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Safety, quality and environmental services

WELDER QUALIFICATION AND TEST CERTIFICATE

Code / Testing Standard	: Pressure Equipment Directive 97/23 /EG & NEN-EN-ISO 9606-1:2013		
Designation 1	: 138 P FW FM1 S t10 PF ss mb ml	Certificate ref. No.	: 14-04-51021-02
Designation 2	: -	Date of welding	: 21-03-2014
Manufacturer's WPS. Ref. No.	: 2014-004	Order No.	: 2014-072
Welder's Name	: M. de Weert	Welder Id	: MDW72
Method of Identification	: ID card	Identification No.	: IRC0976K5
Date and Place of Birth	: 28-02-1972, 's-Hertogenbosch	Employer	: Mark de Weert
Job Knowledge	: Not tested		

TESTING CONDITIONS AND QUALIFICATIONS LIMITS

Variables	Weld Test Details	Range of Approval
Welding process(es)	: 138	: 135, 138
Transfer mode	: Short-circuit	: All
Product type - Plate (P) or Pipe (T)	: Plate	: P / T ≥ 75 mm (rotating) D ≥ 500 mm (fixed) PA,PB
Type of weld	: FW	: FW
Parent material group(s) subgroups	: 1.2	: Nonessential
Filler material group(s)	: FM1	: FM1, FM2
Filler material (designation)	: M	: S, M
Shielding gas	: M21	: Nonessential
Auxiliaries	: -	: -
Type of current and polarity	: DC+	: Nonessential
Material thickness (mm)	: 10	: ≥ 3
Deposited thickness (mm)	: -	: -
Outside pipe diameter (mm)	: -	: -
Welding position	: PF	: PA, PB, PF
Weld detail	: ss mb	: ss mb, bs
Multi-layer / single layer	: ml	: sl, ml

Suppl. fillet weld test acceptable/not acceptable :

TEST RESULTS

Type of Test	Performed and Accepted	Not Required
Visual Examination	: Acceptable	: ☐
Radiographic Examination	: -	: ☒
Magnetic Particle/Penetrant Examination	: -	: ☒
Macro Examination	: Acc.Element DEG004-14-03-06687-2	: ☐
Fracture Test	: -	: ☒
Filet weld break Test	: Acc.Element DEG004-14-03-06687-2	: ☐
Notch Tensile Test	: -	: ☒
Additional Tests (impact & hardness)	: -	: ☒

We certify that test welds were prepared, welded and tested satisfactorily in accordance with the requirements of the code/testing standard indicated above.

Revalidation (9.3 a)	Revalidation (9.3 b)	Revalidation (9.3 c)
Valid until : -	Valid until : 22-03-2016	Valid until : -

Inspector		Verified by	
Name	: E. Kempe	Name	:
Date	: 01 APR. 2014	Date	:
Signature	:	Signature	:

FOR-DK-054 r7

element™

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TEST CERTIFICATE

Date: 3/31/2014
Purchase Order Number: 2014-072
Report No.: DEG004-14-03-06687-2

WELDERS PERFORMANCE QUALIFICATION

Testing in accordance with:	NEN-EN-ISO 9606-1 and ASME IX
WPS No.:	2014-004 (PF)
Item Description:	Fillet weld
Dimensions:	10 mm
Material type and grade:	S355J2+AR
Identification on Sample:	welders name, welders no., WPS no.
Welding Process(es):	138
Welding Consumable(s):	FM1: T46 6 MM 1 H5: E70C-6M
Shielding gas:	M21
Welding position:	PF
Joint Type:	FW
Heat Treatment:	No
Welders Name:	M. de Weert
Welder(s) No.:	MDW72
Welders ID	IRCo976K5
Place and D.O.B.:	's Hertogenbosch, 28.02.1972

NONDESTRUCTIVE EXAMINATION

* Visual examination:

TECHNOLOGICAL TEST

Type of test	Results
Fillet weld break test	During the examination of the fracture surface, no weld defects have been observed.

MACROSCOPIC EXAMINATION

Amount of Cross sections	Result
1 x	During the examination of the cross section, no weld defects have been observed.

Conclusion: The results satisfy the requirements.

RVA L 063

For Element Breda,	Testing witnessed by; AIB Vincotte
Sandra Wevers	R. van Hellemond Inspector ☒ Witnessed ☐ Reviewed 31 MAART 2014