



EUROPEAN INSPECTION AND CERTIFICATION COMPANY S.A
PED IDENTIFICATION No 1128

89 CHLOIS st. & LIKOVRISEOS- 14452 METAMORFOSI GREECE
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WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)

DIRECTIVE 97/23/EEC Annex I, par.3, section 3.1.2

EN ISO 15614-1:2004+A2:2012

WELDING PROCEDURE QUALIFICATION TEST CERTIFICATE

pWPS No:	32/16	Reference No:	10.24.0022.01 Rev.00
Manufacturer:	D.VRAYKOS & ASSOCIATES Ltd.	Code / Testing Standard:	EN ISO 15614-1:2004+A2:2012
Address:	15 th Km Thiva – Halkida Old National Rd. Ritsona	Date of Welding:	10/09/2016

Range of qualification

Welding Process:	141
Type of joint:& weld	Single side butt weld, Both sides butt weld, full and partial penetration butt welds and fillet welds
Parent Metal(s) group:	8.1 steels in the same sub-group and any lower sub-group within the same group
Parent Metal Thickness (mm):	2.1 - 6
Weld Metal Thickness (mm):	2.1 - 6
Throat Thickness (mm)	---
Single run/Multi run	Multi run
Outside Pipe Diameter (mm):	≥ 36,5
Filler Metal Designation:	141 –EN ISO 14343-A W 19 9 3 L Si, AWS A5.9: ER308LSi
Filler Material Make	AVESTA TIG
Filler Material Size (mm)	141: Φ 2.0 mm
Designation of Shielding Gas / Flux:	EN 439 II
Designation of Backing Gas	EN 439 II
Type of Welding Current: & Polarity	141: DC (-)
Welding Positions:	ALL EXCEPT PG – J-L045
Preheat Temperature	-
Interpass Temperature	Max 250 ⁰ C
Post-Heating	-
Post – Weld Heat Treatment	-
Other Information:	-

Location	Date of Issue	Test Body / Surveyor
METAMORFOSI GREECE	27/09/2016	EUROCERT/ D.DIPSAKIS

It is certified, that the test welds were prepared, welded and tested in a satisfactory manner, according to the requirements of the code / testing standard as indicated above.