

UA Welder Certification Tests

All tests are in the **6G** position unless indicated otherwise in the Special Notes column.

Weld Test	Process	Pipe Coupon Size	Wall Thickness	Filler Metals	Special Notes
UA-R1	GTAW	2" Sch. 80	.218"	ER309	Requalification Test
UA-R2	SMAW	6" Sch. 80	.432"	E6010 / E7018	Requalification Test
UA-R3	GTAW	2" Sch. 80	.218"	ER70S-6	Requalification Test
UA-1	SMAW	6" Sch. 40	.280"	E6010	Downhill Welding
UA-2	SMAW	6" Sch. 40	.280"	E6010 / E7018	—
UA-6	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018 / E309	—
UA-8	SMAW	2" Sch. 80	.218"	E6010 / E7018	—
UA-10	GTAW & SMAW	2" Sch. 80	.218"	ER70S-2 / E7018	—
UA-12W	GMAW-S	6" Sch. 80	.432"	ER70S-3 or 6	GMAW-Short Circuiting Mode
UA-15	GTAW	2" Sch. 80	.218"	ER70S-2	—
UA-17W	GMAW-S & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	—
UA-18A	GTAW	0.750" O.D.	.065"	none	Automatic Orbital Welding
UA-20	FCAW	6" Sch. 80	.432"	E71-T1	Using Backing Ring
UA-21	SMAW	2" XXS	.436"	E6010 / E7018	—
UA-22	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018	—
UA-25	GTAW	2" XXS	.436"	ER70S-2	—
UA-27	GMAW-S	6" Sch. 80	.432"	ER70S-6	Root-down / Balance-up
UA-28	SMAW	6" Sch. 80	.432"	E6010 / E7018	—
UA-30	GMAW-S & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	IG Rolled Test
UA-33	GTAW	2" Sch. 40	.154"	ER NiCrMo-10	Nickel Alloy Test
UA-34	GTAW	2" Sch. 10	.109"	ER NiCrMo-10	Nickel Alloy Test
UA-35	GTAW	2" Sch. 80	.218"	ER NiCrMo-10	Nickel Alloy Wire / SA-106 Coupon
UA-36	GMAW-S & FCAW	2 3/4" O.D.	.625"	ER70S-6 / E71-T1	Super Coupon Test
UA-39	GMAW-S & GMAW-P	6" Sch. 80	.432"	ER308Si	IG Rolled Test
UA-42	GTAW & SMAW	2" XXS	.436"	ER309 / E309-16	Stainless Test
UA-45	GTAW	2" Sch. 10	.109"	ER308	Stainless Test
UA-50	Brazing	3/4" Tube	.045"	BCuP 2 thru 7	Manual Torch Brazing
UA-51	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Manual Torch Brazing
UA-52	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Brazer Qual Renewal Test
UA-60	SMAW	2 3/4" O.D.	.625"	E6010 / E7018	Super Coupon Test
UA-61	GTAW & SMAW	2 3/4" O.D.	.625"	ER309 / E309-16	Stainless Test
UA-62	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E309-16	Super Coupon Test
UA-63	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E7018	Super Coupon Test
UA-66	GTAW	2 3/4" O.D.	.625"	ER NiCr-3	Nickel Alloy Wire / SA-106 Coupon
UA-67	GTAW	2 3/4" O.D.	.625"	ER70S-2	Super Coupon Test
UA-68	SMAW	2 3/4" O.D.	.625"	E6010 / E7018	Root-down / Balance-up
UA-70	SMAW	2" pipe & 3/16" plate	.154"	E7018	Structural Steel Fillet Weld Test
UA-71	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-3 or 6	Short Arc Root / Spray or Pulse Fill
UA-72	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-2 or 3	IG Rolled Test
UA-73	SMAW	6" Sch. 80	.432"	E6010 / E7018	Flip Flop Test (2G & 5G)
UA-76	SMAW	2" XXS	.436"	E6010 / E7018	Two Coupons (2G & 5G)
UA-78	GTAW & SMAW	2 3/4" O.D.	.625"	ERNiCr-3 / ENiCr-3	Nickel Chrome Super Coupon Test
UA-79	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-3 or 6	Mixed Gas - 90% Argon / 10% CO2
UA-85	GMAW-S & GMAW	2 3/4" O.D.	.625"	ER70S-6	Mixed Gas - 90% Argon / 10% CO2
UA-93	GTAW	4" Sch. 5	.083"	none	Manual Fusion