

ATC
06-006
 АКРЕДИТОВАНО
 КОНТРОЛНО
 ТЕЛО
 SRPS ISO/IEC 17020:2012

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)
KVALIFIKACIJA TEHNOLOGIJE ZAVARIVANJA

Manufacturer's Welding Procedure Specification Prethodna specifikacija tehnologije zavarivanja	ST-WPS1-111	Inspection body: Kontrolno telo:	SGS Beograd
		Reference No/ Broj izveštaja.: 50-2 0800/17	

Manufacturer : Proizvođač:	Synergy Tech d.o.o.
Address: Adresa:	Kondina 11/ 9, 11000 Beograd
Code/Testing Standard : Primenjeni standard :	SRPS EN ISO 15614-1:2008+A2:2012
Date of welding : Datum zavarivanja :	13.11.2017.

Range of Approval / Područje kvalifikacije:

Welding Process/ : Postupak zavarivanja:	111 (E / REL) acc. to EN ISO 4063
Joint Type : Tip spoja:	BW , -sl, -ss , (testing piece/ispitni uzorak); BW , -sl, -ss , FW (range of qualification/opseg kvalifikacije) Cevni priključak sa uglom ≥60°
Parent Metal Group(s): Grupa osnovnog materijala:	1.1 acc.to SRPS CEN ISO/TR 15608
Parent Material Thickness (mm): Debljina osnovnog materijala (mm):	2,6 (testing piece/ispitni uzorak); 1,82 - 3,38 (range of qualification/opseg kvalifikacije)
Pipe Outside Diameter (mm): Debljina osnovnog materijala (mm):	Ø 21,3 (testing piece/ispitni uzorak); 10,65 - 42,6 (range of qualification/opseg kvalifikacije),
Filler Material Type/Designation: Dodatni material :	EN ISO 2560-A / E38 3 C 21
Filler Metal size (mm): Prečnik dodatnog materijala (mm):	ø2,5;
Shielding Gas / Flux: Zaštitni gas/prašak :	-
Type of Welding Current: Struja za zavarivanje :	DC- ;
Heat input(kJ/mm): Unos toplote(kJ/mm):	0,51+0,61;
Welding Position: Položaj zavarivanja :	SRPS EN ISO 6947 - PH
Preheat temperature: Temperatura predgreivanja :	/
Interpass Temperature: Meduprolazna temperatura :	/
Post Weld Heat Treatment: Term.obrada posle zavarivanja	bez/ without
Other Information: Ostali podaci :	N/A
Certified that test welds prepared, welded and tested satisfactorily in accordance with the requirements of the code / testing standard indicated above. Potvrđuje se da je ispitani spoj pripremljen, zavaren i ispitivan saglasno zahtevima gorenavedenih propisa/standarda	

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Name and
signature
Ime i potpis:Date of Issue :
Datum izdavanja:

24.11.2017

Gordan Mandić B.Sc., SRB/IWI-C /00012.

Approved by:
Odobrio:

Marinko Ukropina B.Sc.

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