

1 **WELDING PROCEDURE QUALIFICATION RECORD (WPQR)**

Welding procedure qualification - Test certificate

3 Manufacturer's Welding Procedure Specification Inspection Company : **SGS Italia S.p.A.**
 4 Reference No. : **WPS MT 01/21** Reference No. : **SGS-ITA-PQR-21-000141**
 5 Manufacturer : **MECTUBI S.R.L.**
 6 Address : **Via Cà Noa, 34/A - 24012 - Val Brembilla (BG)**
 7 Code / Testing Standard : **UNI EN ISO 15614-1:2019**
Level (*) : 2
 8 Date of welding **19/06/2021**

9 **Range of qualification**

Test piece

Product form : **Tube - standard test piece**

10 Welding process (es) :

Welding Processes used

	No. 1	No. 2	No. 3
Process	135		
Dep. metal thk. (mm)	8,00		

11 Type of joint and weld : **BW With Batching Material: ss mb**

12 Parent Metal Group(s) and Sub-group(s) : **Group 1 (Sub-group 1.2) to Group 1 (Sub-group 1.2)**
Qualified Groups 1 - 1 and combinations

13 Parent Material Thickness (mm) : **3 to 16** Deposited Weld Metal Thk. (mm.) : **8**
 Throat thickness (mm) : **no restriction** / Single layer / multi-run : **ml**

14 Pipe Outside Diameter (mm) : **88,9**
 Filler material make : **SOGES** Filler material size : **All**

15 Filler Metal Designation : **EN ISO 14343-A-18 8 Mn / AWS 5.1 ER 307 Si**

16 Designation of shielding gas / Flux : **UNI EN ISO 14175-M14**
 Designation of backing gas :

17 Type of welding current & polarity : **DCEP**
 Transfer mode : **See table pag. 2** Heat input : **See table pag. 2**

18 Welding Position : **All except PG, PJ and J-L045**

19 Pre-heating **≥ 10 °C** Interpass Temperature: **≤ 200°C**
 Post-heating : **N.A.**

20 Post Weld Heat Treatment and / or Ageing : **N.A.**

21 Other Information : (see also 8.5) **Heat Input : ± 25 %**
Fillet throat thickness : no restriction
Fillet weld material thickness : 3 to 16

(*) Note: Level 2 satisfies Level 1 requirements.

22 We confirm that the statemnts in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with: **UNI EN ISO 15614-1:2019**
SGS Job No 21.20214

23 Location : **Milano - MI (Italy)** Date of Issue: **19.07.2021**



On Behalf of Business Manager
T. Lotito