TUV HELLAS
Member of TÜV NORD Group

TÜV Hellas Order No. : 02.39.13

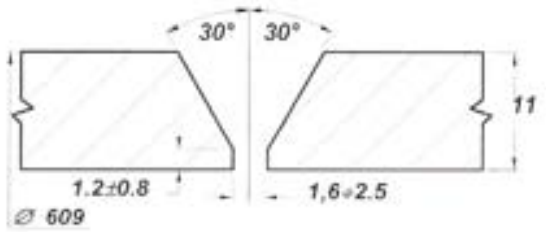
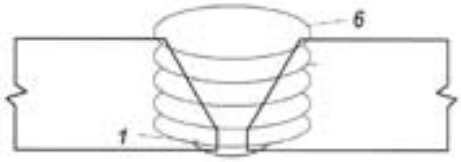
WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

Manufacturer	: MGT ltd	Inspection Authority	: TUV HELLAS (TUV NORD) A.E
WPS No	: 398/09	Location	: Mallot Isarel
WPQR No	: 397/09	Date of Welding	: 2/10/2008
Code / Testing Standard	: EN/ISO 15614-1-2004		

RECORD OF WELD TEST

Welder's Name	: Louis Dakur	Outside Diameter (mm)	: Ø 609 mm. (ND. 24 in.)
Welder stamp	: WT-01		
Welding Process	: 141(GTAW)+135(MAG)	Welding Position	: PA
Parent Material	: EN 10208 -2	Joint Type	: TBW (Single V groove butt weld in plate)
Material Thickness (mm)	: 11 mm.	Method of Preparation And Cleaning	: Grinding – Brushing

WELD PREPARATION DETAILS (SKETCH)*:

Joint Design	Welding Sequences
	

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/min)	Heat Input* (J/mm)	Metal Transfer *
1	141	24	134	11,4	DC(-)	%	40	1,833	%
2	141	24	138	11,4	DC(-)	%	40	1,954	%
3-6	135	16	170	28	DC(+)	%	80	4,090	%

Filler Metal Classification and trade name	: GTAW (141): ER70SN2 Hiko& MAG (135) E71 T-1 Lincoln		
Any Special Baking of Drying	: %		
Gas Flux : shielding	: 141 Ar.99,99 EN 439 11	Other information*	: %
	: 135 EN 439 C1	Torch angle	: -
Gas Flow Rate : shielding	: 10-14 lt / min	Pulse welding details	: SPARK 135
backing	: NA .	Stand off distance	: -
Tungsten Electrode Type/Size	: 2% Thorium – 2.0 mm	Plasma welding details	:
Details of Back Gouging/Backing	: %	Oscillation: amplitude, frequency, dwell time	:
Preheat Temperature	: %		
Interpass Temperature	: 250 ^{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		

TUV HELLAS
Member of TÜV NORD Group
H. TIMOR
☐ WITNESS ☐ REVIEW

INSPECTION-CERTIFICATION
HELLAS S.A.

Location	Date of issue	The Inspector / Expert of TÜV Hellas (TÜV NORD) S.A.
Haifa -Israel	2/3/2009	H. Timor/I.Konstantaropoulos

Headquarters
TUV HELLAS (TUV NORD) S.A
24, El. Venizelou Str. -153 41 Ag. Paraskevi, Athens-Greece
Phone : +30-210-6540195 - Fax :+30-210-6528025
IBAN Code: GR 93 0140 1580 – Account : 158002320000236
info@tuvhellas.gr -www.tuvhellas.gr