



WELDING PROCEDURE QUALIFICATION RECORD (WPQR) KVALIFIKACIJA TEHNOLOGIJE ZAVARIVANJA

Manufacturer's Welding Procedure Specification Prethodna specifikacija tehnologije zavarivanja	ST-WPS1- FW-135	Inspection body: Kontrolno telo: Reference No/ Broj izveštaja.: 50-2 0291/18	SGS Beograd
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Manufacturer : Proizvođač:	Synergy Tech d.o.o.
Address: Adresa :	Gostivarska 70 ž/1 , 11000 Beograd
Code/Testing Standard : Primenjeni standard :	SRPS EN ISO 15614-1:2017
Date of welding : Datum zavarivanja :	27.04.2018.

Range of Approval / Područje kvalifikacije:

Welding Process / Postupak zavarivanja:	135 (MAG, manual welding) acc. to EN ISO 4063
Joint Type : Tip spoja:	FW, single run/ jedan prolaz, (testing piece/ispitni uzorak); FW, single run/ jedan prolaz, (range of qualification/opseg kvalifikacije)
Parent Metal Group(s): Grupa osnovnog materijala:	1.2 acc.to SRPS CEN ISO/TR 15608 with yield point ReH ≤355MPa , S355J2+N
Parent Material Thickness (mm): Debljina osnovnog materijala (mm):	12 (testing piece/ispitni uzorak); 6 - 24 (range of qualification/opseg kvalifikacije)
Pipe Outside Diameter (mm): Spoljašnji prečnik cevi (mm):	-
Filler Material Type/Designation: Dodatni materijal :	G42 5 M/C G3Si1 (EN ISO 14341-A);
Throat thickness (mm): Debljina zavarenog spoja (mm):	a5 (testing piece/ispitni uzorak); 3.75 – 7.5 (range of qualification/opseg kvalifikacije)
Filler Metal size (mm): Prečnik dodatnog materijala (mm):	Ø1,2;
Shielding Gas / Flux: Zaštitni gas/prašak :	SRPS EN ISO 14175- M21 ,
Type of Welding Current: Struja za zavarivanje :	DC+;
Heat input(kJ/mm): Unos toplote(kJ/mm):	1,28 + 1,47;
Welding Position: Položaj zavarivanja :	SRPS EN ISO 6947 – PB;
Preheat temperature: Temperatura predgrevanja :	/
Interpass Temperature: Međuprolazna 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 ispitan saglasno zahtevima gorenavedenih propisa/standarda

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Date of Issue :
Datum izdavanja:

18.05.2018

Name and
signature
Ime i potpis:

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



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WELDING PROCEDURE QUALIFICATION RECORD (WPQR)
KVALIFIKACIJA TEHNOLOGIJE ZAVARIVANJA

Manufacturer's Welding Procedure Specification Prethodna specifikacija tehnologije zavarivanja	ST-WPS2- FW-135	Inspection body: Kontrolno telo: Reference No/ Broj izveštaja.: 50-2 0291/18	SGS Beograd
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Manufacturer : Proizvođač:	Synergy Tech d.o.o.
Address: Adresa:	Gostivarska 70 ž/1, 11000 Beograd
Code/Testing Standard : Primenjeni standard :	SRPS EN ISO 15614-1:2017
Date of welding : Datum zavarivanja :	27.04.2018.

Range of Approval / Područje kvalifikacije:

Welding Process/ : Postupak zavarivanja:	135 (MAG, manual welding) acc. to EN ISO 4063
Joint Type : Tip spoja:	FW, single run./ jedan prolaz (testing piece/ispitni uzorak); FW, single run/ jedan prolaz, (range of qualification/opseg kvalifikacije)
Parent Metal Group(s): Grupa osnovnog materijala:	1.2 acc.to SRPS CEN ISO/TR 15608 with yield point ReH ≤355MPa, S355J2+N
Parent Material Thickness (mm): Debljina osnovnog materijala (mm):	30 (testing piece/ispitni uzorak); ≥ 5 (range of qualification/opseg kvalifikacije)
Pipe Outside Diameter (mm): Spoljašnji prečnik cevi (mm):	-
Filler Material Type/Designation: Dodatni material :	G42 5 M/C G3Si1 (EN ISO 14341-A);
Throat thickness (mm): Debljina zavarenog spoja (mm):	a 6
Filler Metal size (mm): Prečnik dodatnog materijala (mm):	Ø1,2;
Shielding Gas / Flux: Zaštitni gas/prašak :	SRPS EN ISO 14175- M21,
Type of Welding Current: Struja za zavarivanje :	DC+;
Heat input(kJ/mm): Unos toplote(kJ/mm):	1,28 + 1,47;
Welding Position: Položaj zavarivanja :	SRPS EN ISO 6947 – PB;
Preheat temperature: Temperatura predgrevanja :	/
Interpass Temperature: Međuprolazna 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 ispitan saglasno zahtevima gorenavedenih propisa/standarda	

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Manufacturer's Welding Procedure Specification Prethodna specifikacija tehnologije zavarivanja	ST-WPS3- FW-135	Inspection body: Kontrolno telo: Reference No/ Broj izveštaja: 50-2 0291/18	SGS Beograd
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Manufacturer: Proizvođač:	Synergy Tech d.o.o.
Address: Adresa:	Gostivarska 70 ž/1, 11000 Beograd
Code/Testing Standard: Primenjeni standard:	SRPS EN ISO 15614-1:2017
Date of welding: Datum zavarivanja:	27.04.2018.

Range of Approval / Područje kvalifikacije:

Welding Process/ Postupak zavarivanja:	135 (MAG, manual welding) acc. to EN ISO 4063
Joint Type: Tip spoja:	BW, - ml, -ss -nb, (testing piece/ispitni uzorak); BW, -ml, -ss -mb, -bs, FW (range of qualification/opseg)
Parent Metal Group(s): Grupa osnovnog materijala:	1.2 acc.to SRPS CEN ISO/TR 15608 with yield point ReH ≤355MPa, S355J2+N
Parent Material Thickness (mm): Debljina osnovnog materijala (mm):	12 (testing piece/ispitni uzorak); 3 - 24 (range of qualification/opseg kvalifikacije)
Pipe Outside Diameter (mm): Spoljšnji prečnik cevi (mm):	> 500mm, for PA or PC rot. > 150mm.
Filler Material Type/Designation: Dodatni material:	G42 5 M/C G3Si1 (EN ISO 14341-A);
Throat thickness (mm): Debljina zavarenog spoja (mm):	-
Filler Metal size (mm): Prečnik dodatnog materijala (mm):	Ø1,2;
Shielding Gas / Flux: Zaštitni gas/prašak:	SRPS EN ISO 14175- M21,
Type of Welding Current: Struja za zavarivanje:	DC+;
Heat input(kJ/mm): Unos toplote(kJ/mm):	0,37 + 0,73;
Welding Position: Položaj zavarivanja:	SRPS EN ISO 6947 – PA;
Preheat temperature: Temperatura predgrevanja:	/
Interpass Temperature: Međuprolazna temperatura:	/
Post Weld Heat Treatment: Term.obrada posle zavarivanja	bez/ without
Other Information: Ostali podaci:	N/A

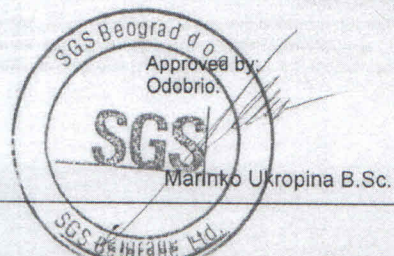
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