

PN-EN ISO 15614-1:2005; DNV-OS-C401

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

Manufacturer's WPQR No:	03/2010	Examiner or examining body:	DNV
Manufacturer:	Cermar sp. z o.o.	Reference No:	None
Address:	Sienna 5a 70-542 Szczecin		
Code/Testing Standard	PN-EN ISO 15614-1:2005 DNV-OS-C401		
Date of Welding	26.05.2010		

Range of qualification	
Welding process	136
Type of joint and weld:	BW Pipe
Parent material group(s) and sub group(s):	X6CrNiMoTi17-12-2; (316Ti ; 1.4571) / 8.1
Parent material thickness:	6,3 mm
Weld metal thickness:	6,3mm
Throat thickness [mm]:	None
Single run/Multi run:	Multi run
Outside pipe diameter [mm]:	ø76,1
Filler material designation:	ISO 17633: T 19 12 3 L P C/M 2
Filler material make:	LINCOLN / COR-A-ROSTA P-316L
Filler material size:	φ1,2 mm
Designation of shielding gas/Flux:	EN 439: C1 / 100% CO ₂
Designation of backing gas:	None
Type of welding current and polarity:	DC / +
Mode of metal transfer:	Short-Circuit
Heat input:	0,95-1,05 [kJ/mm]
Welding position:	H-L045
Preheat temperature:	None
Interpass temperature:	150°C
Post-Heating:	None
Post-Weld-Heat-Treatments:	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

01.07.2010

Location

Date of issue


GŁÓWNY SPAWALNIK
WELDING ENGINEER
mgr inż. Wiesław Wymiatel
www.cermar.com.pl

DNV
Examiner or examining body
Name, date and signature

MICHAŁ ZGLICZYŃSKI
SURVEYOR



2010 -07-01