

**Welder's Qualification
Test Certificate
ISO 9606: 1:2013 (Cor)**



Designation(s):	EN 9606-1 131 P FW FM1 S t10 D12 PB ss nb			
WPS - Reference	WPS/123/TECHNOFAB	Certificate No	EACS/18/23	
Welder's Name:	Ashish Yadav	Identification:	UID No : 8636 5685 4553	
Address Welder	XXXXXXXXXXXXXXXXXXXX	Date of birth:	02-01-1988	
Employer/ Organisation:	XXXXXXXXXXXXXXXXXXXX	Code/Testing Standard:	BS EN ISO 15614-1 : 2017 + ASME B31.1 + API-5L	
Method of identification:	Test as per standard	Job knowledge:	Acceptable	

Qualification	Test Piece	Range of Qualification
Welding process(es)	131	131 (GMAW) FW on plate
Transfer Mode	Spray	Spray
Product type (plate or pipe)	Plate	Plate
Type of weld	Fillet weld	Fillet weld (single and both side)
Pipe Material group(s)(Al)	1.2	Any group
Filler Material group(s)	FM1	FM1.
Filler material (Designation)	ER 70S-6	SFA - 5.18, AWS No Class ER 70S-6 , F No Solid and Metal Cored Wire Electrode ; Size 0.8 mm
Shielding gas	CO 2	CO 2- 100%
Auxiliaries (e.g. backing gas)	N/A	N/A
Type of Current and Polarity	DCEP	DCEP
Material thickness (mm)	10 MM	The range of approval on thickness for butt welds is now based on the deposited weld metal thickness.
Deposited Thickness (mm)	12 MM	5 mm to 15 mm
Outside pipe diameter (mm)	--	Not Applicable
Welding position	PB	PB (Hor- Ver -2F),
Weld details	(ss,nb)	(ss,nb),(ss,mb),(bs)
Multi/Single layer	ml	sl and ml

Type of tests	Performed and Accepted	Not tested	Type of tests	Performed and Accepted	Not tested
Visual testing	Accepted		Notch Tensile Test	Accepted	
Radiographic Testing	Accepted		Fracture Test	Accepted	
Bend test	NA		Ultrasonic Testing	Accepted	

Name of examiner or examining body	Eurotech	Place, date and signature of examiner or examining body:	
Date of Welding	12 July 2018		
Date of Issue	20 July 2018		
Revalidation 9.3a	Valid until 20 July 2021		
Revalidation 9.3b	Valid until 20 July 2020		
Revalidation 9.3c	Valid until 20 Jan 2019		

Confirmation of the validity by employer/welding coordinator for the following 6 month (refer to 9.2)			Prolongation for qualification by examiner or examining body for the following 2 years (refer to 9.3b)		
Date	Signature	Position or title	Date	Signature	Position or title
20/07/2018		QA Manager	20/07/2018		Manager Technical – Eurotech

 ASSESSMENT AND CERTIFICATION SERVICES PVT. LTD.	WELDING PROCEDURE QUALIFICATION RECORD (WPQR) ISO 15614-1:2017+ AWS 31.1	 American Welding Society Educational Institution Member Examiner/Examining Body Ref No CWI-0806441
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WPQR No	WPQR/123/ TECHNOFAB	Reference No	20180720-FW-023
Manufacturer EN ISO 15614	TECHNOFAB ENGG LTD	Code / Testing Standard	EN ISO 15614-1:2017 + AWS 31.1+APL-5L
Address	XXXXXXXXXXXXXXXXXXXXX	Date of Welding	12/07/2018
Test Body/Surveyor	Eurotech ACS Pvt Ltd	Welder's Birth date	02-01-1988
Welder Name	Ashish Yadav	Identification	UID No : 8636 5685 4553

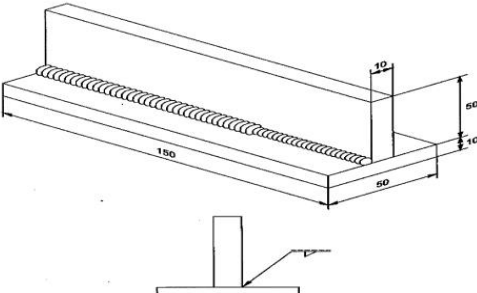
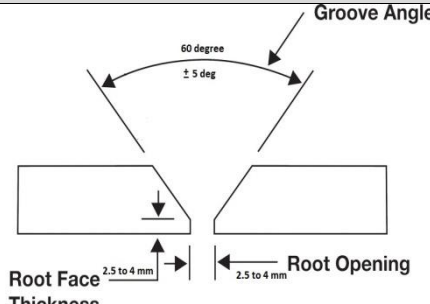
RANGE OF QUALIFICATION

Welding Process	131 (GMAW) , FW
Type of joint & weld	Fillet weld in Plate
Parent Metal(s) group	1.2
Parent Metal Thickness (mm)	10 mm (Qualify 2mm to 10mm)
Weld Metal Thickness (mm)	12 mm (Qualify 3mm to 15mm)
Throat Thickness (mm)	$3 < t < 15$
Single run/Multi run	Single run and Multi Run
Outside Pipe Diameter (mm)	Not Applicable
Filler Metal Designation	FM1
Filler Material Make	ADOR welding Pvt ltd
Filler Material Size (mm)	Dia. 0.8 mm
Designation of Shielding Gas / Flux	CO2
Designation of Backing Gas	--
Type of Welding Current: & Polarity	DCEP
Mode of Metal Transfer	Spray
Heat Input	--
Welding Positions	Fillet PB (Hor- Ver -2F),
Preheat Temperature	Ambient (50 deg)
Inter pass Temperature	None
Post-Heating	None
Post - Weld Heat Treatment	None
Other Information:	None

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.

euroTECH ASSESSMENT AND CERTIFICATION SERVICES PVT. LTD.		RECORD OF WELD TEST		 American Welding Society Educational Institution Member	
Location	Eurotech, Mohali	Date of Issue	20/07/2018		
WPS No	WPS/123/TECHNOFAB	Welding Process	131 (GMAW)		
Welding position	Fillet PB (Hor- Ver -2F),	Joint Type	Fillet Weld in Plate		
Mode of Metal transfer	Spray	Method of Preparation and Cleaning	Grinding & Brushing		

WELD PREPARATION DETAILS

Joint Design	Welding Sequences
	

ELECTRICAL CHARACTERISTICS

Run Process	Process	Size of Filler Metal (mm)	Current A	Voltage V	Type of current/ Polarity	Travel Speed inch / min	Heat Input kJ / mm
1	131	0.8 mm	80	18	DCEP	235	1.62 k /J

TECHNIQUE

Filler Metal Designation and Make	ER70S-6	Other Information (If Required):-	None
Any special Backing or Drying	None	Weaving (Maximum Width of Run)	Either
Gas/Flux for Shielding CO2	CO2 100 %	Oscillation	None
Gas/Flux for Backing	N/A	Pulse welding details	None
Gas Flow rate for Shielding	15 LPM	Standoff Distance	None
Gas Flow rate for Backing	N/A	Plasma welding details	NA
Tungsten Electrode Type/Size	N/A	Torch angle	NA
Details of Back Gouging/Backing	None	Inter Pass Temperature	None
Preheat Temperature	50 deg	Post weld Heat Treatment	None
Post Heating	None	Other	None

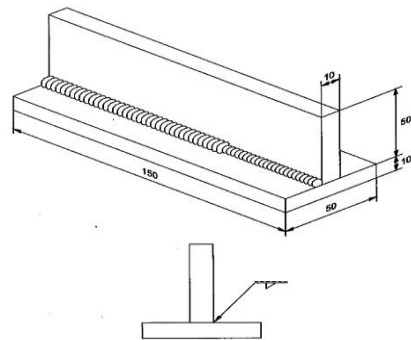
Company Name	TECHNOFAB ENGG LTD	Examined By	Sh.K. Manikandan
Welding Procedure Specification NO.	WPS/123/ TECHNOFAB	Date	20/07/2018
Supporting PQR NO.(s)	WPQR/123/ TECHNOFAB	Revision No & Date	Original
Standard	ISO 15614-1:2017 + AWS 31.1 +APL-5L	Page	1 of 2

SCOPE

Welding Process (es)	GMAW	Type of Process	Semi Automatic
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JOINTS (QW- 402) DETAILS

Joint Design	Fillet Weld
Root Spacing	None
Backing Material	None
Treatment of backside, Method of gauging/preparation	None
Backing Material (Type)	None
Maximum Mismatch	None
Typical Joint Details	See Diagram



BASE METAL (QW-403)

M No: 1	Group No: 1	TO	M No : 1	Group No : 1
USN Number	K 02596	Type and Grade	A 36	

FILLER METALS	1	2
Process	GMAW	
AWS Spec. No. (SFA)	A 5.18	
AWS No. (Classification No)	ER 70S-6	
F-No.	6	
A-No.	1	
Size of Filler Metals	0.8 mm	
Weld Metal : Deposited Thickness:	12 mm	
Electrode-Flux (Class)	N/A	
Flux Type	N/A	
Flux Trade Name	N/A	
Consumable Insert	CCMS Wire	

PS No		WPS/123/TECHNOFAB		Page	2 of 2	
POSITION (QW-405)				PREHEAT (QW-406)		
Position of Groove		N/A		Preheat Temp, Min		50 deg
Welding Progression		N/A		Interpass Temp Max		N/A
Position of Fillet		2 F Horizontal- Vertical		Preheat Maintenance		N/A
Progression		Left to Right		Other		N/A
GAS (QW-408)	Gases	Percentage Composition Mixture	Flow Rate (LPM)	POSTWELD HEAT TREATMENT (QW-407)		
Shielding	CO2	100 %	10-15	Temp Range		N/A
Trailing	N/A	N/A	N/A	Other		N/A
Backing	N/A	N/A	N/A			
Other	N/A	N/A	N/A			

ELECTRICAL CHARACTERISTICS (QW-409)										
Weld Pass(s)	Process	Filler Metal		Current/ Polarity type	Amp Range	Wire feed speed	Energy or power (range)	Volts (Range)	Travel Speed Range	Other (e.g., Remarks, Torch Angle, etc.)
		Class-ification	Dia-meter							
Multi Run	GMAW	A5.18 ER70S-6	0.8 mm	DCEP	70-150 amp	250 imp	DC Inverter	18-20	235 imp	Torch angle 75 Degree
<i>Amps and volts range should be recorded for each electrode size, Position, and thickness, etc.</i>										
Pulsing Current		N/A		Heat Input (Max)				1.62 kJ/mm		
Tungsten Electrode Size and Type		N/A		Mode of Metal Transfer for GMAW				Spray		

TECHNIQUE (QW-410)			
Stringer or Weave Bead	Either	Oscillation	N/A
Orifice or Gas Cup Size	13-25 mm	Contact Tube to Work Distance	8 mm
Method of Back Gouging	N/A	Multiple or Single Electrodes	Multiple
Multiple or Single Pass (Per Side)	Multiple	Peening	N/A
Other	Chipping, Grinding and/or Wire brushing	Initial and Interpass Cleaning (Brushing, Grinding, etc.)	Silicon spray/Gel
Electrodes Spacing	As needed		