

Name of the Instrument	WELDING MACHINE (Inverter)
Make	Rilon
Model No	MZ-1250
Range	1250 Amps
Serial No	202001977(SAW30034491) (SAW)
Type of Calibration	Manual
Name of the Customer	M/s. Patel Engineering Works Visakhapatnam.
Calibration Certificate No	MKT/EC/24-3098
Date of Calibration	22-08-2024
Next Calibration Date	21-08-2025

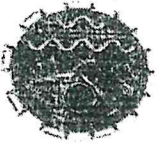
Master Instrument Details			
Name	Digital Clamp Meter	Calibration date	31-07-2024
Make	Victor	Due on	30-07-2025
Range	100864629	Cert No	MKT/INT/152-01
Environment Condition During Calibration on site			
Temperature		(23 ± 1.5) °C	
Relative Humidity		(50 ± 10) %RH	

Master Reading Values	Calculated Values of UUC			(±) Average in Amps	(±) Deviation in Amps
	X	Y	Z		
1	200	197	195	194	195
2	400	391	396	398	395
3	600	596	598	594	596
4	800	803	795	796	798
5	950	948	938	945	944

Remarks:

1. This Calibration certificate is applicable to the item calibrated only.
2. UUC Refers to Unit Under Calibration.
3. Physical condition of UUC is satisfactory.
4. Due date for next calibration is given as per the request of the customer.
5. All calibrations are traceable to national measurement standards as per the traceability details given in the calibration certificate.

Calibrated by
Mr. B Chandra Sekhar
(Engineer)



Verified by
Mr. MD Murtazuddin
(Senior Engineer)

CALIBRATION CERTIFICATE

UUC DETAILS	
Name of the Instrument	ARC Welding Rectifier
Make	Allied
Model No	AWR-400
Range	400 Amps
Serial No	AWI-3327
Type of Calibration	MMAW
Name of the Customer	M/s. Patel Engineering Works Visakhapatnam.
Calibration Certificate No	MKT/EC/24-798
Date of Calibration	01-10-2024
Next Calibration Date	30-09-2025
Calibrated By	Mr. MD Munvaruddin

Master Instrument Details			
Certificate No	Due on	Calibration date	Digital Clamp Meter
MKT/INT/23-013	31-07-2025	01-08-2024	094644740
Environment Condition During Calibration in Lab			
Relative Humidity		Temperature	
(50 ± 10)%RH		(23 ± 1.5)°C	

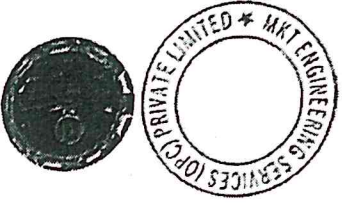
Calibration Data:

Sr	Electrode	UUC reading in amps		Master Instrument Reading in amps		Remarks
		E6013	E7018	E6013	E7018	
1	2.50	45 to 90	70 to 110	63	97	Pass
2	3.15	80 to 130	105 to 155	109	146	Pass
3	4.0	105 to 180	130 to 200	154	182	Pass

Remarks:

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END OF CERTIFICATE



Digitally signed by SHAIK IBRAHIM
DN: cn=SHAIK IBRAHIM,
o=MKT ENGINEERING
SERVICES(OPC) PVT LTD.,
ou=MKT ENGINEERING
SERVICES(OPC) PVT LTD.,
email=technical.mktengg@gmail.com, c=IN
Reason: I have reviewed
this document
Location: VISAKHAPATNAM
Date: 2024.10.03 12:48:47
+05'30'

UUC DETAILS	
Name of the Instrument	ARC Welding Rectifier
Make	Allied
Model No	AWR-400
Range	400 Amps
Serial No	AWI-3380
Type of Calibration	MMAV
Name of the Customer	M/s. Patel Engineering Works Visakhapatnam.
Calibration Certificate No	MKT/EC/24-797
Date of Calibration	01-10-2024
Next Calibration Date	30-09-2025
Calibrated By	Mr. MD Munvaruddin

Master Instrument Details				
Name	Serial No.	Calibration date	Due on	Certificate No
Digital Clamp Meter	094644740	01-08-2024	31-07-2025	MKT/INT/23-013
Environment Condition During Calibration on site				
Temperature	(23 ± 1.5°C		Relative Humidity	(50 ± 10%RH

Sr	Electrode	UUC reading in amps		Master Instrument Reading in amps	Remarks
no.					
1	2.50	45 to 90	70 to 110	81	97 Pass
2	3.15	80 to 130	105 to 155	123	132 Pass
3	4.00	105 to 180	130 to 200	165	188 Pass
		E6013 (X1)	E7018 (X2)	E6013 (Y1)	E7018 (Y2)
					Pass/ Fail

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CALIBRATION CERTIFICATE

UUC DETAILS	
Name of the Instrument	MIG WELDING MACHINE (Inverter)
Make	Allied
Model No	MIG CO2-400
Range	400 Amps
Serial No	AWI3916
Type of Calibration	Manual
Name of the Customer	M/s. Patel Engineering Works Visakhapatnam.
Calibration Certificate No	MKT/EC/24-801
Date of Calibration	01-10-2024
Next Calibration Date	30-09-2025
Calibrated By	Mr. MD Munvaruddin

Master Instrument Details			
Name	Serial No.	Calibration date	Due on
Digital Clamp Meter	094644740	01-08-2024	31-07-2025
Environment Condition During Calibration in Lab			
Temperature	(23 ± 1.5°C		
Relative Humidity		(50 ± 10)%RH	

Calibration Data:						
Sl.No	Electrod e	Amps Set	UUC reading (x) in Amps	Master Instrument Reading (y) in Amps	(±)Deviation (x-y) in Amps	Voltage During in Amps
1	2.5	60	55	58	3	32
2	2.5	70	68	66	2	30
3	2.5	80	72	75	3	35
4	2.5	110	102	104	2	33
5	2.5	125	125	126	1	33
6	2.5	240	234	239	5	32
7	2.5	280	278	275	3	35

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email=technical.mktengg@gmail.com, c=IN
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Date: 2024.10.03 12:51:23

WELDER QUALIFICATION TEST RECORD (PARAMETER SHEET)

WELDER NAME & WPS NO.	ID NO	POSITION	PROCESS	WELD PASSES	ELECTRICAL			WELDING SPEED			REMARK
					AMPS (A)	VOLTS (V)	GAS FLOW (ltrs/min)	WELD DISTANCE (mm)	WELD TIME (min)	SPEED (mm/min)	
NARINKANTA		7G	SIDE 1	Root	478	30	16				
			SIDE 2	Final	485	35	-				
				FINAL	500	36					
SHASHA		3G	FCAW	Root	92	21.2	16				
				Hot Pass	105	21	16				
				Buildup 1	107	21	16				
				Buildup 2	108	21	16				
				Capping 1	98	21	16				
				Capping 2	95	21	16				
C. NARESH		1G	SAW	Capping 3	97	21	16				
				Root	480	31	-				
				Final	510	37	-				
				FINAL	490	36					

WELDER QUALIFICATION TEST RECORD (PARAMETERS TEST)

WELDER NAME & WPS NO.	ID NO	POSITION	PROCESS	WELD PASSES	ELECTRICAL			WELDING SPEED			REMARK
					AMPS (A)	VOLTS (V)	GAS FLOW (ltrs/min)	WELD DISTANCE (mm)	WELD TIME (min)	SPEED (mm/min)	
Prasad		3G	FCAW	Root	101	223	15	350mm x 12			
				Hot Pass	105	22	15				
				Buildup 1	107	22	15				
				Buildup 2	107	22	15				
				Capping 1	97	20	15				
				Capping 2	95	21	15				
				Capping 3	96	20	15				
V. Naidu		3G	FCAW	Root	99	21.1	17	350mm x 12			
				Hot Pass	107	21	17				
				Buildup 1	109	21	16				
				Buildup 2	109	21	16				
				Capping 1	98	20	16				
				Capping 2	96	20.5	16				
				Capping 3	99	20	16				
Pradeep Kumar		3G	FCAW	Root	100	23	16	350mm x 12			
				Hot Pass	108	22	16				
				Buildup 1	109	22	16				
				Buildup 2	109	22	16				
				Capping 1	95	21	16				
				Capping 2	98	21	16				
				Capping 3	97	21	16				

DER QUALIFICATION RECORD (PARAMETER SET)

WELDER NAME & WPS NO.		ID NO	Qualification				ELECTRICAL			WELDING SPEED			RE
			POSITION	PROCESS	WELD PASSES	AMPS (A)	VOLTS (V)	GAS FLOW (ltrs/min)	WELD DISTANCE (mm)	WELD TIME (min)	SPEED (mm/min)		
K. Narash			4G	Side 1	Root	152	26.1	15					
					Hot Pass	110	23	15					
					Building	120	23	15					
					"	114	23	15					
					Capping	110	23	15					
			"		113	23	15						
			"		110	23	15						
			Side 2	"	Root	115	23	15					
					Capping	109	23	15					
					"	110	23	15					