

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

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|---|---|--|
| Specificatia procedurii de sudare Manufacturer's Welding Procedure | Inspectia Nr.: Inspection No. | 2018-WPQR-048 Rev.1 |
| Nr. Referinta : Reference No. | Examinator : Examiner | 2018-1 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 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: Joint Type | Tube: L 415 M - PSL2 (Group 2.1 acc CEN ISO/TR 15608) | |
| Material(e) de baza : Parent metal (s): | 10,31 mm BW: from 5,15 mm to 20,6 mm | |
| Grosime material (mm): Material Thickness (mm) | 508,0 mm (from 254,0 mm) | |
| Diametrul exterior (mm): Outside Diameter (mm) | ESAB OK 53.70 (E42 5 B 12 H5 acc EN 2560-A) | |
| Material de adaos: Filler Material | --- | |
| Gaz / Flux Gas / Flux | De protectie/Shielding - Suport la radacina/Backing: | --- |
| Tip current / Polaritate: Type of Welding Current / Polarity | DC+ | |
| Pozitia de sudare : Welding Position: | PH | |
| Temperatura de preincalzire: Preheat Temperature | Min 80 °C | |
| Temperatura intre straturi: Interpass Temperature | Max. 250 °C | |
| Tratament termic dupa sudare: Post-Weld Heat Treatment | --- | |
| 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



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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9226 4250 RON

RO20
BACX 0000 0000
9226 4320 EUR