

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

Welding procedure qualification – Test Certificate

Manufacturer's WPQR No:	12/2009	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	07-08-2009		

Range of qualification	
Welding process	136
Type of joint and weld:	BW Plate
Parent material group(s) and sub group(s):	WELDOX 900E gr.3.2 + X4CrNiMo16-5-1 gr. 7.2
Parent material thickness:	19 mm
Weld metal thickness:	19 mm
Throat thickness [mm]:	None
Single run/Multi run:	Multi run
Outside pipe diameter [mm]:	None
Filler material designation:	EN ISO 17633: T2293NLRM/C3
Filler material make:	AVESTA FCW-2D 2205
Filler material size:	φ1,2 mm
Designation of shielding gas/Flux:	EN 439: (M21 ; 80%Ar+20%CO ₂ -136)
Designation of backing gas:	None
Type of welding current and polarity:	DC / +
Mode of metal transfer:	Spray transfer
Heat input:	0,61-1,09 [kJ/mm]
Welding position:	PA
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

[Signature]

DNV

Examiner or examining body
Name, date and signature



[Signature]
GŁÓWNY SPAWALNIK
WELDING ENGINEER
mgr inż. Wiesław Wymiałat
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Valid with the re-test
WPQR „ 12-2009 - complement ”
11-03-2010