

Welding Procedure Qualification Record form (WPQR)

Welding procedure qualification – Test Certificate

Manufacturer's WPQR No. :	MIR / WPQR / 3296-19	Examiner or examining body reference No. :	MIRTEC S.A. MIR / WPQR / 3296-19
Manufacturer :	ΥΙΟΙ. Α. ΜΙΖΑΗΛΙΔΗ ΟΕ		
Address :	PERIVOLAKI LAGADA, THESSALONIKI		
Code / Testing Standard :	ELOT EN ISO 15614.01 (2004+A1 2008+A2 2012)		
Date of Welding :	18.03.2019		

Range of qualification

Welding Process(es) :	135:MAG
Type of joint and weld :	FILLET WELD PLATE ON PLATE AND FILLET WELD TUBE ON TUBE
Parent material group(s) and sub group(s) :	GROUP 1 TO GROUP 1 (COVERS THE EQUAL OR LOWER SPECIFIED YIELD STRENGTH STEEL OF THE SAME GROUP)
Parent Material Thickness (mm) :	FW : $3,0 \leq t \leq 8,0$
Weld Metal Thickness (mm) :	--
Throat Thickness (mm) :	No restriction
Single run / Multi run :	Single run
Outside Pipe Diameter (mm) :	
Filler Material Designation :	EN ISO14341-A: G3 Si 1 Filler materials with equivalent mechanical properties, same type of covering core or flux, same nominal composition, same or lower hydrogen content according to the appropriate European standard for the filler material concerned
Filler Material Make :	SIDER WELD (It is permissible to change the specific make of filler material to another with the same compulsory part of the designation when an additional test piece is welded)
Filler Material Size :	Φ1,0mm. It is permitted to change the size providing that the requirements of 8.4.8 are satisfied
Designation of Shielding Gas :	ISO 14175:82% Ar- 18%CO ₂ LINDE CORGON18, M21 ACTIVE GASES (The qualification given to the shielding gas is restricted to the symbol of the gas according to ISO14175. However, the content of CO ₂ shall not exceed 10 % of that used to qualify the procedure test. Shielding gases not covered by ISO14175 are restricted to the nominal composition used in the test).
Designation of Backing Gas :	N/A
Type of Welding Current and Polarity :	PULSE
Mode of Metal Transfer :	DIP
Heat Input :	---
Welding Positions :	ALL POSITIONS EXCEPT PG AND J-L045
Preheat Temperature :	PREHEATING REQUIRED ONLY FOR REMOVAL MOISTURE IF AMBIENT TEMPERATURE IS BELOW +5° C
Interpass Temperature :	≤ 250 °C
Post – Heating :	NO
Post – Weld Heat Treatment and or ageing :	NO
Other Information :	--

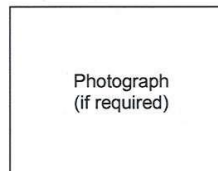
Certified that test welds prepared, welded and tested satisfactorily in accordance with the requirements of the code / testing standard indicated above.

Location	Date of Issue	Examiner or examining body Name, date and signature
THESSALONIKI	11/4/2019	11/4/2019, E. CHABOURIS Mechanical Engineer International Welding Engineer

EBETAM A.E.

WELDER's QUALIFICATION TEST CERTIFICATE

Designation(s) : **EN ISO 9606-1 135, P FW W1.1 t 4 PB**
 WPS – Reference : **No1** Examining body – Reference No. : **MIR/WATC/3297-19**
 Welder's Name : **MISAILIDIS ANESTIS**
 Identification : **W01**
 Method of identification : **Marking**
 Date and place of birth : **3/10/1967, HELLAS**
 Employer : **YIOI A. MIZAHALAH OE**
 Code/Testing Standard : **EN ISO 9606-1:2017**



Job knowledge : Acceptable/Not tested (delete as necessary)

	Test Piece	Range of Qualification
Welding process(es)	135 MAG	135,138
Transfer mode	DIP	DIP,spray
Product Type (plate or pipe)	P	T,P
Type of weld	BW	BW
Parent material group(s)/subgroups	1.1	---
Filler material group(s)	EN ISO14341-A: G3 Si 1 , FM1	FM1,FM2 S,M
Filler material (Designation)	SIDER WELD	Filler Material with same characteristics
Shielding gas	ISO 14175:82% Ar- 18%CO₂ LINDE CORGON18	ACTIVE GASES
Auxiliaries (e.g. backing gas)	---	---
Type of current and polarity	PULSE	PULSE
Material thickness (mm)	4,0	>=3
Deposited thickness (mm)	---	---
Outside pipe diameter (mm)	---	---
Welding position	PB	PA,PB
Weld details	---	---
Multi-layer/single layer	Single layer	Single layer

Supplementary fillet weld test (completed in conjunction with a butt weld certification): acceptable/not acceptable

Type of test	Performed and acceptable	Not tested	Examining body : EBETAM A.E (MIRTEC S.A.)
Visual testing	YES	X	Place : THESSALONIKI
Radiographic testing		X	Date of issue : 18/3/19
Magnetic Particles Test	MIRTEC SA, NDT-MP-1699/23.5.2019		Examiner : EBETAM (MIRTEC SA)
Bend test		X	Date of welding : 11/4/19
Notch tensile test		X	E. CHABOURIS
Macroscopic examination	MIRTEC SA, 2212F, 26/4/19		Signature :
Additional tests	-	-	

Revalidation 9.3 a) ☐ Valid until ☐ Revalidation 9.3 b) ☒ Valid until **17/3/2021** Revalidation 9.3 c) ☐ Valid until ☐
Confirmation of the validity by employer/welding coordinator/examiner or examining body for the following 6months [refer to 9.3c)]

Date	Signature	Position or title

Revalidation for qualification by examiner or examining body for the following 2 years [refer to 9.3b)]

Date	Signature	Position or title