

WPQR No.:
120050

**WELDING PROCEDURE QUALIFICATION RECORD
(WPQR)**

according to EN ISO 15614-1:2004



Welding Procedure Qualification – Test Certificate

Manufacturer's WPQR No.: 120050
Manufacturer: LASERTECH S.A.
Address: 43rd km of Old National Road Elefsina-Thiva, 322 00 THIVA
Code / Testing Standard: EN ISO 15614-1:2004
Date of Welding: 04.06.2012
Examiner or examining body: TÜV AUSTRIA HELLAS
Reference No.: 120050

Range of Qualification

Welding Process(es): EN ISO 4063-131
Type of Joint and Weld: Fillet Welds (FW)
Parent Material Group(s) and Subgroups(s): 1.2 with equal or lower specified yield strength (acc. CR ISO 15608)- S355 (acc. EN 10025-2)
Parent Material Thickness (mm): $\geq 5,00$
Weld Metal Thickness (mm): N/A
Throat Thickness (mm): No restriction
Single run / Multi run: Multi run
Pipe Outside Diameter (mm): N/A
Filler Material Designation: G3Si1 / EN ISO 14341-A (ER70S-6 / AWS A5.18) and others with equivalent characteristics

Filler Material Make:

All Manufacturers

Filler Material Size:

All sizes allowed provided that heat input requirements are fulfilled
M21 (EN 439)

Designation of Shielding Gas / Flux:

Designation of Backing Gas:

N/A

Type of Welding Current and Polarity:

DC (-)

Mode of Metal Transfer:

Spray

Heat Input:

$0,55 \div 1,39$ (kJ/mm)

Welding Positions:

All positions except for PG and J-L045

Preheat Temperature:

Ambient Temperature

Interpass Temperature:

Max. 250 °C

Post-Heating:

N/A

Post-Weld Heat Treatment:

N/A

Other Information:

%

Certified that test welds prepared welded and tested satisfactorily in accordance with the requirements of the code / testing standard indicated above.

Athens

Location

13.06.2012

Date of issue

