

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



TÜV
AUSTRIA
ROMANIA

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

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

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

**TÜV 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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TUV AUSTRIA
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RO67
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9226 4250 RON

RO20
BACX 0000 0000
9226 4320 EUR