 6 months
- ☐ Re-qualification current if applicable
- ☐ Welding activities recorded in logbook
- ☐ Does not exceed qualified range limits
- ☐ Next verification or re-qualification scheduled

8. Inspector Conclusions

- ☐ Meets all ASME IX requirements
- ☐ Approved for welder certification
- ☐ Non-conformant (re-testing or training required)
- **Comments:** _____

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- **Inspector Signature:** _____ **Date:** _____

- **Seal or Certification:** _____
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