

RAPORT DE CALIFICARE A PROCEDURII DE SUDARE (WPQR) WELDING PROCEDURE QUALIFICATION RECORD (WPQR)



Calificarea procedurii de sudare - Certificat de testare Welding procedure qualification - Test certificate

Specificatia procedurii de sudare <i>Manufacturer's Welding Procedure</i>	Inspectia Nr.: <i>Inspection No.</i>	2018-WPQR-048 Rev.1
Nr. Referinta : <i>Reference No.</i>	Examinator : <i>Examiner</i>	Eng. IONESCU C
Producator: <i>Manufacturer</i>	SC TELPROD-COM S.R.L.	
Adresa: <i>Address</i>	CHISINAU, MOLDOVA	
Cod/Standard testare: <i>Code/Testing Standard</i>	EN ISO 15614-1:2017	
Data sudarii : <i>Date of Welding</i>	25.10.2018	
Domeniul de calificare: <i>Range of qualification</i>	Conform cu / According to EN ISO 15614-1:2017	
Procedeu de sudare : <i>Welding Process</i>	111 Teava - Tube (T), Cap-la-cap - Butt Weld (BW), Sudare dintr-o singura parte - Single Side Weld (ss), Multi-strat - Multi-run weld (ml)	
Tipul imbinarii: <i>Joint Type</i>	Tube: L 415 M - PSL2 (Group 2.1 acc CEN ISO/TR 15608)	
Material(e) de baza : <i>Parent metal (s):</i>	10,31 mm BW: from 5,15 mm to 20,6 mm	
Grosime material (mm): <i>Material Thickness (mm)</i>	508,0 mm (from 254,0 mm)	
Diametrul exterior (mm): <i>Outside Diameter (mm)</i>	ESAB OK 53.70 (E42 5 B 12 H5 acc EN 2560-A)	
Material de adaos: <i>Filler Material</i>	---	
Gaz / Flux <i>Gas / Flux</i>	De protectie/Shielding - Suport la radacina/Backing:	---
Tip current / Polaritate: <i>Type of Welding Current / Polarity</i>	DC+	
Pozitia de sudare : <i>Welding Position:</i>	PH	
Temperatura de preincalzire: <i>Preheat Temperature</i>	Min 80 °C	
Temperatura intre straturi: <i>Interpass Temperature</i>	Max. 250 °C	
Tratament termic dupa sudare: <i>Post-Weld Heat Treatment</i>	---	
Alte informatii : <i>Other Information:</i>	---	

Confirmam ca probele au fost pregatite, sudate si testate in mod corespunzator, in conformitate cu cerintele codului/standardului de testare indicat mai sus.

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

Bucharest, ROMANIA

Emis in / Issued in

24.12.2018

Data emiterii / Date of issue

Ing. Fulga D.

Nume si semnatura / Name and signature



TUV AUSTRIA
ROMANIA S.R.L.

Organism
Notificat cf.
PED 2014/68/UE
Nr. 2414

Notified Body
Acc.
PED 2014/68/UE
No. 2414

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Registration No.
RO 19231430

Bank Connections:

Unicredit Tiriac,
Grigore Mora

Account No.
RO67
BACX 0000 0000
9226 4250 RON

RO20
BACX 0000 0000
9226 4320 EUR