

How to Qualify for All Thicknesses with One Coupon

If you need to qualify your welders for all thicknesses and for ASME Section IX, then the **SUPER COUPON®** will allow you to do so with just one coupon size. Table QW-452.1(b) of Section IX allows the use of a coupon of 1/2 inch or over to qualify up to the maximum thickness to be welded.

SA-106-B SUPER COUPON®

For pipe qualification, there is a lower limit on the diameter that is qualified by a given pipe size. Any pipe over 2-7/8" outside diameter only qualifies down to 2-7/8" OD minimum. This is the equivalent of a 2-1/2" nominal pipe size. The nominal dimensions of 2-1/2" Sch. XXS pipe meets the above requirements. Unfortunately, the SA-106B pipe specification allows the actual wall thickness to be undersize by down to 0.483 wall. The typical pipe coupon needs to be bored to give a consistent land. This is not possible unless you check each pipe to see if the wall is close to 0.552" thick before being bored.

So, to qualify for small diameter and all thicknesses, you have to use a 2" pipe for the small diameter and a 6" pipe for the thickness; unless you use the **SUPER COUPON®**, that is!



2XXS Coupon vs. a **SUPER COUPON®**

We have a special pipe size made in mill quantities that meets both the diameter and the thickness limitations mentioned above. This pipe is 2-3/4" OD and has a 5/8" wall thickness. The material is SA-106, Grade B. Don't try to find it on a pipe chart, because it's not there. It is only used for the purpose of qualifying welders to Section IX.

We have several **SUPER COUPON®** options made from this material. They have a 37½° bevel with a 1/16" land, or a knife edge if desired. A couple of examples are shown here and described below.



T01-2341L is 4" long and has a bevel with a land on one end only.

T01-2342 is 4" long and has a bevel with a knife edge on both ends.

SA-36 SUPER Plate Coupons

If you don't need to qualify for pipe, our SUPER plate coupons offer similar advantages. According to ASME QW-452.1(b), a 1/2 inch thick coupon qualifies a welder for all thicknesses, subject to position limitations.

The standard size we offer is as follows:

T01-5047 is SA-36 material, 1/2" thick x 4" wide x 7" long with a 37½° bevel on both long sides.

Qualifies for Stainless and Nickel Alloys Also!

Paragraph QW-423.1 allows for SA-106-B and SA-36 material, which are both in group P-No. 1, to qualify the welder for all materials in groups P-No. 1-15F, 34 and 41-49, as limited by F-No. according to QW-433.

Using a **SUPER COUPON®** can Reduce Welder Qualification Costs by Over 67%!

For current pricing on these and other coupons, visit our website at www.fischerengr.com