

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)
Welding procedure qualification – Test Certificate

Manufacturer's WPQR No:	09/2009	Examiner or examining body:	DNV
Manufacturer:	Cermar sp. z o.o.	Reference No:	None
Address:	Cukrowa 10H 71-004 Szczecin		
Code/Testing Standard	PN-EN ISO 15614-1:2005 DNV-OS-C401		
Date of Welding	27.07.2009		

Range of qualification	
Welding process	135/136
Type of joint and weld:	BW Plate
Parent material group(s) and sub group(s):	3.2
Parent material thickness:	12 mm
Weld metal thickness:	12 mm
Throat thickness [mm]:	None
Single run/Multi run:	135-Multi run / 136 Multi run
Outside pipe diameter [mm]:	None
Filler material designation:	135 - EN 440: G463M G4Si1 136 - EN ISO 18276-A: T694Mn2NiMoMM2H10
Filler material make:	OK AUTROD 12.64 - ESAB OK. TUBROD 14.03 - ESAB
Filler material size:	φ1,2 mm / φ1,2 mm
Designation of shielding gas/Flux:	EN 439: (M21 ; 80%Ar+20%CO ₂ -135,136)
Designation of backing gas:	None
Type of welding current and polarity:	135 DC / + ; 136 DC / -
Mode of metal transfer:	Globular / Spray transfer
Heat input:	0,33-1,22 [kJ/mm]
Welding position:	PF ; PC
Preheat temperature:	100°C
Interpass temperature:	150°C
Post-Heating:	None
Post-Weld-Heat-Treatmens:	None
Other information	None

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

Szczecin

10.09.2009

Location

Date of issue

W. Wymiatal
GŁÓWNY SPAWALNIK
WELDING ENGINEER
www.cermar.com.pl

K. Lutyński
DNV

Examiner or examining body
Name, date and signature

K. Lutyński

