

ATC
06-006АКРЕДИТОВАНО
КОНТРОЛНО
ТЕЛО
SRPS ISO/IEC 17020:2012WELDING PROCEDURE QUALIFICATION RECORD CERTIFICATE(WPQR)
KVALIFIKACIJA TEHNOLOGIJE ZAVARIVANJA

Manufacturer's Welding Procedure Specification Prethodna specifikacija tehnologije zavarivanja	ST WPS 1- 311	Inspection body: Kontrolno telo:	SGS Beograd
		Reference No/ Broj izveštaja.: 50-2 0555/17	

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 :	01.08.2017.

Range of Approval / Područje kvalifikacije:

Welding Process / : Postupak zavarivanja:	311(gasno) acc. to EN ISO 4063
Joint Type : Tip spoja:	BW , - sl, - bs , (testing piece/ispitni uzorak); BW , -sl, - bs , FW (range of qualification/opseg kvalifikacije) Cevni priključak sa uglom $\geq 60^\circ$
Parent Metal Group(s): Grupa osnovnog materijala:	1.1 acc.to SRPS CEN ISO/TR 15608
Parent Material Thickness (mm): Debljina osnovnog materijala (mm):	2,9 (testing piece/ispitni uzorak); 2,0 – 5,8 (range of qualification/opseg kvalifikacije)
Pipe Outside Diameter (mm): Debljina osnovnog materijala (mm):	48,3 (testing piece/ispitni uzorak); ≥ 25 (range of qualification/opseg kvalifikacije)
Filler Material Type/Designation: Dodatni material :	OIII / EN 12536
Filler Metal size (mm): Prečnik dodatnog materijala (mm):	Ø 2 ;
Shielding Gas / Flux/ Fuel gas : Zaštitni gas/prašak/Gorivi gas :	O ₂ / C ₂ H ₂ (Kiseonik/ Acetilen)
Type of Welding Current: Struja za zavarivanje :	-
Heat input(kJ/mm): Unos toplote(kJ/mm):	-
Welding Position: Položaj zavarivanja :	SRPS EN ISO 6947 - PH
Preheat temperature: Temperatura predgrevanja :	/
Interpass Temperature: Međuprolazna temperature :	/
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 ispitani saglasno zahtevima gorenavedenih propisa/standarda

This Certificate cancels and supersedes the Certificate No.16796152 dated 07.08.2017. issued by SGS Beograd Ltd.

SGS Beograd Ltd.
Jurija Gagarina 7b

11070 Belgrade

t: (381 11) 71 55 277

f: (381 11) 71 55 279

e: sgs_beograd@sgs.com

Date of Issue :
Datum
izdavanja:.

07.08.2017

Name and signature
Ime i potpis

Gordan Mandić, SRB/IWI-C/00012.

Approved by:
Odobrio:

Marinko Ukropina B.Sc.

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