



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)

EN ISO 15614-1:2017

WELDING PROCEDURE QUALIFICATION TEST CERTIFICATE

WPS No:	100/18	Examining body:	EUROCERT S.A.
Manufacturer:	D.VRAYKOS & ASSOCIATES Ltd	Reference No:	10.24.0110PQR
Address:	15th km, Thiva-Halkida Old National Road, Ritsona	Code / Testing Standard:	EN ISO 15614-1:2017
Level:	2	Date of Welding:	18/07/2018

Range of qualification

Product Form:	PLATE, PIPE
Welding Process(es):	135
Type of joint:& weld	Full and partial penetration butt welds and fillet welds in any type of joints
Parent Metal(s) group:	1.2 steels in the same sub-group and any lower sub-group within the same group
Parent Metal Thickness (mm):	3 to 12
Deposited Metal Thickness (mm):	Max 12
Throat Thickness (mm)	No restriction for FW
Single run/Multi run	Multirun
Outside Pipe Diameter (mm):	≥ 500
Filler Metal Designation:	EN ISO 14341-A : G 42 4 M21 3Si1, AWS A5.18 ER70S-6
Filler Material Make	BOHLER EMK 6 NC
Filler Material Size (mm)	Ø 1.0 (root)
Designation of Shielding Gas / Flux:	EN 14175 M20, 8%CO2
Designation of Backing Gas	-
Type of Welding Current: & Polarity	DC (+)
Transfer Mode:	DIP
Heat Input (kJ/mm)	0.64 to 1.32
Welding Positions:	ALL EXCEPT PG – J-L045
Preheat Temperature	Ambient temperature
Interpass Temperature	-
Post-Heating	-
Post – Weld Heat Treatment	-
Other Information:	-

We confirm that the statements in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with ISO 15614-1

Location	Date of Issue	Test Body / Surveyor
METAMORFOSI GREECE	24/07/2018	EUROCERT/S. LOUKOPOULOS

