

WELDER'S QUALIFICATION TEST CERTIFICATE

according to NEN-EN-ISO 9606-1: 2017

DNV-GL

Certificate No.:

A0565824-88

Rev.: 0

Ref.: WPS-DNVGL-2018-17

Designation(s)

138 T BW FM1 M t=25 (s1=12.50) D 141.3 H-L045 ss, nb

136 T BW FM1 P t=25 (s2=12.50) D 141.3 H-L045 ss, mb

Approval body

Det Norske Veritas B.V., the Netherlands

Welder's name

Grzegorz Idasiak

Identification / Method of identification

Identiteitsbewijs /

Date and place of birth

1979-01-20 / Polen

Employer

W.P.S. Welding Services

WPS - Reference

FCAW 138-136-X65-6G-02

Job knowledge

Not tested

Welding data	Test Piece	Range of qualification NEN-EN-ISO 9606-1:2017
Welding process(es)	138 136	135, 138 136
Transfer mode	Short circuit arc N.A.	Short circuiting arc, Globulair arc, Spray arc, Pulse arc N.A.
Current and polarity	DC pos DC pos	N.A. N.A.
Product type	T	P, T
Type of weld	BW	BW, branch joints with an angle $\geq 60^\circ$
Material group(s)	1.3 (API 5L X65)	N.A.
Filler metal group and type	FM1, M, ISO 17632-A T 46 6 1,5Ni M M 1 H5 FM1, P, ISO 17632-A T46 6 1,5Ni P M 1 H5	FM1, FM2, S, M FM1, FM2, R, P, V, W, Y, Z
Shielding gas	M21 M21	N.A. N.A.
Auxiliaries (e.g. backing gas)	N.A. N.A.	N.A. N.A.
Material thickness (mm)	t=25.00 mm	N.A.
Deposite weld thickness (mm)	S1:12.50mm (*) S2:12.50mm (*)	S1: ≥ 3.00 mm - S2: ≥ 3.00 mm
Outside pipe diameter (mm)	141.3 mm	D ≥ 70.65 mm
Welding position	H-L045	PA, PB, PC, PD, PE, PF, PH
Weld details	ss, nb ss, mb	ss nb - ss mb - bs - ss gb - ss fb ss mb - bs
Suppl. FW Test piece (5.4e)	Yes Yes	FW sl, ml ≥ 3.00 mm FW sl, ml ≥ 3.00 mm

*) 3 or more layers.

Type of qualification tests	Performed and accepted	Not tested	
Visual testing	Yes	-----	Accept. NEN EN ISO 9606-1 clause 7 40320051
Radiographic testing	Yes	-----	
Ultrasonic testing	-----	Not tested	
Liquid Penetrant testing	-----	Not tested	
Magnetic testing	-----	Not tested	
Bend test	Yes	-----	WPS-B-60/18
Macroscopic examination	-----	Not tested	
Fracture test	Yes	-----	Acceptable, performed on site
Hardness examination	-----	Not tested	
Impact testing	-----	Not tested	
Tensile test	-----	Not tested	

Place of welding Rotterdam
Date of welding 2018-11-16
Valid till 2020-11-16
Issue date 2018-11-21
Issue place Barendrecht
Surveyor Leo Knops

Verified by

Signature welder

Signature employer:



See reverse side for prolongation by employer every 6 months, and examiner/test body's prolongation every 2 years. Additional information may also be stated in the column 'supplementary remarks'.

Det Norske Veritas B.V., Zwolseweg 1, NL - 2294 LB Barendrecht; T: +3110 2922718

E: Rotterdam.maritime.support@dnvgl.com; KvK: 24171900

DNV GL Headquarters, Veritasveien 1, PO Box 300, 1322 Høvik, Norway; www.dnvgl.com

Form F-PC-5-2-4/2018-04 9606-1-B.docx

Page 1 of 2