

TÜV Hellas Order No. : 02.30.13

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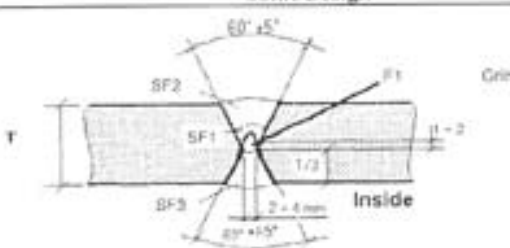
WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

Manufacturer	: MGT IND LTD	Inspection Authority	: TÜV HELLAS (TÜV NORD) A.E
WPS No	: 191/09	Location	: Mallot Isarel
WPQR No	: 193/09	Date of Welding	: 25/12/08
Code / Testing Standard	: EN/ISO 15614-1-2004		

RECORD OF WELD TEST

Welder's Name	: Louise Dakur	Outside Diameter (mm)	: %
Welder stamp	: 6	Welding Position	: PA
Welding Process	: 141(GTAW)	Joint Type	: PBW (double V groove butt weld -plate)
Parent Material	: ASTM A240 Gr.316L	Method of Preparation	: Grinding - Brushing & cleaning
Material	: 10 mm.		
Thickness (mm)			

WELD PREPARATION DETAILS (SKETCH)*:

Joint Design	Welding Sequences
	<p>See the attached sketch</p>

WELDING DETAILS

Pass	Process	Size of Filler Metal (Φ mm.)	Current A	Voltage V	Type of current/ Polarity	Wire Feed Speed* (m/min.)	Travel Speed (mm/sec)	Heat Input* (J/mm)	Metal Transfer *
1	141	1.2	80-90	13	DC(-)	%	0.5 - 1	%	%
2,4,5,6	141	1.6	120-130	16	DC(-)	%	0.5 - 1	%	%
3	141	1.6	120-130	16	DC(-)	%	0.5 - 1	%	%

Filler Metal Classification and trade name	: GTAW: AWSA59ER316L - Lincoln Electric 316L	Other information*	: %
Any Special Baking or Drying	: %	Torch angle	: -
Gas Flux : shielding	: Argon 99.996 % / II - EN 439-II	Pulse welding details	: -
backing	: %	Stand off distance	: -
Gas Flow Rate : shielding	: 10-14 ltr / min	Plasma welding details	: -
backing	: %	Oscillation: amplitude,	: -
Tungsten Electrode Type/Size	: 2% Thorium - 2.0 mm	frequency, dwell time	
Details of Back Gouging/Backing	: %		
Preheat Temperature	: %		
Interpass Temperature	: 150 ^o C MAX. (check method: digital thermo or temperature sticks)		
Post-Weld heat treatment and/or Ageing	: N/A		
Time, Temperature, Method	: N/A		
Heating and Cooling Rates*	: N/A		



Location
Athens

Date of issue
29/1/2009

The Inspector / Expert of TÜV Hellas (TÜV NORD) S.A.

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