Notified body for pressure equipment of TÜV Thüringen e.V.

Melchendorfer Str. 64, 99096 Erfurt, Tel. +49 361 42 83 0 Email: info@tuev-thueringen.de



Welder's Qualification Test Certificate Certificate No. 24-296456-SK

3 Designation(s):

ISO 9606-1 141 T BW FM1 S s6.3 D48.3 PH-L045 ss nb ISO 9606-1 141 T FW FM1 S t6.3 D48.3 PH ml

24/082 4 WPS-Reference:

Slovweld, s.r.o.

Examining body: TÜV Thüringen e. V.

Examiner:

Dipl. Ing. Terezia Suselova

6 Welder's name:

9 Employer:

Serhii PRYSIAZHNIUK

7 Method of Identification:

Identity card

8 Date and place of birth:

1994-06-11, Baranivka / UKRAINE

Selbständig

10 Code / testing standard:

DIN EN ISO 9606-1:2017

Photograph (If required)

11 Supplementary fillet weld test: NO (completed in conjunction with a butt weld qualification)

12 Job knowledge: Acceptable but language problems

13	Test piece		Range of qualification	
4 Welding process(es);	141 TIG (GTAW)	141 TIG (GTAW)	141, 142, 143, 145	141, 142, 143, 145
15 Transfer mode	The second second	The second second	Carrie Carrier	The state of the s
6 Product type (plate or pipe)	T Pipe/Tube	T Pipe/Tube	T, P, Pipe branch ≥60°	T, P
7 Type of weld	BW Butt weld	FW Fillet weld	BW	FW
18 Parent material group(s)	1.1	1.1	142 only 1.1	142 only 1.1
9 Filler material group(s)	FM1	FM1	FM1, FM2, nm	FM1, FM2, nm
20 Filler material typ(s)	S	S	S, M, nm	S, M, nm
21 Shielding gas / flux	EN ISO 14175-I1	EN ISO 14175-11		
22 Auxiliaries				
23 Type of current and polarity	DC- (= -)	DC- (= -)	- 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	
4 Material thickness t (mm)		6.30	The state of the s	≥ 3.00
25 Deposited thickness s (mm)	6.30		3.00 to 12.60	
26 Outside pipe diameter (mm)	48.30	48.30	≥ 25.00	≥ 25.00
27 Welding position(s)	PH-L045 (6G)	PH (5F up)	All except PG (Vd)	All except PG; (Vd)
28 Weld details	ss nb		ss (nb, mb, gb, fb), bs	
29 Multi layer / single layer		ml		sl, ml

Parent metal: P235GH. Filler: ISO 636-A W 2 Si1 (GI 113, Esab). ISO 636-A W 2 Si1 (GI 113, Esab). The requirements of the Pressure Equipment Directive 2014/68/EU approval of personnel Annex I, 3.1.2 are fulfilled.

31	Type of tests	Performed and accepted	Not tested
33	Visual testing	X	
34	Radiographic testing	X (BW)	3
35	Fracture test	X (FW)	63 m
36	Bend test		X
37	Notch tensile test	M 49 63	X
38	Macroscopic examination	W ALL PAR	X
39	Additional tests	THE REAL PROPERTY.	X

Dipl. Ing. Jozef Vadkerti

Notified Body 0090 for Pressure Equipment

Place, date: Nitra, 2024-03-15 Revalidation method: 9.3 a Date of welding: 2024-03-12 Validity until: 2027-03-11



40 Revalidation for qualification by examiner or examining body for the following 2 years

Confirmation of the validity by welding coordinator I examiner or examining body for the following 6 months

Date	Signature	Position or title
	N/A	
	N/A	

Date	Signature	Position or title
2024-09-		
2025-03-	120 W 40	3 3 A TO
2025-09-	AS AS AS A	AN ANTAN
2026-03-	THE RESIDENCE	
2026-09-	A 100 100 1	7 & AV
A 60 50	AND A PARTY	1 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0

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