



AIB-VINÇOTTE NEDERLAND B.V.

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Safety, quality and environmental services

WELDER PERFORMANCE QUALIFICATIONS (WPQ)

Code / Testing Standard	: Pressure Equipment Directive 97/23 /EG & ASME Boiler and Pressure Vessel Code Section IX:2010	
Order No.	: 2014-072	Certificate ref. No. : 14-03-51047-60
Welder's Name	: M. de Weert	Identification : MDW72
Method of Identification	: ID - card	No. : IRC0976K5
Date and Place of Birth	: 28-02-1972, 's-Hertogenbosch	Employer : Mark de Weert

TEST DESCRIPTION

Manufacturer's WPS. Ref. No	: 2014-003	Test Coupon <input checked="" type="checkbox"/>	Production Weld <input type="checkbox"/>
Specification of Base Metal(s)	: S355 J2+AR	Thickness	: 10 mm

TESTING CONDITIONS AND QUALIFICATIONS LIMITS

Welding variables (QW-350)	Actual Values	Range Qualified
Welding Process(es)	: FCAW	: FCAW
Type Used (manual, semi-automatic)	: Manual	: Manual
Backing (weld metal, double-welded, etc)	: With	: With
Plate or Pipe (enter diameter if pipe)	: Plate	: Plate, Pipe ≥ 73 mm
Base Metal P-or S-Number(s)	: S355 J2+AR	: S355 J2+AR
Filler Metal F-Number(s)	: F-No. 6	: All F-No. 6
Filler Metal or Electrode Specification(s)	: E 70C-6M	: Nonessential
Filler Metal of Electrode Classification(s)	: SFA-5.18	: Nonessential
Consumable Insert (GTAW of PAW)	: N.a.	: N.a.
Filler Type(solid/metal or flux cored powder):	Metal	: Nonessential
Deposit Thickness for Each Process	: 8	: Max 16 mm
Position	: 4F	: F, H, O
Vertical Progression (uphill or downhill)	: N.a.	: N.a.
Type of Fuel Gas (OFW)	: N.a.	: N.a.
Inert Gas Backing (GTAW, PAW, GMAW)	: N.a.	: N.a.
Transfer Mode (spray/globular or pulse)	: Short circuiting	: Short circuiting
GTAW Current Type/Polarity (AC, DC)	: N.a.	: N.a.

TEST RESULTS

Type of Test	Performed and Accepted	Not Required
Visual Examination	: Acceptable	: <input type="checkbox"/>
Radiographic Examination	: -	: <input checked="" type="checkbox"/>
Magnetic Particle / Penetrant Examination	: -	: <input checked="" type="checkbox"/>
Macro Examination	: Acc. see report: DEG004-14-03-06687-1	: <input type="checkbox"/>
Fracture Test	: Acc. see report: DEG004-14-03-06687-1	: <input type="checkbox"/>
Bend Test	: -	: <input checked="" type="checkbox"/>
Notch Tensile Test	: -	: <input checked="" type="checkbox"/>
Additional Tests	: -	: <input checked="" type="checkbox"/>

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

Inspector	Verified by	Date of Test/Issue	: 21-03-2014
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Name : R. van Hellemond

Date : 31-03-2014

Signature :

Name :

Date :

Signature :

de Groot Lasopleidingen
 Weidehek 24
 BREDA, 4824 AS

TEST CERTIFICATE

 Date: 3/31/2014
 Purchase Order Number: 2014-072
 Report No.: DEG004-14-03-06687-1

WELDERS PERFORMANCE QUALIFICATION

Testing in accordance with:	NEN-EN-ISO 9606-1 and ASME IX
WPS No.:	2014-003 (PD)
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:	PD
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.


For Element Breda,  Sandra Wevers	Testing witnessed by: AIB Vincotte  H. van Hellemond Inspector <input checked="" type="checkbox"/> Witnessed <input type="checkbox"/> Reviewed 31 MAART 2014
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All characteristics of the above object(s) have, as far as accessible and relevant, been verified by Element Materials Technology Rotterdam b.v. (Element). Other information was provided by the purchaser. This information was verified as far as possible and has been copied into this report, unchanged. We hereby certify that the reported test data is correct and that the above object(s) was (were) tested/examined in accordance with purchaser's requirements and/or the above procedure(s) and/or code(s)/specification(s). On occasion a test is subcontracted by Element (marked 'U' on the report). Opinions, interpretations and advice expressed in this report are outside the scope of any possible RvA accreditation, but are presented in a true and fair manner based on the best knowledge of the Element personnel involved. Interpretations, opinions, conclusions en advice are partly based on the examination results and partly on information supplied by the purchaser. Element does not bear responsibility for the correctness of the information submitted by the purchaser.
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